

HABCO CA 666

A PREMIUM UNIVERSAL BRONZE ELECTRODE FOR JOINING AND SURFACING

FEATURES

HABCO CA 666 is a premium bronze electrode containing aluminum, nickel and manganese. This unique formula with a special coating makes this electrode outstanding for a wide range of applications.

APPLICATIONS

Use for repair and surfacing of high manganese steel, nickel, and iron containing aluminum bronzes, tin (phosphor bronze), brass, copper and steel. Use for cast iron surfacing when the first layer is applied with **HABCO CX 886S**. Use on ship propellers, thrust bearings, turbines, valves, stirrer blades, suction rolls and hydraulic equipment parts. Used for fabricating fittings, instruments and pumps for the chemical and paper industries. This electrode is often used to join dissimilar metals.

INSTRUCTIONS

A pre-heat of 570°F (330°C) is necessary for copper base alloys. Other materials should not be preheated. A short arc length should be maintained. Use stringer beads or weave beads to apply thin layers. Slag must be removed between passes. Part should be allowed to cool slowly.

Tensile Strength: up to 100,000 Psi (71 kg/mm²)

Yield Strength: up to 63,000 Psi (44 kg/mm²)

Elongation: approx. 20%

Hardness (HB): 200

Corrosion Resistance: Very Good

Current: DC +

Amperage:	90-125	120-150	135-200
Diameters: (in)	1/8	5/32	3/16
(mm)	3.25	4.0	5.0

- Available in (GTAW) TIG and (GMAW) MIG form