

# AMERIARC

## Ameri Pure Bronze

### INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.6 E Cu

DIN 1733: EL-CuMn2

### DESCRIPTION & APPLICATION:

**Ameri Pure Bronze** is the superior rutile coated tough bronze electrode for joining and overlaying steels, cast irons, malleable iron, bronze, brass & copper based metals.

High is recommended for joining & build up on copper parts requiring corrosion resistance & thermal and electrical conductivity.

### WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

Mn	Al	Si	Pb	Fe	Other	Cu
.09	.07	.08	.02	15	.50	Bal

**Flux Color :** Lt. Grey

### TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	33,000 PSI (225 MPa)
Yield Strength	27,000 PSI (185 MPa)
Elongation	35%
Electrical Conductivity	25-45
Hardness	Brinell 50-60

### WELDING CURRENT & INSTRUCTIONS:

**Recommended Current :** DC Reverse (+)

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	100	140	170
Maximum Amperage	130	170	200

### 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