

Lastek 508

TIG welding of brass and bronze

CLASSIFICATION

DIN 1733 : E-CuSn-C

AWS A5.6 : S-CuSn6

GENERAL DESCRIPTION

Filler rod for TIG and oxy-acetylene welding of copper alloys like brass and bronze and for welding of steel.

Lastek 508 can be used for joining and surfacing.

Excellent fluidity and porous free welds, sound and smooth deposit.

No flux needed with oxy-acetylene welding of steel.

After welding no further treatment is required before finish is applied (painting, plating ...).

Good colour match with brass (if small joints).

APPLICATIONS

Applying wear and corrosion resistant layers on copper alloys and steel and joining copper, bronze alloys and mild steel.

Resistant to atmospheric influences, sulphite liquor (in paper and sugar production), seawater, vinegar, condensing water, lactic acid, etc.

The deposit has a low coefficient of friction.

Used for flaw repair in castings, cosmetic repairs and machining errors in bronze work pieces (be careful with phosphor bronze containing lead - can cause porosity and cracks).

Recommended for applications in the food industry.

Hardness: 95 - 120 HB // Bonding temperature 900 °C

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Sn : 8.00	P : < 0.10	Cu : Balance		
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MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)		
	≥ 370 MPa	≥ 20%			

GENERAL INFORMATION

Welding positions NA

Shielding gas Argon

Packing 5 kg in a cardboard box

Polarity DC, with the torch on the negative pole.

Diameter (mm)	1.0	2.0	2.4	3.2	4.0	5.0
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Lenght (mm)	1000	1000	1000	1000	1000	1000
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Tips & tricks

Clean the base material thoroughly around the joint.

Use short stringer beads and fast welding.

Oxy-acetylene welding: good wetting without using a flux.

Can be cold peened after welding, in order to diminish tensions.