

ARCTEC® 440S ALUMINUM



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® 440S ALUMINUM is a coated electrode for arc welding of aluminum and aluminum alloys. This electrode produces strong, dense and porosity free welds. Can also be applied with an oxyacetylene torch. Used for fabrication and maintenance applications. Exceptionally stable arc operates at low amperage with a minimum of spatter and fuming. Weld deposits have good color match and corrosion resistance. Not suitable for anodizing.

APPLICATIONS:

ARCTEC® 440S ALUMINUM electrode is used for repair of machining errors, build up of worn sections of castings, extrusions, plates, etc. Also for truck, bus and automotive parts repair. Use for tanks, ladders, shelves, refrigeration equipment, foundry patterns and many other aluminum structures. Ideal for heat treated aluminum parts and irrigation pipe.

WELDING PROCEDURE:

Clean the weld zone of all contaminants by grinding if necessary. Bevel sections 3.25mm (1/8") or heavier to 70°-90° included angle. Preheat is not necessary on thin gauge material. On heavier section preheat of approximately 205°C (440°F) produces flatter, smoother weld beads. Hold electrode vertical to the work piece, maintain a short arc and fast travel speeds. Either stringer beads or weaving may be used. Slag must be removed between passes and before quenching. Restrike arc on existing weld deposit. Allow welded part to air cool slowly. Complete slag removal can be accomplished by using a wire brush with a 10% sulfuric acid and hot water solution. Rinse thoroughly with clean hot water.

MECHANICAL PROPERTIES:

Hardness	Tensile Strength	Elongation
40-55 HB	34,000psi (234Mpa)	15-25%-2"

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse

Diameter:	2.5mm 3/32"	3.25mm 1/8"	4.00mm 5/32"
Amperage	50-80	80-130	110-160

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