

SUPERBRONZE DC+

Superior coated tough Lo-Temp bronze electrode for joining and overlaying steels, cast irons, malleable irons, bronzes and copper based alloy and for dissimilar combination. 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 surface 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 preheating is desirable in certain instances particularly where heavy section are involved., ensure electrodes are dry. Set lowest possible amperage. Use short arc and stringer bead technique. Remove slag thoroughly.

<u>Technical Data</u>	:	DIFFUSALLOY 916L
Tensile Strength	:	45-50 kgf / mm ² (Min.)
Hardness	:	75-80 HRB(as deposited) 90-95 HRB(work hardened)
Elongation	:	30% (Min.)
Coating Color	:	Light Pink
Tip Colour	:	Yellow
Size (mm)	:	3.15 4.00
Recommended Welding Current (Amps)	:	80-110

DIFFUSION ENGINEERS LIMITED

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