

SHUBER E 380

AC/DC BRONZE ELECTRODE



DESCRIPTION

MOST VERSATILE BRONZE ELECTRODE FOR WELDING OF COPPER ALLOYS AND JOINING COPPER(BRONZE) TO FERROUS METALS INCLUDING STEEL AND CAST IRON. Deposits are seawater corrosion resistant making it ideally suited for welding non-ferrous pipings, pump housings and impellers. Applications also include overlay work on guides, bearing surfaces, worm screws and filling of casting defects.

SPECIAL FEATURES

- Smooth, spatter-free deposit & easily machinable.
- Superior weldability on either AC or DC.
- Excellent frictional wear resistance.
- Good colour match to bronze.

APPLICATION INSTRUCTIONS

Preheat heavy sections to 300°C (575°F) in order to obtain better fusion. Hold a short arc at the lowest amperage possible. Use stringer bead or slight weaving technique. For multi-pass build-up, reduce amperage setting as base metal temperature increases. Avoid working temperature range 400-600°C (760-1120°F) because of the risk of hot shortness. Upon cooling, slag can easily be removed by light chipping and brushing.

TECHNICAL DATA

TENSILE STRENGTH: 35 kg/mm² (50,000 psi)

HARDNESS: 95 HB

RECOMMENDED CURRENT:

AC or DC (Reverse Polarity)	DIAMETER	AMPS
	3.2 mm (1/8")	80 - 120
	4.0 mm (5/32")	100 - 150

Tip Colour: Blue

DIN 1733
S-Sn Bz6