

**Impeller**

## **Superior strength bronze electrode for welding of bronze, brass, carbon steel and 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.
- Dense, porosity-free deposits which are fully machinable and colour matching to bronze.
- Versatile product for steel, cast iron, bronze etc. in joining and overlaying applications.

### **Recommendation:**

A unique bronze alloy electrode offering exceptional weldability. The arc striking 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 150°C-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)	I - Range	II - Range
3.15	80 - 120	80 - 100
4.00	110 - 150	90 - 120

**Tensile Strength:** 37 Kg/mm<sup>2</sup>  
(52,000 psi)