

# SME B14 DC

## SPECIAL TIN-BRONZE ELECTRODE FOR WELDING BRONZE PARTS



### Alloy Basis

Cu, Sn, P

### Characteristics :

SME B14DC features a smooth & uniform bead with weld metal free from porosity & cracks and an excellent color match to bronze.

### Typical Applications

These electrodes are commonly used for welding and surfacing copper, brass and bronze. They are also ideal for building up missing sections, filling cavities in copper alloy castings and applying overlays on pumps, shafts, bearing surfaces, impellers, magma pump rotors and more.

### Mechanical Properties

Tensile Strength : 35 Kg/mm<sup>2</sup>

### Welding Current : 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.