

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)
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Welding Current	DC+
Alloy Type	Copper alloy
Coating Type	Basic

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	235 MPa	360 MPa	25 %

Charpy Testing

Testing Condition	Testing Temp	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	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	60-90 A	22 V	71 %	39 sec	1.2 kg/h
3.2 x 350.0 mm	90-125 A	24 V	72 %	40 sec	1.9 kg/h
4.0 x 350.0 mm	125-170 A	25 V	74 %	41 sec	2.9 kg/h