



Impeller

## High strength 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, dissimilar metals.

### Outstanding Features:

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

### Recommendation:

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

### Procedure:

Clean weld area. Remove damaged metal by chiseling. Bevel edges 90°. Preheat heavy sections to 100°-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)	I - Range	II - Range
3.15	80-120	80-100
4.00	110-150	90-120

**Hardness:** 75-85 HRb (3 layer)

**Tensile Strength:** 350 MPa (50, 000 psi)