

ELLOR® GRAPHITE
FOR ELECTRICAL
DISCHARGE MACHINING

A complete range of
grades, from universal
to micro-grain graphite



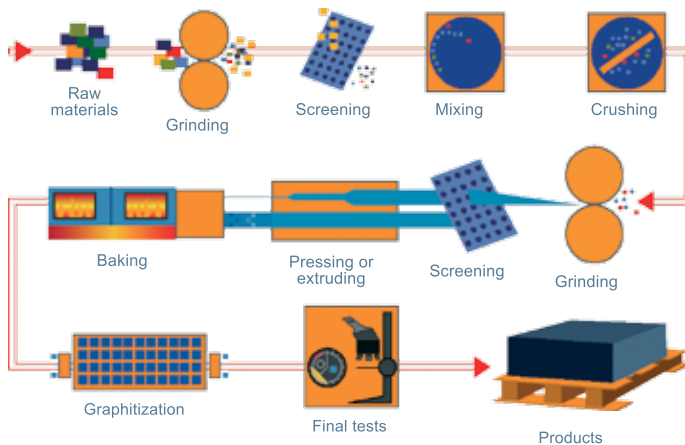
MERSEN

ELLOR® GRAPHITE GRADES FOR ELECTRICAL DISCHARGE MACHINING...

...to suit a wide range of applications



GRAPHITE MANUFACTURING

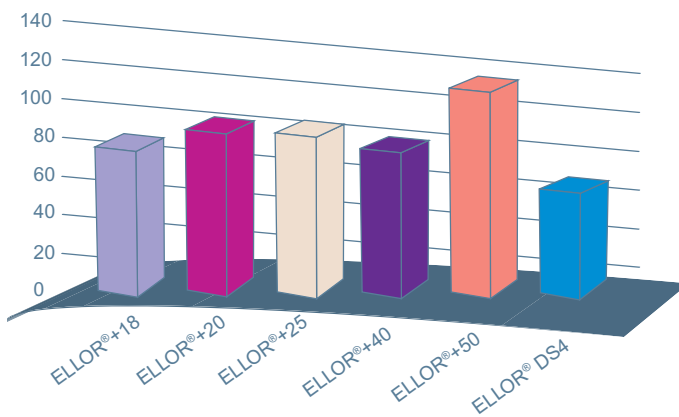


GRAPHITE ADVANTAGES

Graphite has many advantages that have made it the material most widely used for EDM electrodes.

- > It is **easy to machine**.
- > It is very resistant to **thermal shock**.
- > It has a **low coefficient of thermal expansion** (3 times lower than copper) which guarantees stability of electrode geometry during EDM.
- > It is available in **large blocks**.
- > It does not melt, but goes directly from the solid state to the **gaseous at 3,400°C**, which reduces wear.
- > Its **density** is 5 times **lower** than that of copper, which results in lighter electrodes.
- > It provides a higher **metal removal rate** than copper with less wear.
- > It has the unique characteristic that the **wear ratio** tends to decrease as the peak current increases.

GRADE MACHINABILITY



The index describes how difficult it is to machine the electrode. ELLOR®+25 equals 100 as a reference.

MACHINING RECOMMENDATIONS

MILLING	Speed m/min	Feed rate (per tooth) mm	<i>(We recommend dry machining with the use of a dust collector.)</i>	
<i>Roughing</i>	800~1000	0,1~0,8		
<i>Finish</i>	1000	< 0,09		
TURNING	Speed m/min	Advance mm per revolution (rpm)	Depth of cutting in mm	
<i>Roughing</i>	100~250	0,3~0,45	5~19	
<i>Finish</i>	200~450	0,06~0,15	0,1~0,5	
RECTIFICATION	Speed m/min	Advance mm / min		
	1000~2300	150~800	< 3	
SAWING	Speed m/min	Advance mm / min		
	350~500	300~400		

TOOLS

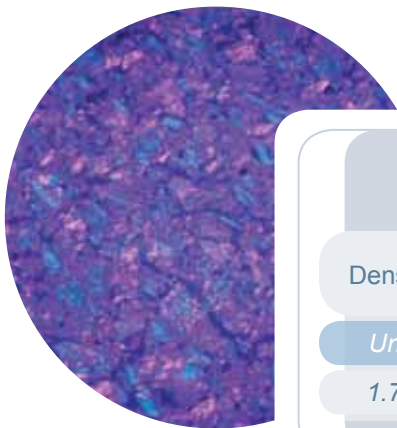
Micro-grain tungsten carbide, diamond,...

