PRODUCT SPECIFICATION

Lastek 64 C

TIG welding of aluminium-bronze

CLASSIFICATION

EN ISO 24373 : CuAl8Ni2Fe2Mn
DIN 1733T1 : S-CuAl8Ni2

GENERAL DESCRIPTION

TIG rod for joining and refacing workpieces in Ni containing aluminium-bronze.
Joining copper alloys to steel and cast iron.
Good wear resistance.
Good resistance against corrosion by seawater and many acids.

APPLICATIONS

Alu-bronze and steel.
Propellers, machine parts, shafts, hydraulic turbines, pump housing, refacing steel bearings.
Joining Wn° 2.0916, 2.0920, 2.0928, 2.0932, 2.0936, 2.0940, 2.0960, 2.0962, 2.0966, 2.0970, 2.0978, 2.0980.

Hardness: 150 - 180 HB
Bonding temperature: 1.000 °C

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

Mn : 2.00	**Fe :** 2.00	**Ni :** 2.00	**Al :** 8.00	**Cu :** Balance

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 530 MPa	≥ 30%	

GENERAL INFORMATION

Welding positions	NA			
Shielding gas	Argon (or Argon/Helium mixed gas)			
Packing	5 kg in a cardboard box			
Polarity	AC			
Diameter (mm)	1.6	2.4	3	3.2
Lenght (mm)	1000	1000	1000	1000

Tips & tricks

Use AC on Alu-bronze and (if necessary) the flux Lastek 64CA to break through the aluminium oxide layer and to weld on a lower amperage.
Maximum preheating temperature for aluminium-bronze (≤12 % Al): 160 °C (320 °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.