

Lastek 52

Sheet metal and cast brass parts

CLASSIFICATION

EN 1044 : Cu 303

AWS A5.8 : RB CuZn-A

GENERAL DESCRIPTION

Rod for oxy-acetylene welding or tig welding of brass and bronze and for brazing of steel, cast iron and copper.

Low heat input minimizes distortion.

Brazing sheet metal with Lastek 52 is very easy and the beads are smooth and have a good appearance.

APPLICATIONS

Car bodies, pipes, sheet metal.

Brass and bronze art work and furniture.

Parts for refrigeration and heating equipment.

Repairs on cast iron.

Soldering of cast iron, steel and red copper applications.

Hardness: 110 HB

Bonding temperature: 820 °C

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

Mn : 0.05 - 0.20	Si : 0.10 - 0.15	Cu : 59.50 - 60.50	Sn : 0.10 - 0.20	Zn : 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	≥ 20%	

GENERAL INFORMATION

Welding positions All

Shielding gas For tig: Argon

Packing 5 kg in a cardboard box

Polarity For tig welding use DC, with the torch on the negative pole.

Diameter (mm)	2.0	3.0	4.0	5.0	6.0
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Lenght (mm)	500	500	1000	1000	1000
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Tips & tricks

Remove paint, oil, and other impurities.

Chamfer edges and angles. Preheat slightly.

Heat steel plate locally until dark red.

Use a slightly oxidizing flame on brass and a neutral flame on steel. Hold inner cone of the flame about 1 cm from work piece, avoid overheating.

Melt the rod by rubbing along the joint.

No finishing required.

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.