

Xuper 1851 XHD

Welding Aluminum Bronzes And Dissimilar Metal Joining Of Copper Alloys To Steels And Cast Irons

DESCRIPTION

Xuper 1851 XHD is a copper-based filler rod for the joining and cladding of aluminum bronzes or dissimilar combinations of Aluminum-bronze to some steels and cast irons. Its special formulation inhibits inter-granular stress corrosion known to cause cracking in copper alloys and steels. As cladding it exhibits all the benefits of Al-bronze itself and a high deposition rate saves time and money in any application where it is used.

- Good crack and corrosion resistance
- Excellent comparative mechanical properties
- High deposition rates

APPLICATION :

- Aluminum Bronze Pump Housings
- Manganese Bronze Impellers
- Ship Propellers
- Turbine Runners
- Press Rams
- Joining Cast Iron to Steel
- Tin Plate Mill Rolls
- Hydraulic Pistons

PROCEDURE FOR USE

cracks or prior deposits should be removed by grinding or by using ExoTrod 4 to leave rounded edges.

Preparation: Remove all contaminants, particularly oil and grease. Lightly grind surfaces to remove superficial oxides.

Prepare cracks to have a 60-75° V-groove. A root opening of -8/1 in. is recommended. If necessary, preheat to remove moisture. Technique: Use either stringer or weave beads with the latter being preferred to minimize slag entrapment. Make sure to thoroughly deslag between passes.

Note: High frequency AC recommended for application thinner than 0.040 or where additional weld puddle cleaning is needed.

Note: Make sure that the inter-pass temperature does not exceed 300°F (148°C)

TECHNICAL DATA

Tensile Strength : 550 N/mm² (80,000 psi)

Yield strength : 255 N/mm² (37,000 psi)

Typical Hardness : 200 HB

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	90-160

Note: For optimum result use the lowest amperage practical