



NEXA-214

SPECIAL ELECTRODE FOR NON- FERROUS

ALLOY BASE : Cu, Sn, P.

SPECIAL FEATURES

- The weld metal is free from porosity and cracks.
- The bead is smooth and uniform.
- Excellent colour match on broze.

RECOMMENDATIONS

An electrode with exceptional weldability for joining and overlaying of steels & cast irons. Preheat thick sections up to 300^oc. suitable for AC power source.

APPLICATIONS

Welding and surfacing of copper, brass and bronze. Joining copper and bronze to cast iron overlays and steel. Filling cavities in copper alloy casting. Overlays on pumps, shafts and bearing surfaces. Building up missing section.

PROCEDURES

Prepare a large V approx. 80-90^oC. for work piece above 8 mm thick preheat upto 300^oC. bronze casting should be cooled slowly.

TECHNICAL DATA

Tensile Strength : 24-28 kgf / mm²
Hardness : 70-85 BHN

CURRENT RANGE : DC (+)

SIZE mm	3.15	4.00
CURRENT (Amps)	80-110	110-140