

# ARCTEC® 606 BRONZE



a quality welding alloy

## GENERAL CHARACTERISTICS:

ARCTEC® 606 BRONZE is a wear resistant, machinable aluminum bronze electrode containing manganese and nickel. The weld deposit has work hardening capabilities and a low coefficient of friction, that makes it suitable for bearing surfaces. The weld metal offers an optimum combination of strength, toughness, non-porosity and resistance to: cracking, corrosion, erosion and cavitation. This high alloy bronze can be used for joint-welding and surfacing on copper, brass, aluminum bronze and steel.

## APPLICATIONS:

The ARCTEC® 606 electrode is used for joining, surfacing and repair work in the chemical, oil, electrical, pulp and paper, tool making, and machine building industry. Used on ship propellers, turbines, rotors, valves, thrust bearing shoes, stripper blades, guides, suction rolls, steam fittings, pump housings, roller bearings, gear teeth and hydraulic equipment control parts.

## WELDING PROCEDURE:

Clean the weld free of all foreign matter by grinding if necessary. Thin components can be welded together without joint preparation provided that a sufficient joint gap is maintained. Bevel sections 1/8" (3.25mm) or heavier to 90° included angle. Preheating is only necessary in the case of heavy copper components. Maintain a short arc and hold electrode vertical to the workpiece. Provide adequate ventilation when welding in confined spaces.

## MECHANICAL PROPERTIES:

Hardness	Tensile Strength	Elongation
200 HB approx.	95,000-100,000psi (655-689 MPa)	15-20% - 2"

## OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse

### Recommended Amperage:

Diameter	2.5mm 3/32"	3.25mm 1/8"	4.00mm 5/32"	5.00mm 3/16"
Amperage	50-75	60-100	80-130	110-160

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