

**516 DC+****COPPER ALLOY****DESCRIPTION**

Electrode with **very high copper content core** for welding and building up various common grades of pure copper and copper alloys.

**CHARACTERISTICS**

- **Excellent electrical and thermal conductivity**
- Smooth fusion
- Excellent resistance to corrosion
- Porosity-free and crack-resistant deposit
- Easy slag removal
- Good colour match on pure copper

**TYPICAL APPLICATIONS**

Assembly and building up of electrolytic and deoxidized copper. Copper coating on steel and cast iron, statue components, building up of shaft cranks, couplings, electrical copper bus bars, etc.

**PROCEDURE**

Remove any trace of oil, grease and/or dirt from the surface. Gouge the base metal over 3/16" (5.0 mm) thick. **Preheat heavy parts between 400 - 600°C (752 - 1112°F), depending on the thickness.** Maintain a short arc with a slight weaving motion. Cool before removing slag between passes.

**MECHANICAL PROPERTIES**

Tensile strength: 31 000 psi (220 MPa)  
 Elongation: 35 %  
 Hardness (as-welded): 55 BH

**WELDING PARAMETERS**

Diameter: 3.2 mm (1/8")  
 Amperage: 95 - 135 A

TIG rods also available: **Soudotec T516** and MIG solid wire: **Soudotec M8516**

Rév.: 21\_08

*Specialized welding alloys and technology. For technical assistance or for ordering :*