

# HABCO CA 660/ HABCO CA 661 DC

## PHOSPHOR (TIN) BRONZE ELECTRODES FOR APPLICATIONS SUBJECTED TO FRICTIONAL WEAR

### FEATURES

Both AC and DC electrodes produce a smooth stable arc that deposits dense porosity free welds in all positions with a minimum of spatter. Welds color match bronze. Slag is easily removed.

### APPLICATIONS

Due to the addition of nickel in the **HABCO CA 661**, the weld deposits are hard and resistant to frictional wear. Both electrodes can be used for joining and cladding of bronzes, brasses, steel, cast steel and cast iron. This alloy offers good resistance to sea water, and other corrosive environments. Common applications include repair and surfacing of gears, bearings, pumps, impellers, valve bodies and turbines.

### INSTRUCTIONS

Clean and prepare weld zone in accordance with standard welding practice. Preheat thick sections to 400°F. Maintain a medium arc length. Allow weld to cool before peening.

**Tensile Strength: up to 60,000 Psi (42 kg/mm<sup>2</sup>)**

**Yield Strength: up to 35,000 Psi (25 kg/mm<sup>2</sup>)**

**Elongation: up to 40%**

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

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