

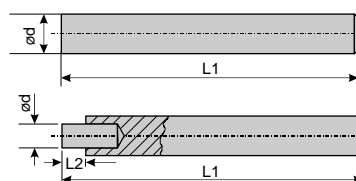
Electrodes Data Sheet

The right electrode selection influences quality of the weld joint and the uniformity in series production. Electrode's stability under heat is crucial concerning the costs for series production. PECO offers the whole range of electrodes depending on the welding material:

Electrode classes:

- **Class 0 electrodes (ECu)**
made from electrolytic copper (E Cu) hard-drawn, for welding Al and Al-alloys.
- **Class 2 electrodes (CuCr, CuCrZr)**
made from copper-chromium (CuCr, CuCrZr), for welding mild steel, stainless steel, Ni-alloys, brass and bronzes.
- **Class 3 electrodes (CuCoBe)**
made from copper-cobalt-beryllium (CuCoBe), for welding high-alloy steel, NiCr-alloys and monel.
- **Class 6 electrodes WCu, WCuAg)**
made from copper-tungsten (WCu, WCuAg), for welding non-ferrous metals with high copper content.
- **Class 7 electrodes (W) und 7.3(WL)**
made from tungsten (W), brazed into copper base, for welding copper and silver, resistance brazing and hot staking, respect. thermodes from tungsten-lanthan (WL).
- **Class 8 electrodes (Mo) and 8.1 (TZM)**
made from molybdenum (Mo) (brazed into copper base), for welding copper (stranded copper cable) and silver respect. titan-zircon-molybdenum for compacting device welding.

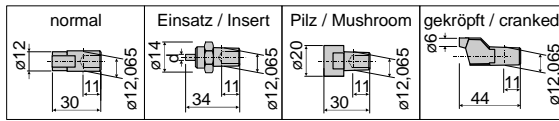
1. Electrodes, cylindrical



Cl.	Mat.	N d [mm]	Insert d [mm]	L1 mm	L2 mm	Part-no.
0	E-Cu	3	-	40	-	765.90 777
0	E-Cu	6	-	50	-	765.91 116
0	E-Cu	10	-	75	-	765.90 678
2	CuCrZr	3	-	40	-	765.83 458
2	CuCrZr	4	-	30	-	765.90 675
2	CuCrZr	4	-	75	-	765.90 745
2	CuCrZr	6	-	50	-	765.90 674
2	CuCrZr	10	-	75	-	765.90 677
3	CuCoBe	3	-	40	-	765.90 843
3	CuCoBe	6	-	50	-	765.90 673
3	CuCoBe	10	-	75	-	765.90 676
6	WCu	3	2	40	3	765.83 449
6	WCu	6	3	50	5	765.83 470
6	WCu	6	4	50	5	765.83 324
6	WCu	10	6	75	6	765.83 333
7	W	3	2	40	3	765.83 325
7	W	6	2	50	5	765.83 314
7	W	6	3	50	5	765.83 315
7	W	6	4	50	5	765.83 319
7	W	10	3	75	6	765.83 338
7	W	10	4	75	6	765.83 339
7	W	10	6	75	6	765.83 336
7.3	WI	6	2	50	5	765.21 154
7.3	WI	6	3	50	5	765.21 155
7.3	WI	6	4	50	5	765.21 156
7.3	WI	10	3	75	6	765.21 157
7.3	WI	10	4	75	6	765.21 158
7.3	WI	10	6	75	6	765.21 159
8	Mo	3	2	40	3	765.83 326
8	Mo	6	2	50	5	765.83 304
8	Mo	6	3	50	5	765.83 305
8	Mo	6	4	50	5	765.83 306
8	Mo	10	3	75	6	765.83 311
8	Mo	10	4	75	6	765.83 312
8	Mo	10	6	75	6	765.83 313
8.1	TZM	6	4	50	5	765.83 318
8.1	TZM	10	6	75	6	765.15 898
8.1	TZM	10	8	75	6	765.17 711

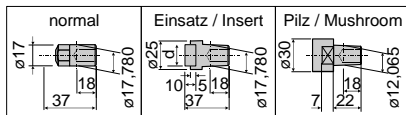
2. Taper shank electrodes

2.1 MK1



Cl.	Material	N d [mm]	Insert d [mm]	L mm	Part-no.
MK1-Normal electrode					
2		12		30	765.83 274
MK1-Insert electrode					
7	W	14	4	34	765.83 473
7	W	14	6	34	765.83 425
7	W	14	8	34	765.83 253
8	Mo	14	4	34	765.83 323
8	Mo	14	5	34	765.83 279
8	Mo	14	6	34	765.83 330
8	Mo	14	8	34	765.83 332
MK1-Mushroom electrode					
2		20		30	765.83 280
3	CuCoBe	20		30	765.90 703
MK1-Cranked electrode					
2				44	765.83 275

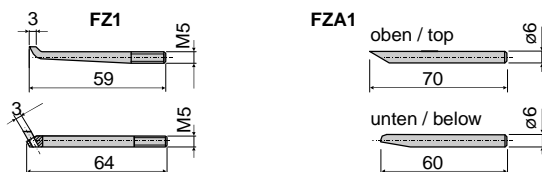
2.1 MK2



Cl.	Material	N d [mm]	Insert d [mm]	L mm	Part-no.
MK1-Normal electrode					
0	ECu	17		37	765.83 293
2		17		37	765.83 295
MK1-Insert electrode					
8	Mo		13		765.83 482
MK1-Mushroom electrode					
2					765.83 467

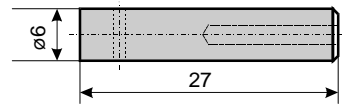
3. Special electrodes

3.1 FZ-Electrodes



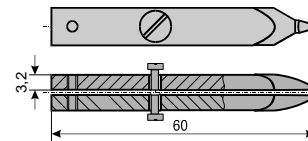
Cl.	Mat.	N d [mm]	Insert d [mm]	L mm	Part-no.
FZ1					
2		M5	3	59	76.590.680
8	Mo	M5		64	76.583.307
FZA1					
3	Cu CoBe	6	top	70	765.90 764
3	CuCoBe	6	below	60	765.90 765

3.2 Thermodes with isolation pin



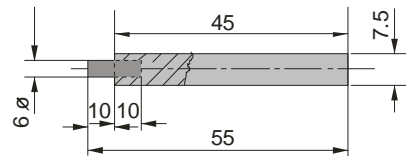
Cl.	Material	N d [mm]	Insert d [mm]	L mm	Part-no.
7.3	WL	6	---	25	765.35 332

3.3 Gap welding electrodes (couple)



Cl.	Material	N d [mm]	Insert d [mm]	L mm	Part-no.
8	Mo	2 x 3.2	0.4x1.0	60	765.03 505

3.4 Square electrodes for weld pincers



Cl.	Material	N d [mm]	Insert d [mm]	L mm	Part-no.
7.3	WL	7.5 x 7.5	6	55	765.37 184
8	Mo	7.5 x 7.5	6	55	765.37 185
8.1	TZM	7.5 x 7.5	6	55	765.37 186

3.4 Span pincers

on demand

When ordering bars for self-finishing please state electrode class, diameter and material. For special types we also supply square-selection bars. Special types on demand.

MIYACHI EUROPE GmbH

Lindberghstr. 1 D-82178 Puchheim
Tel. +49-89-839403-0 Fax: +49-89-83940310
info@mec.miyachi.com
www.miyachieurope.com