

AMERIARC

Ameri Bronze

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.6 E CuSn – C

DIN 1733: EL - CuSn8

DESCRIPTION & APPLICATION:

Ameri Bronze electrode that works very well on AC current. It designed for joining and overlaying steels, cast irons, malleable iron, bronze, brass & copper based metals.

The electrode is recommended for overlaying & building up bearing surfaces, bushes, ship screws, impellor blades, valve seals etc.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

Sn	Fe	P	Al	Mn	Pb	Si	Ni	Other	Cu
8	.1	.1	.01	.01	.02	.05	.05	.50	Bal

Flux Color : Dark Brown

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	50,000 PSI (340 MPa)
Yield Strength	30,000 PSI (210 MPa)
Elongation	18%
Hardness	Brinell 105

WELDING CURRENT & INSTRUCTIONS:

Recommended Current : DC Straight (-) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	75	100	120
Maximum Amperage	105	135	160

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
	Length (mm)	14" (350)	14" (350)	14" (350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0