

# LH 215

## ALUMINIUM BRONZE ELECTRODE

### PROPERTIES

Bronze electrode having 9-11% Al and balance copper. Excellent marine corrosion resistance. Stable arc and good welding characteristics. Weld bead is smooth. The weld metal combines high strength and good ductility.

### PROCEDURE

Clean the joint area. For smaller work-pieces preheating is not required. For others, preheat the whole job to around 400°C. For job thickness above 8 mm a 90°U groove should be made. Use dry electrode to avoid porosity. Chip the slag between passes.

### WELDING CURRENT

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

### TYPICAL APPLICATIONS

Joining and surfacing of aluminum bronze. For use in shipbuilding, apparatus construction, chemical, paper industries, repair welding of work-pieces of the same type (laminated or casing), joining of copper alloys to steel.



### SPECIFICATIONS

ALLOY BASIS: Cu, Al



### TECHNICAL DATA

UTS : 42-48 kgf/mm<sup>2</sup>  
Elongation : 13-15 RC