Addifix 640

VERSATILE BRONZE ARC BRAZING ELECTRODE FOR JOINING AND BUILDING UP (DC+)

Tensile strength:	**50,000-60,000 PSI**
Elongation:	**32-42 percent**
Hardness:	**as welded 110 Brinell**
Diameters:	**1/8 5/32**
Amperages:	**120 170**

Smooth soft flowing action in all positions. Use for repair and building up on all steels, bronzes, copper, certain brasses and cast iron. Work hardens under frictional wear. Fully machinable. Applies bronze faster than by using a torch.

- **Smooth flowing, spatter free, all position arc action.**
- **Use for repair and buildup on all kinds of bronzes, copper, certain brasses, cast iron and all steels.**
- **Joins copper alloys to ferrous metals.**
- **Corrosion resistant bronze.**
- **Work hardens under impact.**
- **Polishes with frictional wear.**
- **Dense, porosity free deposits.**
- **Fully machinable.**
- **Faster than gas brazing.**
- **Brazes heavy components.**

MADE IN USA

Typical Industrial Applications: Pump housings, pump impellers, castings, springs, pillow blocks, guides, valve seats, gears, pulleys, brackets, propellers, check valves, seam traps, turbines, wear strips, bearing surfaces, and bronze applications.

Note: All copper base alloys have very high heat conductivity. A very heavy section may tend to act as a heat sink. The deposit, instead of flowing on smoothly may tend to ball up and not adhere to the base metal. A high preheat of 800-1000°F will cure the problem. Use heavier rod than normal whenever possible to minimize the heat loss problem.