UNIQUE GRAPHITE GRADES WITH ENHANCED EDM PERFORMANCE

MERSEN, a worldwide leader in iso-molded graphite, offers a complete range of graphite grades to suit any EDM applications.

In order to satisfy customers and meet their unique specifications and requirements, new materials with improved properties and performance are constantly being developed. Our newest **ELLOR®** graphite grades now benefit from much finer grain size.

Ranging from universal to micro-grain graphite each grade has its own characteristics and offers uniform quality and structural consistency. **Excellent machinability** allows detailed finishing electrodes to be produced.



ELLOR®+18

Roughing graphite ideal for high metal removal rate

Maximum block size: 308 x 620 x 1,830 mm

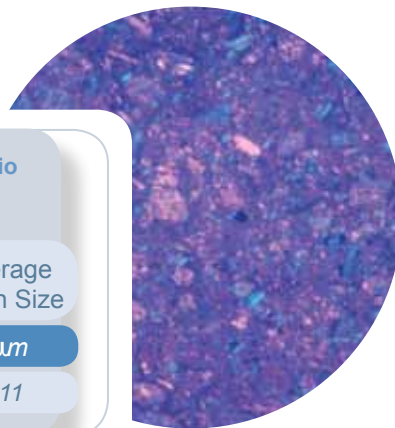
Density	Hardness	Hardness	Flexural Strength	Electrical Resistivity	Average Grain Size
<i>Unit</i>	<i>Rockwell "L"</i>	<i>Shore</i>	<i>MPa</i>	<i>μΩ.cm</i>	<i>μm</i>
1.78	98	55	45	1,370	12

ELLOR®+20

Universal graphite excellent Quality / Performance ratio

Maximum block size: 308 x 620 x 1,830 mm

Density	Hardness	Hardness	Flexural Strength	Electrical Resistivity	Average Grain Size
<i>Unit</i>	<i>Rockwell "H"</i>	<i>Shore</i>	<i>MPa</i>	<i>μΩ.cm</i>	<i>μm</i>
1.81	72	65	52	1,240	11



ELLOR®+25

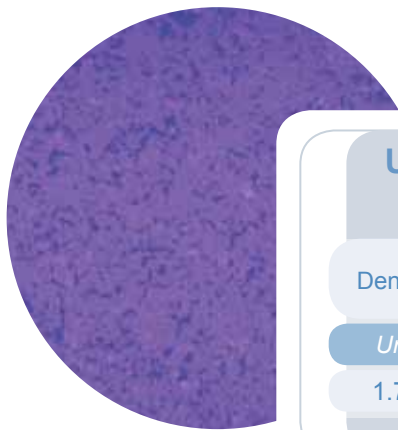
High quality universal graphite - Good surface finish

Maximum block size: 308 x 620 x 1,830 mm



Density	Hardness	Hardness	Flexural Strength	Electrical Resistivity	Average Grain Size
<i>Unit</i>	<i>Rockwell "H"</i>	<i>Shore</i>	<i>MPa</i>	<i>μΩ.cm</i>	<i>μm</i>
1.83	80	65	55	1,220	9

UNIQUE GRAPHITE GRADES WITH ENHANCED EDM PERFORMANCE



ELLOR[®]+40

Ultra fine grain graphite - Low electrode wear, fine detail

Maximum block size: 300 x 600 x 915 mm

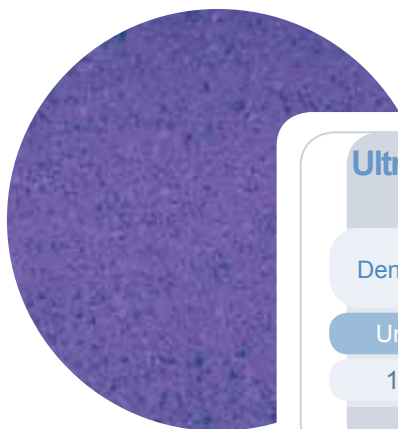
Density	Hardness	Hardness	Flexural Strength	Electrical Resistivity	Average Grain Size
Unit	Rockwell "H"	Shore	MPa	$\mu\Omega.cm$	μm
1.78	75	60	60	1,270	7

