

## SUPERBRONZE SPECIAL DC+

### Description:

Superbronze special is a pure copper electrode, both for joining and overlaying of all commercial grade copper parts. The deposits are dense, porosity free and crack free welds. The weld deposit has a good corrosion resistance and high electrical conductivity.

### Applications:

This electrode is suitable for joining and surfacing all commercially pure copper grades. It is used for the fabrication of copper parts for chemical industries, food processing industries and for high electrical conductivity joints.

### Procedure:

Grind / degrease the surface. Preheat heavy sections to 150° to 300° C using short arc at minimum amperage, deposit stringer beads. Peen deposits and air cool to room temperature.

TECHNICAL DATA	:	SUPERBRONZE SPECIAL DC+	
Size (mm)	:	3.15	4.0
Recommended Welding Current (Amps)	:	80 - 110	90 - 120
Tensile Strength	:	18 - 20 kgf / mm <sup>2</sup>	
% Elongation	:	30 %	
Hardness (As deposited)	:	50-60 HRB	
Tip Colour	:	Yellow	

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