



Boat Fabrication

Special aluminium electrode for joining and maintenance welding application

Typical Applications:

Engine blocks, housings, pumps, tanks, moulds, pistons, fans, frames

Outstanding Features:

- Dense, porosity-free deposits.
- Excellent arc stability.
- Joining, overlaying and filling.

Recommendation:

High strength, versatile alloy ideal for production as well as maintenance welding. Joints are three times stronger than conventional aluminium electrodes. This rapid-depositing alloy is particularly recommended for heat-treated aluminium, heavy castings, long joints, and repairing cracks, filling holes and building up missing sections. Rapid solidification of weld metal facilitates assembly alignment and also positional welding.

Procedure:

Clean weld area. Bevel thickness 3.2 mm or more to a 75° vee. For thick sections, pre-heating up to 200°C will produce faster, flatter deposit at reduced amperages. Use dc reverse polarity. Strike arc by lightly drawing electrode on work piece or with copper starting block. To avoid Arc-Stray on actual job. Maintain a short arc with electrode almost perpendicular. Backwhip craters. Chip slag between passes. Allow to cool slowly.

Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	120-140	90-110
4.00	140-160	105-130

Tensile Strength: 24 Kg/mm²
(34,000 psi)