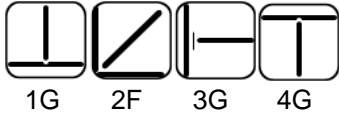


Applications

Suitable for welding copper and bronze to cast iron steel where colour matching is not essential, bearing bushings, impeller blades valve section.

Characteristics on Usage

It is a 94% copper contain light coated electrode, specially develop for the welding of Copper and Bronze. The weld metal gives 93% copper 6% tin and 0.20% phosphorous for complete deoxidation. Maintain preheat and inter pass temperature from 250 °C to 350 °C during the welding operation on heavy section.

Welding Positions**Chemical Composition Of Weld Metal**

P%	Cu %
0.35 Max	92.0 – 96.0

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	2 kg	10 Kg	DC (+)	50 - 80
3.15 x 350	2 kg	10 Kg		80 – 110
4.00 x 350	2 kg	10 Kg		110 – 160
5.00 x 350	2 kg	10 Kg		160 - 200