



# EAGLE 204 TIN BRONZE

*AC Welding Tin Bronze Electrode*

## APPLICATIONS

For repair of bearings, pumps, impellers and castings.

## PROCEDURE

Use AC or DC Reverse [+] Polarity. Clean all weld areas with a grinder and bevel thicker sections. Preheat thick sections to 400°F - 1100°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 Colour: Yellow  
Tensile Strength: Approx. 40,000 psi  
Elongation: Approx. 20 - 30%  
Hardness: (BH) Approx. 80 - 120

## WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity			
Sizes:	Inches	3/32	1/8	5/32
	mm	2.50	3.25	4.00
Amperage:	75 - 90	100 - 120	130 - 170	



≡ HIGH QUALITY WELDING PRODUCTS ≡

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