



# Selectarc Cu116

*Basic coated Cu-Al  
Bronze Electrode*

## Classification

AWS A5.6 : ~ECuAl-A2      DIN 1733 : EL-CuAl9  
ISO 17777 : E Cu 6100A (CuAl9)

## Description & Applications

Basic coated electrode for joining and surfacing on aluminium bronzes with up to 10%Al and for dissimilar joints between steels and CuAl-bronzes. Also recommended for overlays on cast iron, steels and copper alloys. Excellent weldability, stable arc, less spatters, easy to remove slag.

**Main applications:** Ship building, sea water applications, desalination plants, chemical industry, pump parts which are attacked by salt water (propellers, bearings...).

### Base materials

UNS	Alloy	DIN	Material N°
C60600		CuAl5	2.0916
C61000		CuAl8	2.0920
C68700	Yorcalbro	CuZn20Al2	2.0460

## Typical Weld Metal Composition ( % )

Al	Mn	Fe	Cu
8.0	1.0	0.7	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Hardness
180	420	>20	180 HB

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x350
Current	( A )	80-100	90-120	120-140

Redrying 2 h at 250°C. Joints to weld must be clean, exempt from grease, cracks. Guide electrodes with a slight declination (10-20°) inclined in direction of travel). Weld with a short arc. To improve degassing of the deposit, adopt a low welding speed. Heavy pieces (sections above 6 mm) have to be preheated to 150-250°C.

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