



# Aluminum Electrode with Extruded Coating

**DC Reverse (ELECTRODE +)**

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## GENERAL CHARACTERISTICS:

Universal aluminum electrode for arc welding aluminum and aluminum alloys. Welds are strong, dense and free of porosity on both production and maintenance applications. Arc is exceptionally stable, operates at low amperes with a minimum of spatter and fuming. Weld deposits have good color match and corrosion resistance. Ideal for welding heat treated aluminum parts.

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## APPLICATIONS:

Repairing of automotive, truck and bus parts. Also for tanks, pipes, ladders, shelves, refrigeration equipment, foundry patterns and many other aluminum structures. Repair of machining errors and buildup of missing sections of castings, extrusions, plates, etc.

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## TECHNICAL DATA:

Tensile Strength	up to 34,000 psi (24 kg/mm <sup>2</sup> )		
Elongation %	15 - 25		
Hardness (HB)	40 - 55		
Color Match	good (will darken if anodized)		
Current	DC – reverse polarity (electrode +)		
Amperage	50-80	80-130	100-160
(in)	3/32	1/8	5/32
(mm)	2.5	3.25	4.0

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## PROCEDURES:

Clean weld area. Parts 1/8" or heavier should be beveled 70° - 90°. No preheat is necessary on thin gauges; however, faster, flatter, smoother welds are produced on heavier sections if they are preheated to approximately 400° F (205°C). Hold electrode vertical to workpiece, maintain a short arc and fast travel speed. Use either stringer beads or weaving technique. Remove slag between passes. Restart arc on existing weld deposits. Allow part to cool slowly. Chip off all slag before quenching. For complete slag removal, use a wire brush with 10% sulfuric acid and hot water solution. Rinse with clean, hot water.

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To Order - Call: **507-373-1677** or **800-735-3040**  
or E-mail: [amalloyindustries@gmail.com](mailto:amalloyindustries@gmail.com)  
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