

ARCTEC® 618 Al-Bronze

Conforms to: AWS A5.7/ASME SFA6.7 ERcAl-A2



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® 618 AL-BRONZE is an all position aluminum bronze welding wire for use with the GMAW welding process.

APPLICATIONS:

ARCTEC® 618 AL-BRONZE is used to weld base metals of steels and cast iron to copper, brass and bronze. Ideally suited for overlays on shafts, propellers, housings, bushings, valve seats, pumps and other surfaces requiring a bronze wear surface.

MECHANICAL PROPERTIES: (Typical)

Shielding Gas Argon or 75% Argon/25% Helium	Tensile Strength 79000 psi 544 Mpa	Yield Strength 35000 psi 241 Mpa	Elongation 28%-2"	Hardness 140 HB	Melting Point 1915 ⁰ F / 1046 ⁰ C
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CHEMICAL COMPOSITION: (Undiluted)

Fe	Al	Si	Pb	Zn	Cu	Others
1.50 max	8.0-11.0	.10 max	.02 max.	.02 max	Balance	.50 max.

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

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