

# Lastifil 508

## Hard phosphor bronze refacings

### CLASSIFICATION

EN ISO 24373 : Cu 5210 (CuSn8P)

### GENERAL DESCRIPTION

Solid welding wire in a special Sn-bronze quality, suitable for refacings on steel, cast iron and copper alloys.  
 Can also be used for repairing casting defects in Sn-bronze and for joining Sn-bronze and brass workpieces.  
 Also suitable for joining galvanized plate without burning the Zn layer.  
 High hardness and better abrasion resistance than 6% Sn bronze.  
 Porous free deposit.

### APPLICATIONS

Repair of castings in bronze, bearing seatings, refacing and joining steel and cast iron.  
 Welding CuSn8 (2.1030) - CuSn6 (2.1020) - G-CuSn7ZnPb (2.1090), G-CuSn10 (2.1050) aso.

Hardness: 80 HB

### CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Sn : 7.60 - 8.00	P : 0.05 - 0.10	Others : < 0.50	Cu : Balance	
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### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 260 MPa	≥ 20%	≥ 32 J (R.T.)

### GENERAL INFORMATION

**Welding positions** All

**Shielding gas** Argon

**Packing** 15 kg spool (in a cardboard box)

**Polarity** DC+

**Diameter (mm)** 0.8 1.0 1.2

#### Tips & tricks

Clean and degrease the workpieces.  
 Phosphorbronze with thickness > 6 mm (0,24"): preheating 150-200 °C (300-390 °F).  
 Keep molten pool and welding time as short as possible.  
 To avoid shrinking stresses and to refine the grains, the welding joint can be hot peened.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.