

CORBRONZE 204-G

CLASSIFICATION

DIN 8555: MSG 31-GF-200-C

EN 14700: T Cu1

DESCRIPTION

- Special cored wire for GMAW
- The weld metal is a Cu - Al bronze
- Sound, pore free deposits on ferrous and non-ferrous base materials
- The deposit has little tendency to cracking
- Good corrosion resistance.

APPLICATIONS

Building up of aluminium bronze

This alloy is particularly noted for its self-lubricating qualities in applications involving metal-to-metal rubbing under heavy loads.

Examples

Gear teeth, pump shafts, stripper columns etc.

TYPICAL ALL-WELD METAL ANALYSIS

Al	Fe	Cu
9.00	4.00	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 210 HB

SHIELDING GAS

ISO 14175: I1 (pure argon)

I3 (Ar + 30% He)

OPERATING CONDITIONS

Current type	Gas flow rate	Recovery
DC(+) continuous or pulsed	12 - 20 l/min.	90 %
Diameter [mm]	Intensity [A]	Stick-out [mm]

Voltage [V]

	Range	Pulsed	Continuous	Range	Optimum
1.2	150 - 320	22 - 25	27 - 31	10 - 20	15
1.6	200 - 350	22 - 25	27 - 31	10 - 20	15

Stringer or weaved beads.

Can be welded gun leading or gun trailing.

The use of pulsed current is recommended for improved wetting and bead appearance.

Higher currents and voltages can be used, but cause increased element burn-off (particularly Al) and dilution, leading to lower hardness levels.

WELDING POSITIONS

EN ISO 6947 : PA, PB

ASME IX: 1G, 1F, 2F

PACKAGING

Diameter	1.2 mm		1.6 mm
Spool type	EN ISO 544: BS300	EN ISO 544: BS300	EN ISO 544: B450
Weight	15 kg	15 kg	25 kg