TECHNICAL DATA SHEET

Starweld 462 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 in position
- Very good corrosion resistance
- Very low coefficient of friction
- Stable arc and low spatter

Mechanical properties :

- Polarity DC +
- Tensile strength : 100 000 psi (689 MPa)
- Elongation : 26 – 28 %
- Hardness : 130 BH

Procedure :

Remove any trace of oil, grease and dirt from the surface. Gouge the base metal over 3/16'' (5 mm) thick using the Starweld 512B. Preheat the copper and copper alloys between 400 - 600 ºC (752 -1112 ºF), as applicable. Maintain a short arc with a slight weaving motion. Cool before removing slag between passes.

+	**Diameter**	**3.2 mm**
+	**Amperage**	**125 A**

Applications :

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

1 800 361 9097

Starweld