

Coated Electrode for Copper and its Alloys

General Description

Kobatek 725 is a tin-bronze electrode for coating and repairing parts made of copper, bronze, red brass and for joining of these to steels, cast iron, nickel and nickel alloys. Possible to work on very large bronze parts without preheating.

Excellent resistance to metal-metal friction and good resistance to corrosion, particularly attack by acetone and dry ammoniac, industrial atmospheres and salty air, sea water and acids. It gives dense, porosity and spatter free, fully machinable deposits.

Compatibility	██████████
Corrosion	██████████
Machinability	██████████

Mechanical Properties, All Weld Metal

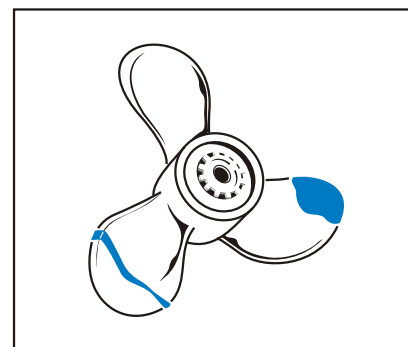
Tensile Strength : 30 - 36 kg/mm²
 Elongation (L=5d) : 15 - 25 %
 Hardness : 100 - 140 HB

Approvals

GOST

Typical Applications

- Electrode holders
- Bearings
- Rotors
- Screws
- Valve seats
- Pump rotors
- Spindles
- Gears
- Spirals
- Pistons
- Repairing defective castings
- Turbine blades



Screws

Welding Parameters / Packing and Diameter Informations

Current Type and Polarity : DC(+)

Diameter [mm]	Length [mm]	Current (Method-A) [A]	Current (Method-B) [A]	Box Weight [kg]
3.25	350	110 - 130	80 - 100	5
4.00	350	145 - 160	110 - 140	5