



Cu Pipe

Ultimate electrode for welding of bronze, brass, steel and 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.
- Versatile product 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°-200°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: 37 Kg/mm²
(52,000 psi)