

## Ratna Cast Bronze

### CLASSIFICATION

- AWS/SFA-5.6 E CUSN-C
- DIN 1733 EL-CUSN 7

### APPLICATIONS

- Suitable for welding of cast-irons without preheat if machinability is not required.
- Suitable for cladding.
- Welding suitable for bushes, brass parts, valve seats, bearing, ship propellers, malleable iron, galvanized iron, impellers blades.

### DESCRIPTION

- A thin coated electrode intended for welding of copper and copper-tin alloys. Welding suitable copper or bronze to steels. For obtain best results, used short arc and control interpass temperature.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)			
COPPER (CU)	MAGNESIUM (MN)	TIN (SN)	PHOSPHORUS (P)
Balance	0.70 MAX	7.00-9.00	0.10-0.35

CURRENT POLARITY	WELDING POSITION
DC(+), AC	FLAT, HORIZONTAL FLAT

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)		
ULTIMATE TENSILE STRENGTH (N/MM <sup>2</sup> ) KSI	ELONGATION (%)	HARDNESS (METAL)
280 MIN	20 MIN	85-100 HB

SIZE AND CURRENT RECOMMENDATIONS		
SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC+, AC
2.5mm x 350mm	3/32" x 14"	40-70
3.2mm x 350mm	1/8" x 14"	70-100
4.0mm x 350mm	5/32" x 14"	110-150

### RE-DRY CONDITIONS

- Re-dry the electrode at 150°C for 1 hour.

NOTE:  
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