


536 DC+

COPPER ALLOY

DESCRIPTION

Special formula aluminum-bronze alloy electrode containing manganese and nickel for building up and welding copper alloys and a wide range of ferrous metals (steels, cast irons, stainless steels) to copper alloys.

CHARACTERISTICS

- **Excellent for parts subjected to compressive stress and wear**
- Excellent for welding a wide variety of copper alloys
- Excellent weldability out of position
- Very good corrosion resistance
- Very low friction coefficient
- Stable arc and low spatter

TYPICAL APPLICATIONS

Ideal for dissimilar assemblies, aluminum-bronze with high manganese content. Boat propellers, turbines, pumps, couplings, gear teeth, punches, dies, rolls, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Gouge the base metal over 3/16" (5 mm) thick. **Preheat the copper and copper alloys between 400 - 600 °C (752 -1112 °F), as applicable.** Maintain a short arc with a slight weaving motion. Cool before removing slag between passes.

MECHANICAL PROPERTIES

Tensile strength: 100 000 psi (689 MPa)
 Yield strength: 55 000 psi (380 MPa)
 Elongation: 26 – 28 %
 Hardness (as-welded): 185 BH

WELDING PARAMETERS

Diameter: 3.2 mm (1/8") (Other diameters available upon request)
 Amperage: 90 – 130 A

TIG rods also available: **Soudotec T536** and MIG solid wire: **Soudotec M8536**

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Specialized welding alloys and technology. For technical assistance or for ordering :