

Lastek 61 G

Smooth bronze layers on low current

CLASSIFICATION

DIN 1733 : EL – CUSn7

AWS A5.6 : E CuSn-C

GENERAL DESCRIPTION

Surfacing of bronze on steel, cast steel and cast iron.

Joining of copper and its alloys.

Easy to weld with a stable arc.

Good wear resistance for metal to metal friction.

APPLICATIONS

Repairs of bronze bells.

Machine repair: surfacing of bearing areas and shafts.

Joining of copper, bronze and brass plates, flanges, tubes.

Hardness: 100 - 120 HB

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Mn : < 0.40	Sn : 7.00 - 9.00	P : < 0.30	Cu : 91.00	
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MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 340 MPa	≥ 610 MPa	≥ 25%	

GENERAL INFORMATION

Welding positions All, except vertical down.

Shielding gas NA

Packing 5 kg in a plastic box

Polarity DC, reverse polarity (electrode positive)

Diameter (mm) 2.5 3.2 4.0

Length (mm) 350 350 350

Approx. current (A) 50 - 70 70 - 110 100 - 130

Tips & tricks

Surfacing:

Clean the parts well.

For the first layer start with a low amperage to minimize dilution.

Operate with a circular movement in order for the weld metal to cool down slowly.

Joining:

Use the maximum amperage.

For butt welds: root gap sufficiently wide to avoid convex beads.

Preheat temperature: Tin bronze: 150-200 °C (300-400 °F), Brass: 200-300 °C (400-570 °F).

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.