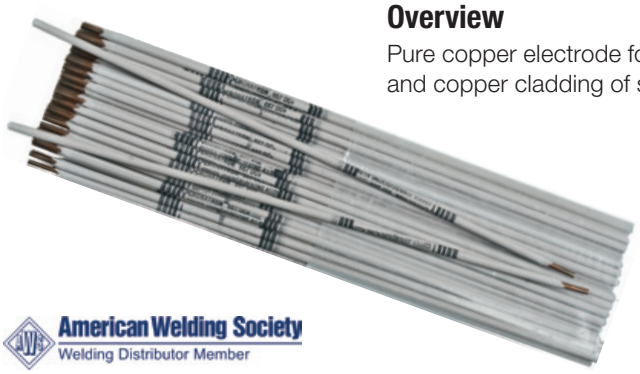
Technical Data Sheet
667 Electrode Copper Electrode

Cronatron™ A LAWSON BRAND



American Welding Society
Welding Distributor Member

Overview

Pure copper electrode for joining and buildup of electrolytic, tough-pitch and deoxidized copper, and copper cladding of steel and cast iron.

Features/Benefits

- Highest electrical conductivity and corrosion resistance
- Excellent ductility
- High strength
- Perfect color match to copper
- Excellent for joining or buildup
- No preheat required on thin components
- The deposit of 667 Electrode has in excess of 99% copper
- Weld deposit is non-porous

Applications

- Blast furnace blow molds
- Sealing rings
- Cooling boxes
- Oxygen lance headers
- Busbars
- Contact jaws
- Electrical components
- Rebuilding pitted electrode holder
- Joining copper to steel

Method of Application

DC reverse polarity

Identification

Printed gray electrode

Directions for Use

Use DC reverse polarity. A close arc should be maintained using a weave or stringer bead technique. Hold electrode perpendicular to workpiece. Preheating unnecessary on thin gauge material. Heavy sections should be preheated to 850°F to 1,000°F (450°C to 540°C). Slag can be removed easily with light chipping or brushing after cooling. When welding copper or copper alloys, always use an electrode one size larger than normal for steel.

Directions for Use

Tensile Strength: 35,000 PSI (241 MPa)
Hardness: Rb 50 to Rb 70
Elongation: 50%