

LH 214 DC



TIN-BRONZE ELECTRODE FOR WELDING
BRONZE PARTS WITH DC

PROPERTIES

The weld metal is free from porosity and cracks. The bead is smooth and uniform. Excellent colour match on bronze.

PROCEDURE

Prepare a large U groove approx. 80-90°. For work piece above 8 mm thick preheat up to 350-400°C. Chip the slag between passes. Bronze casting should be cooled slowly.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-80
	3.2x350	90-110
	4.0x350	120-150

TYPICAL APPLICATIONS

Welding and surfacing of copper, brass and bronze. Joining copper, bronze to cast iron and overlays on steel. Building up missing sections, filling cavities in copper alloy castings. Overlays on pumps, shafts, bearing surfaces, impellers, magma pump rotors, etc.



SPECIFICATIONS

ALLOY BASIS: Cu, Sn, P



TECHNICAL DATA

UTS : 24-30 kgf/mm²
Elongation : 20% (approx.)