

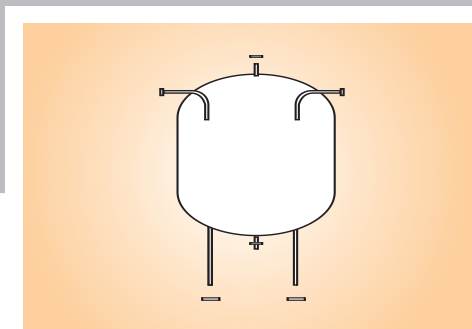
# ESSEN® B28

DC +

**Copper, Brass, Bronze For effective surface treatment**

**AWS A5.6 Ecu, ASME SFA 5.6 A 96 Ecu**

**An Electrode for Welding of Electrolytic Copper, Joining Copper to Brass, Bronze, Gunmetal and Steel and Cast Iron.**



## PROPERTIES

Deposits electrolytic type copper with the help of electrical welding.

## MECHANICAL PROPERTIES

Tensile Strength: 55,000 psi, Elongation: 21%

## APPLICATIONS

The electrode is suitable for joining and build up of copper and copper alloys. It also can be used for joining copper, copper alloys to steel and cast iron. Typical application includes copper vessels, flanges, kettles, pipes & pipe joins in distillery, Beer, alcohol industries. The electrodes can also be used for electrical welding of copper electrical contacts, bus bars etc

## WELDING PROCEDURE

Clean the surface area to be welded. Preheat if required. Use DC-straight polarity current.

RECOMMENDED AMPERAGE	
Size	Current
3.15mmx 350mm	150 - 200Amps
4.00 mm x350 mm	180 - 220Amps

PACKING	
3.15 mm x 450 mm 5 kg	29 pcs/kg (Approx.)
4.00 mm x 350 mm 5kg	18 pcs/kg (Approx.)



**ESSEN**  
WELDING ALLOYS PVT. LTD.



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PREMIUM WELDING ALLOYS

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