

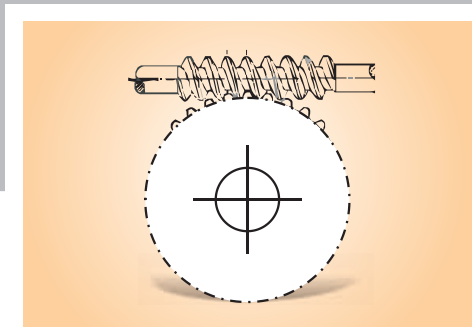
ESSEN® 23 S GAS

AC/ DC +

Copper, Brass, Bronze For effective surface treatment

**AWS A 5.8 - 81 RB CuZn - D; ASME SFA 5.8
A 93 RB CuZn - D**

**A Flame - machinable Electrode for Tough Built-Up
on Brass, Bronze, Steels and Cast Irons for
Outstanding Frictional Wear Resistance.**



PROPERTIES

Phosphor Bronze Electrode for depositing tough deposits on missing sections of gears made of Brass, Bronze, Steel or Cast Iron. The deposits are flame machinable i.e. the right profile can be shaped by means of the torch flame. Deposits can be filed and become hard when put in to service. Remelting temperature is high and hence multiple buildup possible. Bonding temperature is 8500 C.

MECHANICAL PROPERTIES

Tensile strength : 82 Kg / mm² , Elongation : 25% HARDNESS180 BHN as deposited, Work hardens to 22-28 Rc

APPLICATIONS

For buildup of gears splines, sprockets, shafts, bearing seats, pump impeller, propellers etc.

WELDING PROCEDURE

Clean the surface of the part to be repaired. Grind the surface if necessary, preheat up to 3500 C. to 4500 C. Melt off a drop of the flux. When the flux flows freely, deposit a drop of alloy, playing the flame on it until it flows out and bonds. Deposit layer by layer. Deposit profile can be maintained as per requirement.

RECOMMENDED AMPERAGE	
Size	Current
3.15mmx 350mm	060 - 125 Amps
4.00 mm x450 mm	095 - 160 Amps

PACKING	
3.25 mm x 450 mm 5 kg	30 pcs/kg (Approx.)
4.00 mm x 350 mm 5kg	17 pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

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ESSEN WELDING ALLOYS PVT. LTD. PUNE, INDIA,
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