

## Zibro

**CATEGORY** SMAW Stick Electrodes

**TYPE** Bronze electrode developed for welding on DC+ and AC.

**APPLICATIONS** Zibro is suitable for welding and overlaying copper and copper alloys, phosphor and tin -bronzes and copper blades in mechanical and plant engineering and also for shipbuilding.

**PROPERTIES** Ductile welding deposit with good sliding properties suitable for bearings etc.

**CLASSIFICATION**

AWS	A 5.6: E CuSn-C
EN ISO	no standard
DIN: W.Nr.	2.1025
DIN	1733: EL-CuSn 7 (8555: E 30-UM-100-CNR )

**SUITABLE FOR** Tin brons alloy on bushing metal, copper, copper alloys, cast steels, bearing repair, art repair.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

Cu	Sn
rem	6-8

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	120	280					120

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	350	50-75	3.5	21	19.5
3.2	350	60-100	3.5	21	32.8
4.0	350/450	80-130	3.5	21	63.0
5.0	450	110-160			100.1

**REDRYING TEMPERATURE** 150°C / 2hr