

ROYAL 2214 AC / DC TIN-BRONZE ELECTRODE

Allow Basis :-

Cu, Sn, P

Technical Data :-

UTS of Joint: 240-280 N/mm²

Elongation : 20 %

Hardness of Pure Deposit : 70 - 85 Brinell

Application :-

Welding and surfacing of Copper, Brass and Bronze. Joining copper and Bronze to cast iron overlays and steel. Filling cavities in copper alloy castings. Over-lays on pumps, shafts and bearing sur-faces. Building up missing sections.

Propertise :-

The weld metal is free from porosity and cracks. The bead is smooth and uniform excellent colour match on bronze.

LOW HEAT INPUT ELECTRODE

WELDING CURRENT: AC / DC(+) :-

| SIZE (MM) | 3.15 | 4.00 |
|----------------------|----------|-----------|
| Current Range (Amps) | 80 – 110 | 110 - 140 |

PACKING SPECIFICATIONS :-

| SIZE (mm) | KG PER PACKET | KG PER BOX |
|-------------|---------------|------------|
| 3.15 X 350 | 2 Kg | 10 Kg |
| 4.00 X 350 | 2 Kg | 10 Kg |