

ARCTEC® 610 Al-Bronze

Conforms to: AWS A5.7/ASME SFA6.7 ERCuAl-A1



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® 610 Al-Bronze is an all position aluminum bronze welding wire for use with the GMAW welding process.

APPLICATIONS:

ARCTEC® 610 Al-Bronze is used for overlays on shafts, propellers, housings, bushings, valve seats, pumps and other surfaces requiring a bronze wear surface.

MECHANICAL PROPERTIES: (Typical)

Shielding Gas Argon	Tensile Strength 68000 psi 468 Mpa	Yield Strength 28000 psi 193 Mpa	Elongation 47%-2"	Hardness 125 HB	Melting Point 1945 ⁰ F / 1046 ⁰ C
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CHEMICAL COMPOSITION: (Undiluted)

Fe 1.50 max	Al 6.0-8.5	Si .10 max	Pb .02 max.	Zn .10 max	Cu Balance	Mn .50 max.	Others .50 max.
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OPERATING PARAMETERS:

WELDING PROCESS: GMAW

POLARITY: DC Reverse

TRANSFER TYPE: Spray Transfer

Operating Range					
Diameter	Gas	Flow Rate	Wire Feed Speed	Amps	Volts
.030"	Argon	25 CFH	340-450 IPM	90-180	25-26
.035"	Argon	30 CFH	280-400 IPM	150-250	26-27
.045"	Argon	30 CFH	200-300 IPM	130-240	27-28
1/16"	Argon	40 CFH	150-210 IPM	180-400	28-30

STANDARD SIZE AND PACKAGING:

Size	12" spools
.030" .80mm	13.6 kg
.035" .90mm	13.6 Kg
.045" 1.2mm	13.6 Kg
1/16" 1.6mm	13.6 Kg

CALGARY FAX:(403)-250-7682 EDMONTON: (780)-484-4896 VANCOUVER: (604)-596-2940 WINNIPEG: (204)-663-7955

PHONE:(403)-250-9355

(780)-484-3304

(604)-596-6207

(204)-663-9182

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