



## MAC BRONZE E809

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■ **Description & Applications:**

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.

■ **Related Specification:**

AWS E Cu Sn 14% tin bronze type

■ **Typical All Weld Metal Chemical Analysis %:**

Mn	Cu	Sn
0.40	84.30	14.20

■ **Typical All Weld Metal Mechanical Properties:**

**As Welded**

0.2% Proof Stress	278 N/mm <sup>2</sup>
Ultimate Tensile Strength	386 N/mm <sup>2</sup>
Elongation	20- 25 %

■ **Current:**

DC (+).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
50-75	80-120	120-175

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 110°C before use.