

## AI-0808

### Specifications

**AWS/ASME** IIC SF A5.6 : ECuSn-C

### Description and Applications

Basic coated electrode for welding and surfacing all types of bronze (particularly phosphorus), copper, some brasses, cast iron, copper alloys to each other or to ferrous metals.

**Applications include:** Construction of parts such as pump vanes, gears, etc. Building up of worn parts: guides, slide blocks, valve seats.

### Typical Weldmetal Analysis

Sn	Ni	P	Cu
7.5	0.2	0.10	Bal

### Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	310 MPa
Yield Strength (0.2%)	130 MPa
Elongation	35% (4d)
Hardness	105 HB

### Welding Instructions

Preheat component to 250 degrees C and maintain for one hour.

### Welding Parameters

Diameter (mm)	Current type	Amps
3.2	DC	110 – 140
4.0	DC	140 - 160

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position

### Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at [sales@alloysint.com.au](mailto:sales@alloysint.com.au)



**ALLOYS INTERNATIONAL PTY LTD**

25 Raymond Road Laverton North Victoria 3026

Telephone: +61 3 8368 2222 | Facsimile: +61 3 8368 2200

**ABN** 53 112 712 286

[sales@alloysint.com.au](mailto:sales@alloysint.com.au) | [www.alloysint.com.au](http://www.alloysint.com.au)