

SPECIAL ELECTRODE FOR WELDING ALL GRADES OF COPPER

Alloy Basis

Cu

Characteristics :

SME B06 is a specialized electrode designed for smooth and stable arc performance. It produces a weld deposit with excellent corrosion resistance and high electrical conductivity.



Typical Applications

This electrode is suitable for welding deoxidized, tough-pitch, or electrolytic copper. Applications include electrical bus bars, switchgear, transformers, generators, evaporator shells, distillation columns, cooling pans, heat exchangers, boilers, steam coils and high-pressure conduits as well as the fabrication of copper equipment for chemical industries and high-conductivity electrical joints.

Mechanical Properties

Tensile Strength : 18 - 25 kgf/mm²

Welding Current : DCEP

Size (Ø mm)	2.50	3.15	4.00
Current (amps)	60 - 80	90 - 130	140 - 170

Availability:

Standard Size: 4.0, 3.15, 2.50 in 350 mm length

Packing: 2 kg

Procedure

Clean the area to be welded thoroughly. Use a slight weaving motion and maintain the shortest possible arc at the minimum recommended amperage. Preheating is necessary for thick sections and also preheat up to 800°C for heavy pure copper job.