

# ROCAST- BRONZE

A SPECIAL THIN COATED BRONZE ELECTRODE  
FOR JOINING AND SURFACING

BASIC ALLOY: C, CU, SN, P  
AWS/SFA-5.6: ECUSN-C  
DIN 1733 EL- CUSN-7

## KEY FEATURES:

ROCAST BRONZE is one copper alloy electrode with tin and phosphor bronze as the core and low hydrogen flux coating. It has certain strength, good plasticity, impact resistance, wear resistance and corrosion resistance. The welding process has good performance and versatility. DC power supply and electrode are used to connect the positive electrode. used short arc and control interpass temperature

## APPLICATIONS

- It is suitable for welding pure copper, brass, phosphor bronze and other kinds of metal.
- It can be widely used for surfacing welding of phosphor bronze bushing, ship propeller blade, etc.
- It can also be used for welding repair of cast iron and welding

## RE-DRY CONDITION

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

## WELDING NOTE:

1. Clean the weld area free of any surface contaminations.
2. Preheating of the job between 250°C - 500°C may be necessary according to the amount of weld metal to be deposited and the size and type of casting.
3. After the welding is completely with a layer of asbestos or dry lime until it attains room temperature.

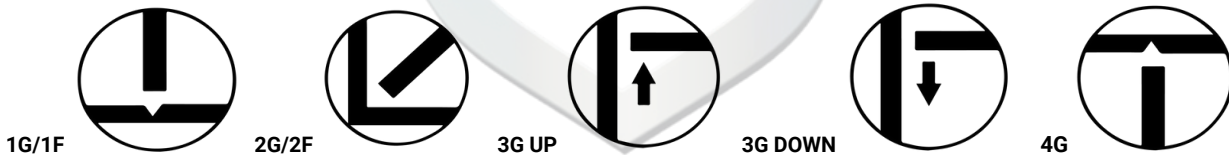
## CHEMICAL COMPOSITION:

| P        | Pb        | Sn        | Cu    | Other    |
|----------|-----------|-----------|-------|----------|
| 0.30 Max | 0.020 Max | 7.00-9.00 | Rest. | 0.50 max |

## WELD METAL HARDNESS:

| UTS (N/mm <sup>2</sup> ) | EL % (l=5d) | Hardness  |
|--------------------------|-------------|-----------|
| 280 min.                 | 20.00 min.  | 85-100 HB |

## WELDING POSITION



## DIEMENSION, CURRENT CONDITION & PACKING DATA

| Size (mm) (Dia) | Size (inch) (Dia) | Current Condition (DC+) Amps | Wt. of /pkt. | Wt. of Case |
|-----------------|-------------------|------------------------------|--------------|-------------|
| 2.50/ 2.40      | 3/ 32"            | 50-70                        | 2            | 10          |
| 3.15/ 3.20      | 1/ 8"             | 80-100                       | 2            | 10          |
| 4.00            | 5/ 32"            | 110-140                      | 2            | 10          |
| 5.00            | 3/ 16"            | 130-180                      | 2            | 10          |