ELLOR[®]+50

High density ultra fine grain graphite - Lowest electrode wear

Maximum block size: 305 x 305 x 915 mm

Density	Hardness	Hardness	Flexural Strength	Electrical Resistivity	Average Grain Size
Unit	Rockwell "H"	Shore	Mpa	$\mu\Omega.cm$	μm
1.86	95	80	76	1,270	5



ELLOR[®] DS4

Ultra fine grain graphite - Ultimate precision and EDM performance

Maximum block size: 102 x 305 x 305 mm

Density	Hardness	Hardness	Flexural Strength	Electrical Resistivity	Average Grain Size
Unit	Rockwell "H"	Shore	Mpa	$\mu\Omega.cm$	μm
1.88	95	70	90	1,270	4

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Our materials are in conformity with the RoHS-Directive (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment).

Besides Mersen guarantees the application of the European Community REACH-Regulation (Registration, Evaluation, Authorisation and Restriction of Chemical substances) to all its plants located in Europe.

USE RECOMMENDATIONS

Good EDM results require not only the proper selection of EDM material, but also proper machine settings, such as peak current, on time, off time, gap size, electrode polarity and most importantly the flushing conditions.

Due to the many variations in work piece geometry, the EDM machine **setting conditions** for new geometries are mainly selected from **experience** and fine tuned as the work progresses. In effect, **the geometry** of the piece being produced will determine the **right selection**. There is not only one proper combination of settings for each grade of graphite, but in reality as many different setting combinations as the number of pieces that can be manufactured by EDM.

That is why experience in EDM is the number one factor of success. Our technical team can give the **basic support needed** to help you understand the effects of these different setting parameters. This information will help you **determine the proper parameters**.

Surface finish achievable on steel with ELLOR® graphite:

	Finishing mode				Intermediate				Roughing			
	▼▼▼				▼▼				▼			
VDI 3400	12	15	18	21	24	27	30	33	36	39	42	45
Ra μm	0.40	0.56	0.80	1.12	1.60	2.24	3.15	4.50	6.30	9.00	12.50	18.00
Ra μm	16	22	31	44	63	88	124	177	248	354	492	709
								ELLOR®+18				
								ELLOR®+20				
							ELLOR®+25					
						ELLOR®+40						
				ELLOR®+50 & DS4								

Recommended grades:

	ELLOR®+18	ELLOR®+20	ELLOR®+25	ELLOR®+40	ELLOR®+50	ELLOR® DS4
Wire EDM		○	●	●	●	●
Deep holes			●	●	●	●
Fine ribs			○	●	●	●
Steel	●	●	●	●	●	●
Refractory steel	○	○	●	●	●	●
Titanium, molybdenum, copper			○	○	●	●
Tungsten Carbide				○	●	●

- Applicable
- Suitable

Maximum current density per material:

