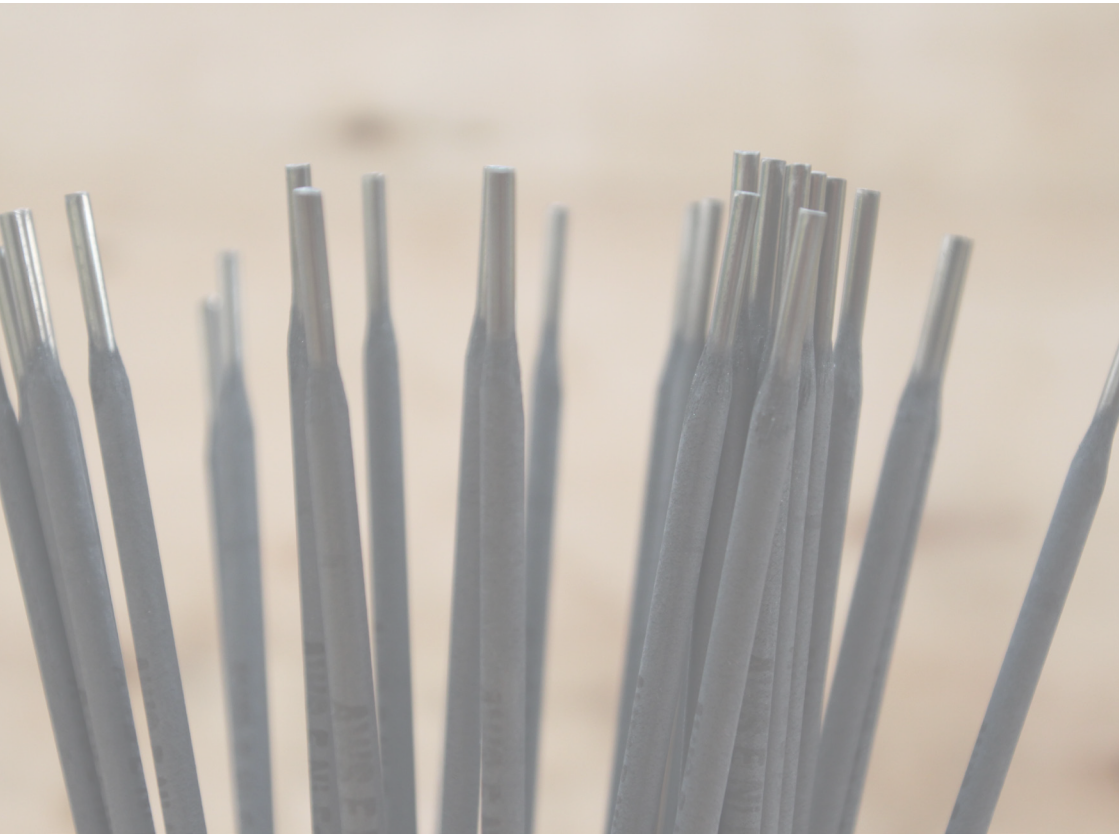

MWA
Product Guide
2nd Edition

CONTENTS

MAC BRONZE E808

A versatile coated electrode which deposits a tough overlay of fully deoxidised bronze. Designed for joining and overlaying steels, cast irons, malleable iron, bronzes, brass and copper based metals. Due to the high thermal conductivity of copper alloys, pre-heating is advisable particularly if heavy sections are involved. The electrode is recommended for overlaying and building up bearing surfaces, bushes, impellor blades, valve seats, etc.

Typical All Weld Metal Chemical Analysis (%)

Cu	Mn	Sn
91.0	0.4	7.5

Typical All Weld Metal Mechanical Properties

As Welded	
Tensile Strength	465 N/mm²
0.2% Proof Stress	310 N/mm²
Elongation	20%

Sizes Available & Recommended Amperages

2.5mm	3.2mm	4.0mm
60-80	80-130	130-180

Related Specification:
AWS E Cu Sn-C
Current:
AC/DC (+)
Storage:
If allowed to become damp, the electrodes should be re-dried for one hour at 110°C before use.

MAC BRONZE E809

MAC BRONZE E809

Superior coated tough bronze electrode for joining and overlaying steels, cast irons, malleable irons, bronzes and copper based metals. Due to the high thermal conductivity of copper and copper alloys pre-heating is advisable in certain instances particularly where heavy sections are involved. Highly recommended for bearing surfaces and for wear facing against sea water corrosion.

Typical All Weld Metal Chemical Analysis (%)

Cu	Mn	Sn
84.30	0.40	14.20

Typical All Weld Metal Mechanical Properties

As Welded	
Tensile Strength	386 N/mm²
0.2% Proof Stress	278 N/mm²
Elongation	20-25%

Sizes Available & Recommended Amperages

2.5mm	3.2mm	4.0mm
50-75	80-120	120-175

Related Specification:
AWS E Cu Sn I 14% Tin Bronze Type
Current:
DC (+)
Storage:
If allowed to become damp, the electrodes should be re-dried for one hour at 110°C before use.

Telephone: +44 (0) 121 556 6366 Fax: +44 (0) 1782 566123

MAC BRONZE E810

An electrode designed for joining and overlaying aluminium bronze and for corrosion and wear resistant deposits on steel and cast irons. The weld metal deposits will produce good friction and corrosion resistance. Ideal for bearing surfaces, shafts, guides, slides, gear teeth and any wear application involving metal to metal friction.

Typical All Weld Metal Chemical Analysis (%)

Al	Cu	Fe	Mn
7.5-9.5	BAL	0.99-Max	0.5-1.8

Typical All Weld Metal Mechanical Properties

As Welded	
Tensile Strength	480 N/mm²
Hardness	160 HB
Elongation	20%

Sizes Available and Recommended Amperages

2.5mm	3.2mm	4.0mm
60-80	80-130	130-180

Related Specification:
AWS E Cu Al-A2
Current:
DC (+)
Storage:
If allowed to become damp, the electrodes should be re-dried for one hour at 200°C before use.

Email: sales@mwa-international.com Website: www.mwa-international.com