



WA. ALLOY CO.

WASHINGTON ALLOY'S Quality Management System is Certified to **ISO 9001:2008** Cert # 05-R0925

RAINIER 3A Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

Rainier 3A is a multipurpose flux-coated electrode used for joining steel and cast iron parts to copper, brass and bronze. Excellent for overlays on shafts, pumps, impellers and propeller blades. Used for building-up bearing journals and frictional wear surfaces on heavier sections. Other uses include ornamental iron, galvanized iron and as a substitute for torch alloys on larger sections.

TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps	Diameter	Amps
1/16"	25-50	1/8"	95-150
5/64"	30-60	5/32"	120-200
3/32"	50-115	3/16"	180-260

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. When welding vertical reduce amperage 10-20%

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Tin	7.0-9.0	Phosphorus	0.05-0.35
Lead	0.02	Iron	0.25
Aluminum	0.01	Others	0.50

Elongation	45-50%
Yield Strength (psi)	up to 30,000
Tensile Strength (psi)	up to 65,000
Brinell Hardness	85-100
Machinability	Excellent

AVAILABLE SIZES: TU PHOSBRONZE C= 3/32", 1/8", 5/32"

SPECIFICATIONS; ANSI/AWS A5.6 ECuSn-C
ASME SFA 5.6 ECuSn-C

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