

CARVER 9201

FEATURES

CARVER 9201 gives fully machinable welds on Cu & Cu alloys. Weld metal is free from porosity and cracks. The bead is smooth and uniform. Arc force is strong, but controllable. Excellent colour match on Bronze. Weld deposit has very good resistance to salt water and steam corrosion.

APPLICATIONS

Welding and surfacing of copper, brass and bronze. Joining copper and bronze to cast iron and steel. Filling cavities in copper alloy castings. Overlays on pumps, shafts and bearing surfaces. Impellers, marine components and pump casings.

PROCEDURE

Prepare a large 'V' approx. 80-90°. For workpiece above 8 mm thick, preheat upto 300° C. Bronze castings to be cooled slowly.

TECHNICAL DATA

Alloy Type	:	Cu, Sn, P alloy
Tensile Strength	:	230-280 N/mm ²
Elongation	:	18-20 %
Hardness	:	Rockwell B 70-90

RECOMMENDED CURRENT RANGE

SIZE (mm)	3.15	4.00
AMPS	80-100	110-130

TIN BRONZE ELECTRODE