

CARBO ZIBRO 6 B

International standards	Material No.	2.1025
	DIN 1733	EL-CuSn7
	AWS A 5.6	E CuSn-A
	AWS A 5.13	E CuSn-A

Approvals ---

Typical applications and characteristics Basic coated tin bronze electrode for repairing copper and copper tin bronzes (Cu-Sn 6-8 %), brasses, and phosphor bronzes. Also for dissimilar joints.
Recommended for surfacing on brasses, wrought bronzes (CuSn), mild steel and cast steel.
Good sliding and emergency running properties for bearings and contact surfaces of grey iron, type GG.

Operating temperature ---

Base materials	2.1010 CuSn2	2.1050 G-CuSn10	2.1086 G-CuSn10Zn
	2.1016 CuSn4	2.1052 G-CuSn12	2.1090 G-CuSn7ZnPb
	2.1020 CuSn6	2.1056 G-CuSn14	2.1096 G-CuSn5ZnPb
	2.1030 CuSn8	2.1056 G-CuSn14	

Mechanical properties of all-weld metal	Tensile strength R_m N/mm ²	Yield strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Hardness HB
	(typical values) 300	180	25	approx. 110

Weld metal analysis (typical, wt. %)	Cu	Sn	Mn	P	Fe
	Bal.	7	0,8	0,1	0,2

Current = +

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 200 °C + / - 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	50 - 80	266	1064	18,8	5,0	20,0
3,2 x 350	80 - 120	158	631	31,7	5,0	20,0
4,0 x 450	120 - 150	125	499	48,1	6,0	24,0
5,0 x 450	150 - 200	62	248	96,6	6,0	24,0

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