

Lastek 512

Bronze welding

CLASSIFICATION

EN ISO 24373 : Cu 5410 (CuSn12P)

GENERAL DESCRIPTION

Filler rod for TIG and oxy-acetylene welding of bronze (bell foundries, bronze statues).

Suitable for joining and surfacing.

Porous free joints with a deep yellow, golden colour.

The weld pool is easy to control and permits welding in position and applying different layers on top of each other.

Resistant against seawater, caustic sulphite (paper and sugarfabrication) and many chemicals.

APPLICATIONS

Repair and joining bronze sculptures, bronze bells, castings with 10-12% tin, bronze 'RG5', building up cast iron with a corrosion resistant layer.

Refacing bearings.

Hardness: 120 HB

Electrical resistivity: 0.2 ohm.mm²/m (7.8 .10⁻⁶ ohms/in/in²)

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

Sn : 12.00 - 13.00	P : 0.15 - 0.25	Others : < 0.05	Cu : Balance	
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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)
	≥ 350 MPa	≥ 15%	

GENERAL INFORMATION

Welding positions NA

Shielding gas Argon

Packing 5 kg in a cardboard box

Polarity DC, with the torch on the negative pole.

Diameter (mm) 2.0 2.5 3.0

Lenght (mm) 1000 1000 1000

Tips & tricks

TIG welding under pure Argon protection (min 10 l/min).

Workpiece thickness > 6 mm (0.24"): preheating up to +- 250 °C (480 °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.