

# Lehami 7210

**A Special tin-bronze electrode for joining and surfacing on DC (+)**



## SPECIAL FEATURES

- Tin content makes deposits harder and more wear resistant.
- Deposits are uniform and porosity free.
- Slag is easy to remove.

## APPLICATIONS

Repairing bronze parts, especially those that are subject to sea water and many other chemicals.

## AVAILABLE SIZES

INCHES	METRIC	GAUGE	RECOMMENDED AMPERAGE
1/8"	3.2 mm	10	100 - 150
5/32"	4.0 mm	8	125 - 190

**RECOMMENDED CURRENT:** DC Reverse polarity (Electrode +)

**WELDING POSITIONS:** Flat, Horizontal

## WELDING TECHNIQUES:

Bevel edges of heavy sections. Preheat is not usually required. Maintain a medium arc length. Allow to cool before chipping slag.

## TYPICAL MECHANICAL PROPERTIES

### Undiluted Weld Metal

	<u>Maximum Value Up to:</u>
Tensile Strength as welded	58,000 psi (410 N / mm <sup>2</sup> )
Yield Strength	42,000 psi (290 N / mm <sup>2</sup> )
Elongation	33%
Hardness	Brinell 110

**MICROSTRUCTURE:**

A multi-phase copper based structure with complex eutectoids.

**WELD METAL ANALYSIS (Typical Weight, %)**

Al	Cu	Fe	Mn	Ni	P	Si	Sn
0.001	Bal	0.10	0.01	0.05	0.10	0.05	8

**DEPOSITION RATES**

<i>Diameter</i>	<i>Length</i>	<i>Weldmetal / Electrode</i>	<i>Electrodes per lb (kg) of Weldmetal</i>	<i>Arc Time of Deposition in Minutes per lb (kg) of Weldmetal</i>
1/8" (3.2 mm)	14" (350 mm)	0.80 oz (22 g)	20 (45)	25 (54)
5/32" (4.0 mm)	14" (350 mm)	1.1 oz (32 g)	14 (31)	16 (36)

<b>INTERNATIONAL SPECIFICATIONS</b>	<b>AWS/ASME IIC SFA 5.6 E CuSn - C</b>
	<b>DIN 8555 E30 - UM - 100 - CNR</b>
	<b>DIN 1733 EL - CuSn8</b>