

VENUS® - C

Shielded Metal Arc Welding
(SMAW-Stick)

For joining or overlays on bronze, brass and steels as well as dissimilar combinations.

ARC DC

All Positions

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FEATURES

- Superior strength 106,000 psi
- Wide range of applications
- Excellent corrosion resistance - chemical and salt water
- Machinable-deposit 200 Brinell
- Low coefficient of friction
- Welds dissimilar metals
- Work hardens

CHARACTERISTICS

VENUS-C is a highly alloyed aluminum bronze electrode. The addition of nickel and manganese gives it great versatility in joining and overlays on silicon bronzes, copper alloys, ferrous alloys and cast irons. It is also suitable for joining dissimilar combinations and deposits requiring machinability, such as guides and bearings.

VENUS-C is an electrode of choice for applications such as a valves, pumps, mixing blades, propellers and turbines.

APPLICATION

Preheat copper alloys 400°F (204°C). Use lowest amperage possible with short arc and electrode near vertical. Apply thin deposits and remove all slag on multipass welds.

TECHNICAL

Size and Amps DC \pm 20%

Inches:	3/32	1/8	5/32
(mm):	(2.4)	(3.2)	(4.0)

Amps:	60	100	130
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Reverse polarity. (DCEP)