



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
1283
Tin Bronze DC Electrode

INTERNATIONAL CLASSIFICATIONS

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

FEATURES & APPLICATIONS

Repairing bronze parts, especially those that are subject to sea water and many other chemicals.

A special tin-bronze electrode for joining and surfacing on DC (+)

- Tin content makes deposits harder and more wear resistant.
- Deposits are uniform and porosity free.
- Slag is easy to remove.
- Also available in TIG form as item #6008

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: A multi-phase copper base structure with complex eutectoids.

Flux Color: Light Grey

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	58,000 PSI (410 MPa)
Yield Strength	42,000 PSI (290 MPa)
Elongation	33%
Hardness	Brinell 107

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

Diameter (mm)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	100	125
Maximum Amperage	150	190

Welding Techniques: Bevel edges of heavy sections. Preheat is not usually required. Maintain a medium arc length. Allow to cool before chipping slag.

Welding Positions: Flat, Horizontal

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
1/8 (3.25)	14" (350)	.8 oz. (22g)	20 (45)	25 (54)	125
5/32 (4.0)	14"(350)	1.1 oz (32g)	14 (31)	16 (36)	155

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/8 (3.25)	5/32 (4.0)
Length (mm)	14" (350)	14" (350)
Electrodes / lb	13	9
Electrodes / kg	29	20