

# CORBRONZE 304-G

## CLASSIFICATION

DIN 8555: MSG 31-GF-300-C

EN 14700: T Cu1

## DESCRIPTION

- Special cored wire for GMAW
- The weld metal is a Cu - Al bronze, corrosion resistant up to 300°C
- Good resistance to metal-to-metal wear

## APPLICATIONS

Building up of aluminium bronze

Cladding components undergoing metal to metal wear under heavy loads

Suited for marine environments

## Examples

Friction plates, bearings, sliders, high speed bearings etc

## TYPICAL ALL-WELD METAL ANALYSIS

Al	Fe	Cu
11.50	4.00	Bal.

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel: 320 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]	Voltage [V]		Stick-out [mm]
	Range	Pulsed	Continuous	Range Optimum

Diameter [mm]	Intensity [A]		Voltage [V]		Stick-out [mm]	
	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. Use of preheat and working temperatures up to 300°C will help forestall cracking.

#### 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