

SME B14 AC/DC

SPECIAL BRONZE ELECTRODE FOR WELDING BRONZE, BRASS, CAST IRON AND CARBON STEEL

Alloy Basis

Cu, Sn, P

Characteristics :

This electrode provides exceptional weldability enabling the deposition of dense, porosity-free welds on materials such as steel, cast iron, bronze etc. and ideal for both joining and overlay applications. The weld deposits are fully machinable and exhibit a color match to bronze. Additionally, the deposit is highly resistant to saltwater and steam corrosion and boasts a very low coefficient of friction.

Typical Applications

Perfect for super conditioning of pump impellers, valves, wear rings, gear teeth, sleeves, packing glands, and dissimilar metal joining applications. Ideal for welding and surfacing of copper, brass, and bronze. It is also highly recommended for marine components.

Mechanical Properties

Tensile Strength : 35 Kg/mm²

Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00
Current (amps)	50 - 80	80 - 110	110 - 150

Availability:

Standard Size: 4.0, 3.15, 2.5 in 350 mm length

Packing: 2 kg.

Note to Usage.

Clean the area to be welded. Deposit thin stringer beads using the shortest possible arc at the minimum amperage. For heavier work pieces, preheat to a temperature range of 150°C to 200°C .

