

THE ALUMINATOR

FLUX COATED ALUMINUM JOINING ALLOY

GENERAL CHARACTERISTICS:

Universal aluminum electrode for arc welding aluminum and aluminum alloys. Welds are strong 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.

APPLICATIONS:

Used for general welding of the 1xxx, 3xxx, 5xxx, 6xxx, and aluminum alloys.

TECHNICAL DATA:

Tensile Strength..... up to 30,000 psi (21 Kg/mm²)
Current DC Reverse Polarity (Electrode +)
Amperage 40-80 75-130
 (in.) 3/32 1/8
 (mm) 2.4 3.2

PROCEDURE:

Clean weld area. Parts 1/8" or heavier should be beveled 70°-90°. No preheat is necessary on thin gauges but faster, flatter, smoother welds are produced on heavier sections if they are preheated to approximately 400°F (204°C). Hold electrode vertical to workpiece, and maintain a short arc and fast travel speed. Use either stringer beads or weaving technique. Remove slag between passes. For complete slag removal use a wire brush with a 10% sulfuric acid and hot water solution. Rinse with clean hot water.