

MINERALS TECHNOLOGY CORPORATION

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ELECTROBRAZE™

ARC DC

FOR JOINING OR OVERLAYING BRASS, BRONZE, COPPER, CAST IRON AND DISSIMILAR METALS

- WELDS COPPER
- EXCELLENT STRENGTH - 100,000 PSI
- EXCELLENT ELONGATION (43%)
- WEAR & SHOCK RESISTANT
- WELDS OVER BRAZED METALS
- EXCELLENT FOR CAST IRON
- LOW FRICTION SURFACE
- EASILY MACHINED
- WELDS DISSIMILAR METALS

GENERAL SPECIFICATIONS:

Electrobraze™ is a highly alloyed electrode containing aluminum, nickel, manganese & iron. It is designed to weld a wide variety of brass, bronze and copper to alloys either similar or dissimilar in nature. The spatter free deposit is exceptionally flat and non-porous even in applications where the base metal has been contaminated by grease, oil or chemicals. The flux coating allows for maximum conductivity, lowering the amperage required for exceptional penetration on high conductive copper alloys.

PROCEDURES:

Preheat copper to 700°F when copper content is over 90%. Preheat to remove "chill" on brass, bronze or cast iron depending upon ambient temperature. Apply thin layers using a short arc in either a wide weave or stringer. Lap overs of as much as 50% are possible when large scale heavy buildup is required. Deposits are smooth and free machining.

APPLICATIONS:

Electrobraze™ has been developed to weld brass, bronze and copper. It is effective on hard-to-weld iron bound aluminum bronze, silicon bronze, nickel and iron containing aluminum bronze, tin bronze and phosphor bronze. Electrobraze™ is also highly effective for "overwelding" a braze that has either worn or failed. It is especially effective in repairing previously brazed cast iron. Welds cutless bearings to carbon steel strut and propeller brass nut to stainless steel and shaft.

SOME USES ARE:

- PULP & PAPER MILL VALVES
- SHIP PROPELLORS
- TURBINES
- STIRRER BLADES
- CAST IRON
- GUIDES
- SUCTION ROLLS
- THRUST BEARINGS
- WORN SHAFTING
- LABYRINTH SEAL
- HYDRAULIC FLANGES
- IMPELLERS
- BUSS BARS
- FITTINGS
- MARINE CUTLESS BEARINGS

TECHNICAL DATA:

TENSILE STRENGTH100,000 PSI (2" BAR)
YIELD STRENGTH.....65,000 PSI
ELONGATION.....43%
HARDNESS.....31 (RC)
CURRENT.....DC (REVERSE POLARITY)
(ELECTRODE POSITIVE)

ELECTRODE SIZE	AMPS +/- 20%
3/32".....(2.5mm)	65
1/8".....(3.2mm)	100
5/32".....(4.0mm)	140

AVAILABLE IN HELIARC: ALLOY #400TIG

MADE IN USA