



70 DC+

ALUMINUM

DESCRIPTION

Specially designed electrode for **welding** and **rebuilding** aluminum and its various alloys.

CHARACTERISTICS

- **Porosity-free and corrosion resistant deposit**
- Good color match with aluminum
- Stable arc in all positions
- Active coating especially suited for welding of contaminated aluminum
- Excellent cracking resistance
- May be used with torch

TYPICAL APPLICATIONS

Recommended for cast aluminum parts, truck bodies, transmissions, tanks, pipes, repairing machining errors, building up missing sections on castings and mouldings, extrusions, plates, etc.

PROCEDURE

Remove the oxide layer prior to welding. Preheating of thick sections is recommended to facilitate welding. Weld while holding the electrode almost vertical while maintaining a short arc so the coating almost touches the base metal. Remove slag between each pass and cool slowly. The deposit may not be anodized.

MECHANICAL PROPERTIES

Tensile strength:	34 000 psi (235 MPa)
Elongation:	15 - 25%
Hardness:	40 - 60 BH

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	105 - 160 A	70 - 120 A	50 - 80 A

Also available : **Mixed diameter box** : 3 diameters in the same box : 0.5 kg of 2.5 mm, 1.5 kg of 3.2 mm and 0.5 kg of 4.0 mm.

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Specialized welding alloys and technology. For technical assistance or for ordering :

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