

CARBO ZIBRO 6 AC

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

Approvals ---

Typical applications and characteristics Basic-graphite special coated tin bronze electrode for repairing copper and copper tin bronzes (Cu-Sn 6-8 %), bronzes, and phosphor bronzes. Also for dissimilar joints.
Recommended for surfacing on bronzes, 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	140	>20

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

Current = + / ~ 50 V

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	240	962	20,8	5,0	20,0
3,2 x 350	80 - 120	142	570	35,1	5,0	20,0
4,0 x 450	120 - 150	96	383	62,6	6	24,0
5,0 x 450	150 - 200	61	245	97,8	6,0	24,0