

LoTherme - 533

Tin-bronze electrodes with 6% tin for welding with AC machines.

Characteristics :

LoTherme-533 is distinguished by good welding properties. With steady arc and low spatter losses it gives dense, pore-less seams. The slag is easily removed.

Applications:

LoTherme-533 for joining copper and copper alloys, phosphorus and tin-bronzes as well as copper-clad plates in mechanical and plant engineering and ship building. For surfacing on copper and copper alloys, phosphorus and tin-bronzes.

Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH	:	32 Kgf/mm ²
ELONGATION (L=4d)	:	30 %

Welding Instructions:

Seam preparation with large V angle (80-90°). Electrode guided vertical, arc 3-4 mm. Only work-pieces more than 5 mm need preheating up to 100 - 250°C. Bronze castings must be cooled slowly. Electrodes that have got damp must be dried 2 to 3 hours at 150°C.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-200	120-160	80-120	60-90