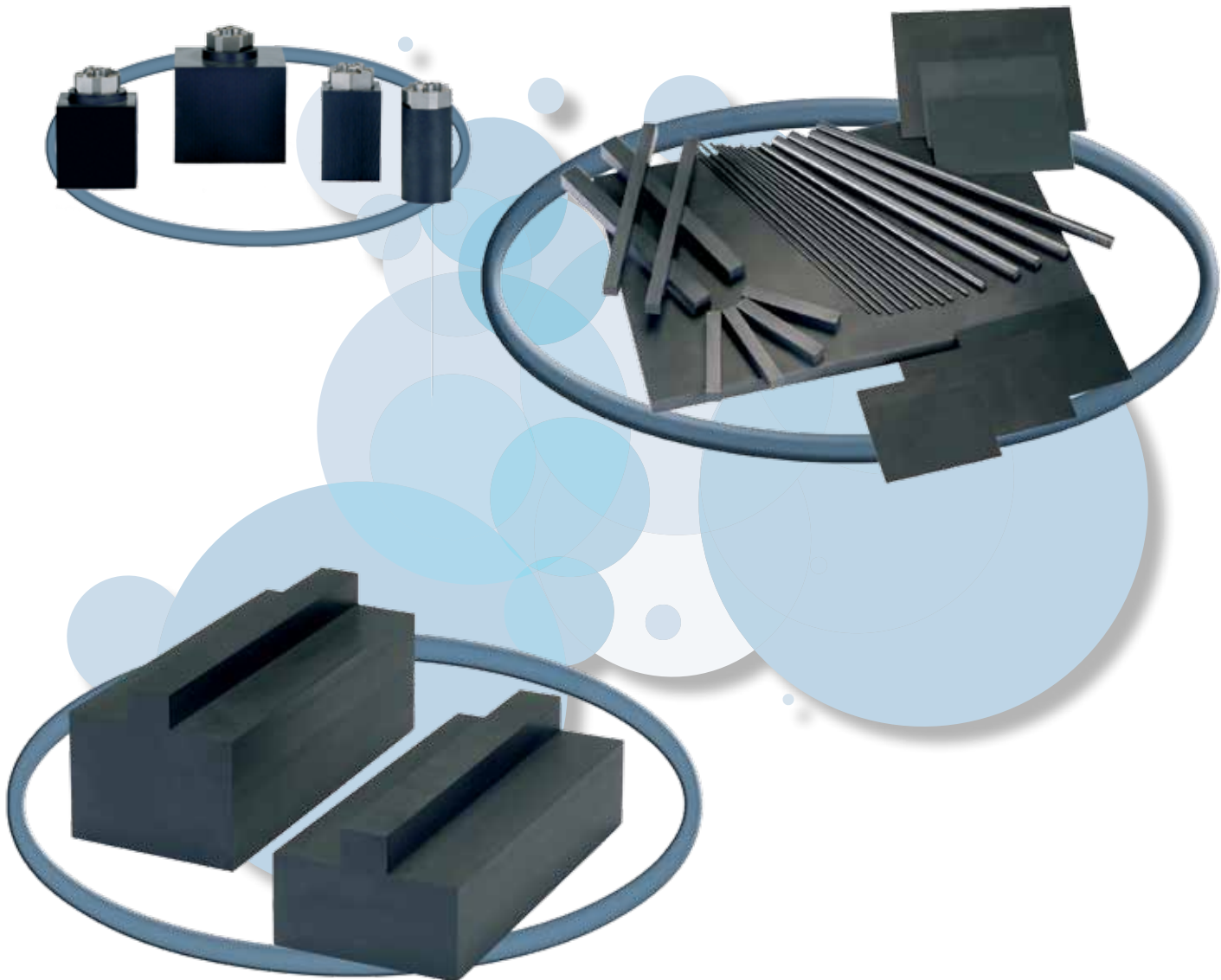
Electrode Material	Polarity	Maximum Current Density	Maximum current
Graphite	+	10 A/cm ²	400 A
Graphite	-	7 A/cm ²	25 A
Copper	+	15 A/cm ²	50 A
Cu-Gr	+	13 A/cm ²	
Cu-W	-/+	10 A/cm ²	25 A

ELLOR® GRAPHITE GRADES FOR ELECTRICAL DISCHARGE MACHINING

A large range of standard electrodes

ELLOR® GRAPHITE = GAIN IN PRODUCTIVITY

- > Using ELLOR® graphite means time savings, up to 40% in roughing mode.
- > With same current density, metal removal turns from 600 mm³ / min with copper to 1,200 mm³ / min with ELLOR® graphite.
- > The stability of ELLOR® graphite grades permits the machining of thin ribs.





progressive creative

MERSEN
Expertise, our source of energy

A WORLD EXPERT
 in materials and solutions
 for high temperature processes

A GLOBAL PLAYER

Global expert in materials and solutions for extreme environments as well as in the safety and reliability of electrical equipment Mersen designs innovative solutions to address its clients specific

needs to enable them to optimize their manufacturing process in sectors such as energy, transportation, electronics, chemical, pharmaceutical and process industries.

Contact for America
MERSEN USA St-Marys
 Graphite Materials Division
 215 Stackpole Street
 St Marys, PA 15857-1488 - USA
 Tel. : +1 814 781 -1234
 Fax : +1 814 781-8570

Contact for Europe
MERSEN France Gennevilliers S.A.S.
 41 rue Jean Jaurès - BP 148
 F-92231 GENNEVILLIERS CEDEX
 FRANCE
 Tel.: +33 (0)1 41 85 45 77
 Fax: +33 (0)1 41 85 45 11
 ellor@mersen.com

Contact for Asia
MERSEN Kunshan Co. Ltd.
 No. 29 South Taihu Road,
 Kunshan, Jiangsu Province
 215334, CHINA
 Tel.: +86 512 5763 9808
 Fax: +86 512 5763 9811

www.mersen.com

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