

	Nickel alloys		Nickel		Nickel silver		Red Bronze		Tin Bronze		Silicon Bronze		Brass 67/33		Brass 80/20		Copper		Alum. and Aluminium alloys		Corrosion and Temperature Resistant steel		Unall. Steel Tinned, Galv., Lead Coated, Cadm. Plated		Unall. Steel Oxide Covered		Unalloyed Steel Bright Surface	
Unalloyed Steel Bright Surface	Z	3	Z	3	S	3	S	3	Z	3	Z	3	N	3	N	3	N	3	S	7,8	D	5,6	D	3	Z	3	0	3
Unall. Steel Oxide Covered	3	c	3	c	3	c	3	c	3	c	3	c	3	c	3	c	3	c	3		3		3,5,6		3		3	
Unall. Steel Tinned, Galv., Lead Coated, Cadm. Plated	S	3	S	3	S	3	N	3	N	3	N	3	S	3	S	3	N	3	N	1,3	S	5,6	Z	2,3	Z	3		
Corrosion and Temperature Resistant steel	3		3	d,a,c	3	d,a	3	a	3	a	3	a	3	a	2,3	a,f	3	a,f	2,3	a,f	3	a,f	2,3	a,f	2,3	a,f		
Alum. and Aluminium alloys	S	3	S	3	S	3	N	3	N	3	N	3	S	3	S	3	S	3	N	3,5,6	D	5,6						
Copper	3,5,6		3,5,6		3,5,6		3,5,6		3,5,6		3,5,6		3,5,6		3,5,6		3,5,6		2,5,6		5,6	f						
Brass 80/20	N	3	N	3	N	3	S	3	S	3	S	3	S	3	S	3	S	3	D	1,2								
Brass 67/33	1,2		1,2		1,2		1,2		1,2		1,2		1,2		1,2	b	1,2	a,f	1,2	a								
Silicon Bronze	S	3	S	3	S	3	S	3	S	3	S	3	S	3	S	3	N	3										
Tin Bronze	4,7	a	4,7		4,7		4,7		4,7	e,c	4,7	e,c	4,7	e,c	4,7	e,c	4,7	e,c										
Red Bronze	Z	3	S	3	S	3	S	3	S	3	Z	3	S	3	S	3												
Nickel silver	4,7	a	4,7	a	4,7,3		4,7,3		4,7,3		3	a	3	b	3	a												
Nickel	S	3	S	3	S	3	S	3	D	3	S	3	D	3														
Nickel alloys	3	a,f	3		3		3		3		3		3															
	D	3	S	3	S	3	S	3	D	3	D	3																
	3		3		3		3		3		3																	
	S	3	S	3	D	3	D	3	D	3																		
	3		3		3		3		3																			
	D	3	D	3	D	3																						
	3		3		3																							
	D	3	0	3																								
	3		3																									
	D	3																										
	3																											



Electrode material for metal in the top row

Electrode material for metals in the left column

- 1 CuTe
- 2 CuCd 1
- 3 Brocadur CCZ
- 4 Brocadur WK
- 5 Brocadur CCNB
- 6 Brocadur CNCS
- 7 Wolfram electrode



Additional information

- a risk of sticking keep the electrode clean
- b use high power current and keep welding time short
- c low welding strength
- d coating shall be uniform
- e strictly observe welding procedure
- f risk of formation of intermetallic alloy



Weldability

- O excellent
- D good
- Z satisfactory
- S bad
- N unsatisfactory