

Spark erosion of mould inserts and mould cores made from ALBROMET W164 and ALBROMET W200 copper alloys

Dear Sir or Madam,

For sink erosion of our beryllium-free copper materials ALBROMET W164 and ALBROMET W200, there has been no generally reliable setting data to date.

Recently, tests were carried out with two EDM machines (Zimmer & Kreim, OPS-Ingersoll) of the latest technologies at the company:

GUSTAV BLOME GMBH
Vertretung der Poco Graphite Inc. Texas/USA
75 417 Muehlacker

Spark Erosion – Calibration Data and Test Results						
Electrode: Copper-infiltrated graphite Poco EDM C3						
Erosion surface area mm ²	Erosion depth mm	Wear %	Erosion time min	Pulse duration μsec	Average current A/cm ²	Peak current A
ALBROMET W164						
130	5	18% (0,77; 4,23)	29	21	5	35
130	5	22%	23	21	7	35
100	5	20% (0,84; 4,16)	16	50	8	35
100	5	22% (0,9; 4,1)	18	20	5	35
ALBROMET W200						
130	5	21%	29	21	7	35
130	5	18%	30	21	5	35
100	5	20% (0,86; 4,14)	19	20	5	35
100	5	23% (0,94; 4,06)	16	50	8	35

The test results are considered as "Good"! Company GUSTAV BLOME offers all customers free on-site support in order to reproduce these results. Contact person is Mr. Schmalzried.