

# 24

## PHOSPHOR BRONZE WELDING ROD TO JOIN AND TO CLAD COPPER ALLOYS, CARBON STEEL, STEEL ALLOYS , NICKEL AND NICKEL ALLOYS.

CLASSIFICATION A.W.S: ECuSn-C

**APPLICATIONS:** It is widely recommended to recondition bearings and to cover surfaces for heavy duty operations because it is corrosion and wear resistant. It is essential for maintenance work on shaft ends, pump pistons, taper end housings, clutch forks, rails, cylinder blocks, gearbox oil sumps, foundry moulds, paper industry rollers, milling tool tips, gears and also for maintenance of parts submitted to sea water corrosion. It has been successfully used to weld and to clad propellers and shaftlines in ships, impellers, pump casings, to recondition bearing pedestals, etc.

**CHARACTERISTICS AND PROCEDURE:** Phosphor bronze alloy with tin content. Filler metal is wear, friction and corrosion resistant. Arc is stable and mild with no splattering. It is recommended for horizontal and vertical welds—including welding upwards. When used to clad a part, the arc should be set to medium. Weld seams can be weaved or straight. Weaved weld seams have proved to be efficient for minimal penetration and little base metal dilution as well as to achieve fast covering of large areas when ferrous metals are welded strongly together. Vilchis 24 can only be used with DC and reverse polarity.

<b>TENSILE RESISTANCE:</b>	5,000 Kg/cm <sup>2</sup> (71,100 PSI)
<b>HARDNESS:</b>	22° RC
<b>ELONGATION:</b>	20%
<b>CURRENT:</b>	DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %			AVAILABLE SIZES	AMPERAGE
<b>Cu</b>	<b>Sn</b>	<b>P</b>	3.25 mm - 1/8"	100-160
Resto	7.20	0.27	4.0 mm - 5/32"	140-180
			5.0 mm - 3/16"	160-250