



# Selectarc Cu114

Copper Tin Electrode  
For AC

## Classification

AWS A5.6 : E CuSn-A  
UNS : W60518

DIN 1733 : EL-CuSn7  
Material N° : 2.1025

## Description & Applications

Basic coated electrode for welding copper tin bronzes (Cu-Sn 6-8%) and brasses (Cu-Zn) in some cases too. Also used for dissimilar joints. Selectarc Cu114 is recommended for repairing wrought bronzes (Cu-Sn), for surfacing on brasses, steels and cast iron. The deposit is resistant to salt water corrosion. This electrode is especially designed to weld with alternating current, but it can also be used either on DC + or -.

**Main applications:** Construction of equipment for the chemical industry and petrochemical industry, naval constructions and installations for sea water desalination, repair works.

### Base materials

UNS	DIN	Material N°
C50700	CuSn2	2.1010
C51100	CuSn4	2.1016
C51900	CuSn6	2.1020
C52100	CuSn8	2.1030
	CuSn6Zn	2.1080
C52400	G-CuSn10	2.1050

## Typical Weld Metal Composition ( % )

Sn	Mn	Fe	P	Cu
6.0	0.8	0.1	0.1	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0,2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Hardness
120	300	>20	100 HB

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x350
Current	( A )	70-90	90-110	110-130

Redrying 2 h at 150°C. Joints to weld must be clean, exempt from grease, cracks. Guide electrodes with a slight declination (10-20°) inclined in direction of travel). Weld with a short arc. To improve degassing of the deposit, adopt a low welding speed. Heavy pieces (sections above 6 mm) have to be preheated to 150-300°C.

ind.12



= + , - ~ 60V

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