



EAGLE 204 Tin Bronze AC welding tin bronze electrode.

APPLICATIONS

For repair of bearings, pumps, impellers and castings.

PROCEDURE

AC or DC reverse polarity (+). Clean all weld areas with a grinder and bevel thicker sections. Preheat thick sections to 400⁰ F and maintain a medium arc length. Allow weld to cool slowly and remove slag between passes.

GENERAL CHARACTERISTICS

The **EAGLE 204** is a tin-bronze electrode for build-up and joining.

TECHNICAL DATA

Tip Color:	Yellow			
Tensile Strength: Psi	Approximate 40,000			
Elongation:	Approximate 20 – 30%			
Hardness: BH	Approximate 80 – 120			
Current:	AC – DC Reverse (+)			
Sizes: (IN)		3/32	1/8	5/32
(MM)		2.50	3.25	4.00
Amperage:		75 - 90	100 - 150	150 - 190

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