

# OK 94.25



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.

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

- valves
- pumps
- housings
- bearing surfaces

<b>Classifications</b>	EN ISO 17777 : E Cu Z (CuSn7)
<b>Approvals</b>	Seproz UNA 272581

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	Copper alloy
<b>Coating Type</b>	Basic

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	235 MPa	330-390 MPa	25 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
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	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	60-90 A	22 V	0.71	77.0	39 sec	1.20 kg/h
3.2 x 350 mm	90-125 A	24 V	0.72	46.0	40 sec	1.90 kg/h
4.0 x 350 mm	125-170 A	25 V	0.74	30.5	41 sec	2.90 kg/h