Lastek 52 V

Sheet metal and cast brass parts

CLASSIFICATION

EN 1044 : Cu 303 AWS A5.8 : RB CuZn-A

GENERAL DESCRIPTION

Flux coated rod for oxy-acetylene welding of brass and bronze and for brazing of steel and cast iron and copper. Low heat input minimizes distortion.

Brazing sheet metal with Lastek 52V is very easy and the beads are smooth and have a good appearance.

APPLICATIONS

Car bodies, pipes, sheet metal. Brass and bronze art work and furniture. Parts for refrigeration and heating equipment. Repairs on cast iron. Soldering of cast iron, steel and red copper applications.

Hardness: 110 HB Bonding temperature: 820 °C

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

Mn: 0.05 - 0.20	Si: 0.10 - 0.15	Cu: 59.50 - 60.50	Sn: 0.10 - 0.20	Zn: Balance

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength	Tensile Strength	Elongation	Impact Strength
N/mm ²	N/mm ²	5d (%)	Charpy V notch (ISO-V)
	≥ 350 MPa	≥ 20%	

GENERAL INFORMATION

Welding positions NA					
Shielding gas NA	NA				
Packing 5 kg in a card	ooard box				
Polarity NA					
Diameter (mm) 2.0	3.0	4.0	5.0		
Lenght (mm) 500	500	800	1000		

Tips & tricks	Remove paint, oil, and other impurities. Chamfer edges and angles. Preheat slightly. Heat steel plate locally until dark red. Use a slightly oxidizing flame on brass and a neutral flame on steel. Hold inner cone of the flame about 1 cm from work piece, avoid overheating. Melt the rod by rubbing along the joint. No finishing required. It is not necessary to use a separate flux.
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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.

