



Weltrode WC 3200 AC-DC

AC - DC Tin Bronze Electrode For Joining, Overlaying And Building Up Of All Copper Alloys

Why Do Welders Choose Weltrode WC 3200 AC/DC

Weltrode WC 3200 is highly versatile, smooth running, easy-to-handle bronze alloy electrode for both ferrous and non-ferrous applications. Ideal for a wide variety of uses including filling in defects on brass and bronze, joining copper alloys to ferrous metal, including cast irons, for salt water corrosion resistance.

Special Features

- ✦ A multipurpose electrode for joining copper base alloys not only to itself but also to steels and cast iron.
- ✦ Excellent wear resistance makes it suitable for overlaying .
- ✦ Extremely resistant to under bead cracking
- ✦ Extremely useful for build up required on forming dies and draw dies.

Applications

Cams, Pumps, Values, Pulleys, Pistons, Housings, Impellers Bushings, Axle Stops, Propellers, Mixer Arms, Feed Screws, Shaft and Sheaves, Bearing Surfaces, Conveyor Guides, Crosshead Slides Drive Sprockets etc.



Typical Properties

Tensile Strength	60,000 Psi
Hardness	Brinell 105
Yield Strength	30,000 Psi
Elongation	20%

International Specification

AWS/ASME IIC SFA 5.6 E CuSn - C

DIN 8555 E30-UM-100-CNR

DIN 1733 EL-CuSn8

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	45	70	95
Maximum Amperage	85	125	150

Welding Techniques

Clean weld area. Preheat is not necessary except for heavy or complex sections which should be preheated to 400F (200C). A close to medium arc should be maintained. Use a slight weaving technique or a stringer bead. Upon cooling, slag can easily be removed by light chipping and brushing. For multi-pass work, it might be necessary to reduce amperage setting as base metal increases in temperature.