Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1282

Tin Bronze Electrode AC/DC

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.6 E CuSn – C
DIN 1733: EL - CuSn8

FEATURES & APPLICATIONS

For joining a wide variety of copper base alloys to themselves and to steels and cast irons.

AC - DC tin bronze electrode can be used as an electric brazing rod
- Bronze electrode that works very well on AC current.
- Excellent for joining copper base alloys not only to themselves but to stainless steel, cast iron, and steels.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: A multi phase copper base structure with complex eutectoids.
Flux Color: Dark Brown

Sn	Fe	P	Al	Mn	Pb	Si	Ni	Other	Cu
8	.1	.1	.01	.01	.02	.05	.05	.50	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	**Maximum Value Up to:**
Tensile Strength	50,000 PSI (340 MPa)
Yield Strength	30,000 PSI (210 MPa)
Elongation	18%
Hardness	Brinell 105, Rockwell B78

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Straight (-) or AC

Diameter (mm)	**3/32 (2.5)**	**1/8(3.25)**	**5/32 (4.0)**
Minimum Amperage	75	100	120
Maximum Amperage	105	135	160

Welding Techniques: Remove all surface contamination from weld area. Maintain a short arc gap and fill in craters prior to extinguishing the arc.

Welding Positions: Flat

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
3/32 (2.5)	14" (350)	.6 oz. (17g)	27 (59)	54 (118)	85
1/8 (3.25)	14"(350)	.7 oz (20g)	22 (48)	38 (83)	120
5/32 (4.0)	14" (350)	1 oz (28g)	15 (32)	20 (45)	140

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	14" (350)
Electrodes / lb	22	14	9
Electrodes / kg	48	31	20