

# OK 94.25

Type Basic

SMAW  
EL-CuSn7

## Description

Electrode for welding copper and bronzes, especially tin bronzes. It is also suitable for cladding steels and for small-scale repair work in weldable cast irons.

## Applications:

For the repair and construction of parts in casting such as:

- valves
- pumps
- housings
- bearing surfaces

## Welding current

DC+



## Classifications

DIN 1733 EL-CuSn7

## Typical all weld metal composition, %

Mn	P	Cu	Sn	Fe
<0.5	<0.1	92.5	7.0	<0.2

## Typical mech. properties all weld metal

Yield stress, MPa	235
Tensile strength, MPa	330-390
Elongation A5, %	25
Hardness( HB):	95
(Preheat and interpass temp. 300°C)	

## Charpy V

Test temps, °C	Impact values, J
+20	25
0	20

## Approvals

Sepros UNA 409820

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	60-90	22	0.71	77.,0	1.2	39
3.2	350	90-125	24	0.72	46.0	1.9	40
4.0	350	125-170	25	0.74	30.5	2.9	41