

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	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 _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	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