PRODUCT SPECIFICATION

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 N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 350 MPa	≥ 20%	

GENERAL INFORMATION

Welding positions	NA			
Shielding gas	NA			
Packing	5 kg in a cardboard 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.