

AMERIARC

Ameri Bronze DC

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.6 E CuAl-A2

DIN 1733: EL - CuAl9

DESCRIPTION & APPLICATION:

Ameri Bronze DC is the superior retile coated tough bronze electrode for joining and overlaying steels, bronze, brass & copper based metals. It is very high strength nickel manganese aluminum bronze electrode with excellent wear resistance.

High is recommended for joining & build up on copper parts requiring corrosion resistance & thermal and electrical conductivity and also joining and surfacing parts subject to service in marine environments and seawater.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

Fe	Si	Al	Pb	Cu
3.2	1.4	8	.02	Bal

Flux Color : Grey

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	89,000 PSI (614 MPa)
Yield Strength	59,000 PSI (407 MPa)
Elongation	23%
Hardness	Brinell 148

WELDING CURRENT & INSTRUCTIONS:

Recommended Current : DC Reverse (+)

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	90	105	135
Maximum Amperage	130	155	210

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
	Length (mm)	14" (350)	14" (350)	14" (350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0