OK 94.25



Electrode for welding copper and bronzes, especially tin-bronzes. It is also suitable for cladding steels and for smaller repair work of weldable cast irons.

Specifications	
Classifications	EN ISO 17777 : E Cu Z (CuSn7)

Welding Current	DC+
Alloy Type	Copper alloy
Coating Type	Basic

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	235 MPa	360 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C	25 J
As Welded	0 °C	20 J

Typical Weld Metal Analysis %		
Mn	**Cu**	**Sn**
0.4	93	6.5

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 350 mm	60-90 A	22 V	71 %	39 sec	1.2 kg/h
3.2 x 350 mm	90-125 A	24 V	72 %	40 sec	1.9 kg/h
4.0 x 350 mm	125-170 A	25 V	74 %	41 sec	2.9 kg/h