

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:

Typical Tensile Strength	30,000 psi (207 N/mm ²)
Current	DC reverse polarity (electrode +)

Diameter	Amperage
3/32" (2.4mm)	40-80
1/8" (3.2mm)	75-130

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 and hot water.

