

Technical Data Sheet

625T TIG Wire The Bronze Beauty



Cronatron™
A LAWSON BRAND



American Welding Society
Welding Distributor Member

Overview

625T TIG Wire provides a high-strength aluminum bronze deposit with the gas tungsten arc process. The deposits are the hardest of all bronze welding alloys. Finished welds are readily machinable and can be polished to a mirror-like finish, resulting in surfaces with a very low coefficient of friction. This bronze alloy meets all the requirements of the appropriate AWS specification.

Features/Benefits

- Low coefficient of friction
- High strength
- Porosity-free, tough deposits with no cracks
- Joins dissimilar metals
- Excellent for cast iron
- Available in 625 Electrode and 625M MIG Wire

Applications

- Bronze impellers
- Cast iron components
- Dissimilar metal joining
- Bronze valves
- Castings

Method of Application

TIG: DC straight polarity
Electrode: DC reverse polarity

Identification

Flag tagged or stamped wire

Directions for Use

Use DC straight polarity (electrode: DC reverse polarity). Clean surfaces of grease, rust, scale, etc. Use pure argon gas or a mixture of argon/helium for heavy sections. Set the flow rate at 15 to 20 cfh (0.42 to 0.55 m³/hr. For best results use a gas lens collet body. Amperage will depend on base metal type and thickness, and wire diameter.

Technical Specifications

Tensile Strength: 110,000 PSI (758 MPa)
Hardness: Rc 21 to Rc 23
Gas: 100% Ar

