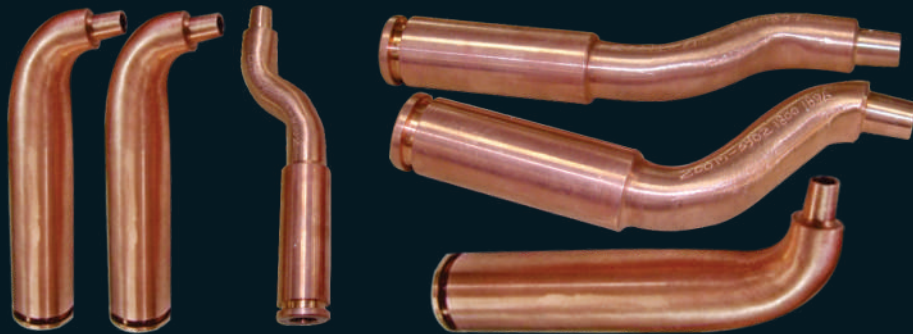


Gold Coin Electrode Holder

Beryllium Copper Nipple Electron Beam Welded to Chromium Zirconium Copper Holder Body

Existing Holder



Full Electrode Holder Constructed in Chromium Zirconium Copper

Problems associated with Electrode Holders made up of Chromium Zirconium Copper:

- Lower hardness in nipple area.
- Tip wear out issue is high.
- Life of Holder is less.

New Developed Holder



Beryllium Copper Nipple Electron Beam Welded to Chromium Zirconium Copper Holder Body

- Beryllium Copper (36C to 44C) has more hardness compared to Chromium Zirconium Copper (70B to 83B).
- Beryllium Copper material Electron Beam Welded onto Chromium Zirconium Copper at nipple area.
- Due to high hardness tip wear out issue is less.
- Life of holder is more.



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Complete Competence in Copper



ISO 9001 : 2015



ISO 14001 : 2015



OHSAS 18001 : 2007

Plot Nos: C14 & C15, SIPCOT Industrial Park, Irrungattukottai - 602 105, Sriperumbudur, (Close to Chennai), India.

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Gold Coin Electrode Holder

Beryllium Copper Nipple Electron Beam Welded to Chromium Zirconium Copper Holder Body

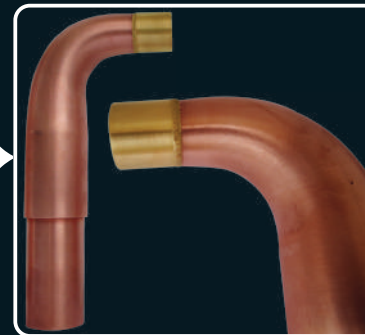
Before EB Welding



EB Welding Process



After EB Welding



Fully Machined Holder



2% Beryllium Copper + Chromium Zirconium Copper
(Gold Coin Electrode Holder)

Alloy	UNS No	Typical Composition	Hardness
Mipalloy3ZR (Cr Zr Cu)	C18150	Cr: 0.5-1.5% Zr: 0.05 - 0.25% Rest: Cu	70 - 83 HRB
Mipalloy 4 (2% Be Cu)	C17200	Be: 1.8-2.0%, Co: 0.2% Si: 0.2%, Al: 0.2% Rest: Cu	36 - 44 HRC



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