

# Lastifil 64

## Seawater resistant bronze wire

### CLASSIFICATION

EN ISO 24373 : Cu 6327 (CuAl8Ni2Fe2Mn2)

DIN 1733T1 : SG CUA18Ni2

### GENERAL DESCRIPTION

Ni alloyed aluminium bronze wire with a very high resistance against corrosion and erosion by seawater.  
 Refacing of propellers of aluminium bronze (with Ni and/or Mn) without danger for desaluminification in warm seawater.  
 Refacing and joining copper alloys, steel and cast iron (metal to metal wear).  
 Applicable to working temperatures up to 250°C (480°F).  
 Porousfree.

### APPLICATIONS

Refacing shippropellers, pumphousings, augers, shafts in pumps and machinery, valves, driving wheels and gliding contacts in different industries.

Repair of casting flaws in (nickel) aluminium bronze pieces.

Joining of plates and pipes in chemical and food-industry.

Joining bronze to steel.

Welding of bronze with 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: 140 - 190 HB

Electrical resistivity: 0.2 ohm.mm<sup>2</sup>/m (1.10-5 ohm/in/in<sup>2</sup>)

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

<b>Ni</b> : 1.90 - 3.00	<b>Mn</b> : 0.50 - 2.50	<b>Fe</b> : 1.00 - 2.50	<b>Al</b> : 7.70 - 10.00	<b>Cu</b> : Balance
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### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 290 MPa	≥ 530 MPa	≥ 30%	

### GENERAL INFORMATION

#### Welding positions

<b>Shielding gas</b>	Argon or Argon-Helium mix		
<b>Packing</b>	15 kg spool (in a cardboard box)		
<b>Polarity</b>	NA		
<b>Diameter (mm)</b>	0.8	1.0	1.2

#### Tips & tricks

Helium generates a hotter pool what makes it easier to reface large bronze pieces or steel without porosity.  
 To join bronze to steel: "butter" the steel with Lastifil 64 (on an amperage as low as possible or with a pulsed arc, and make than the joint with the bronze piece (preheat 150 to 200 °C (300 - 390 °F)).