

## SUPERBRONZE DC+

### Description:

Superior coated tough Lo-Temp bronze electrode for joining and overlaying on steels, cast irons, malleable irons, bronzes and copper based alloys and for dissimilar combinations. Smooth easy to use electrode, producing porosity free deposits having good slag detachability.

### Applications:

For overlaying and joining bronzes and similar non ferrous metals, steels to copper, cast iron, malleable iron or any combination of these to one another. Highly recommended for bearing surfaces and for wear facing against sea water corrosion.

### Procedure:

Gouge out/grind cracks. Thoroughly clean weld area, removing all oil, grease and rust. Due to high thermal conductivity of copper and copper alloys pre-heating is desirable in certain instances particularly where heavy sections are involved. Ensure electrodes are dry. Set lowest possible amperage. Use short arc and stringer bead technique. Remove slag thoroughly.

TECHNICAL DATA	:	SUPERBRONZE DC+	
Size (mm)	:	3.15	4.0
Recommended Welding Current (Amps)	:	75 - 120	110 -160
Tensile Strength	:	35 kgf / mm <sup>2</sup>	
Hardness			
(As deposited)	:	70 – 85 HRB	
(Work Hardened)	:	90 – 95 HRB	
Tip Colour	:	White.	

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