

Xuper 2800 XHD

Manual Metal Arc Electrode For Bronze Welding With Ac

DESCRIPTION

A unique bronze alloy electrode for joining and overlaying parts in bronze, and also for use on a wide variety of ferrous alloys.

This electrode is specially designed for welding with alternating current. Stable arc even using power sources with low open-circuit voltage. Regular metal transfer with a homogeneous deposit. Very good resistance to corrosion by salt water or steam. Thanks to its low friction coefficient, it is ideal for the overlay of surfaces subject to friction, e.g. plain journal bearings. The deposit is very smooth and is easily machinable.

- Excellent weldability and exceptional arc stability with AC
- Very good corrosion resistance to salt water or steam
- Very homogeneous deposit
- Good colour match to bronze
- Deposit easily machinable
- Low friction coefficient

APPLICATIONS

Pump casings, impellers, plain bearings, marine applications, joining of bronze to steel or cast iron.

PROCEDURE FOR USE

Preparation : Clean the surface to be welded. For joining applications, leave sufficient clearance for full penetration welds. For thicknesses greater than 5 mm, make an 80.°U» chamfer. For thicknesses greater than 10 mm make an «X» preparation.

Preheating: Not normally necessary for thin sections. A preheat of 200-250°C is recommended for copper-base alloys in general, and particularly for thick, heavy sections.

When overlaying steels, the preheat temperature depends upon the nature of the steel and the dimensions of the part to be welded. Maintain medium to short arc and keep electrode almost vertical. Deposit stringer beads or weave moderately.

Select the minimum current possible in order to avoid dilution, particularly when welding ferrous metals.

TECHNICAL DATA

Tensile strength: 300 N/mm² (43,000 psi)

Typical Hardness : 70-80 HRB

Work hardening : 85-95 HRB

Current polarity: DC (+)

DIAMETER	AMPERAGE
3.2mm	80-120
4.0mm	110-150
5.0mm	130-170

Note: For optimum result use the lowest amperage practical