



# CEWELD E CuMn

**TYPE** Copper based electrode developed for joining and cladding.

**APPLICATIONS** CEWELD E CuMn is suitable for welding and overlaying Copper and Copper Alloys, Cast Iron and steel.

**PROPRIÉTÉS** Ductile welding deposit with high conductivity and corrosion resistance. The weld deposit is free from porosity and offers similar strength as most commercial copper grades. Thicker sections than 5 mm should be preheated up to approximately 500 °C.

**CLASSIFICATION**

AWS	A 5.6: E Cu
EN ISO	17777: E Cu 1893
W.Nr.	~2.1363
F-nr	31

**CONVIENT POUR** Cladding steel, Grey cast iron, Copper, Copper Alloys and dissimilar welding.  
**Mat.n:** 2.0040, 2.0060, 2.0070, 2.0076, 2.0080, 2.0090, 20100, 2.0110, 2.0150, 2.0170,  
**UNS:** C10100, C11000, C10300, C11020, C12000, C12200, C12250, C14200,  
 CW008A, CW021A, CW023A, CR024A  
 Cu-OF, E Cu, Cu-SE, Cu-SW, CU-SA, Cu-F, Cu-SF, Cu-D, Cu-DLP, Cu-DHP

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

Si	Mn	P	Fe	Sn	Ni+Co	Cu
0.25	2.5	0.08	0.1	0.7	0.2	96

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded		205	35	100 HB

**ETUVAGE** 140°C / 2 hr

**GAS ACC. EN ISO 14175**