



NEXA-2800

SPECIAL ELECTRODE FOR NON-FERROUS

ALLOY BASE : Cu, Sn, P

SPECIAL FEATURES

- A thin coated electrode intended for welding of copper and copper tin-alloys.
- Best suited for joining copper or bronze to steels.
- Can also use for welding of cast irons without preheat if machinability is not required.
- Suited for cladding also.

RECOMMENDATIONS

While welding copper or bronze work piece should be preheated to approx.300°C. But in no case the working temperature should reach 400°C or above as this will result in hot shortness. When welding large jobs maintain the interposes temperature of 300°C.

APPLICATIONS

Brushes valve seat ship propellers, malleable iron, Brass parts, bearing, and impellers blades galvanized iron.

PROCEDURES

Clean and grind the weld surface, for heavy section preheats is needed upto 250°C. Use short arc at low current with deposit stringer beads.

TECHNICAL DATA

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

CURRENT RANGE (AC/DC+)

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