EWACTRO AL 2 dc+

Boat Fabrication

Special designed electrode for joining and repair of aluminum parts.

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: 25 Kg/mm^2 (35,000 psi)