



Cu Pipe

A bronze electrode for welding of bronze, brass, carbon, steel, cast iron

**Typical Applications:**

Impellers, marine components, pump casing, castings, gear teeth, packing glands and sleeves, bushes, washers.

**Outstanding Features:**

- Excellent weldability.
- Dense, porosity-free deposits which are fully machinable and colour matching to bronze.
- Wide usability for steel, cast iron, bronze etc. for joining and overlaying applications.

**Recommendation:**

A unique bronze alloy electrode offering exceptional weldability. The arc is strong and controlled providing superior arc stability and easy handling features. The deposits are easily machinable to a smooth surface with low coefficient of friction. Weld deposit shows good resistance to salt water and steam corrosion.

**Procedure:**

Clean weld area, remove damaged metal by chiselling, bevel edges to 45°, preheat heavy sections to 150°-250°C. Using short arc, at minimum amperage, deposit thin stringer beads. Back-fill craters and chip slag between passes. Peening of deposits recommended. Air cool to room temperature.

**Recommended Amperages:**

Size (mm)	Amperage
3.15	80 - 100
4.00	90 - 130

Tensile Strength: 8 - 14 Kg/mm<sup>2</sup>

Conductivity: 80% IACS