

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

(typical values)

Tensile strength R _m N/mm²	Yield strength	Elongation	Hardness	
	R _{p0,2} N/mm ²	A ₅ %	HB	
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

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.