

GOLD 620-E (CU 116)

COPPER ALLOY

Description and Applications:

Maintenance electrode with a **complex Cu-bronze** deposit for joining and surfacing of copper-alloys, steel and cast iron also for dissimilar joints between copper alloys and steels.

The deposit is corrosion, seawater and cavitations resistant with a **low coefficient of friction**.

Used in ship building, for pumps, impellers, propellers, screws, for surfacing of shafts, bearings, hydraulic piston heads, cable guides and machinery parts, automotive forming dies etc.

Excellent for protection of parts against metal metal wear.

As a overlay for deep drawing of mild steel, stainless steel, aluminium and Titanium.

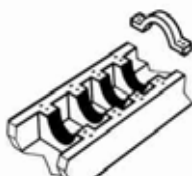
Hardness ~ 200 H, Weld metal contains. Cu, Mn, Ni, Al



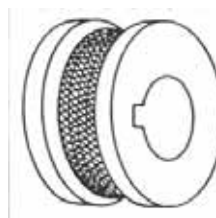
Pump rotor protection



Rebuild worn piston heads



Bearing surfaces



Cable guide rollers



Shaft overlays

Mechanical properties

Up to :

Rm (MPa)	Rp0,2 (MPa)	A5 (%)
660	420	22

Packaging

Data

Sizes	2.5x350	3.2x350	4.0x350
Kgs/Packet	4,5	4,5	4,5
Packets/carton	4	4	4
Kgs/carton	18	18	18

Welding instructions	Current (A)	75	100	130
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Welding positions



1G/PA



2F/PB



2G/PC

= +

Clean area to be over laid. When surfacing iron based metals undercut (machine) area by 4-6mm under-size. Preheat according to base metal. Select recommended amperage and use DC reverse polarity. Deposit electrode with stringer beads and use short arc, avoid excessive weaving. Ensure that each weld overlaps the previous weld. Remove slag from each weld bead before applying next bead. Deposit a minimum of two layer for best results.