

AMTEC 440S ALUMINUM ELECTRODE
DC REVERSE OR WITH OXY-ACETYLENE

General Characteristics

Amtec 440S is a unique "Dual Coat" flux coated aluminum electrode that allows the welder to use it as a welding electrode or a torch brazing alloy. It has a special extruded smooth-coated double coated flux that helps give it moisture resistance. This electrode can be used in all positions, has good corrosion resistance, and gives a dense, porosity free deposit, without excessive spatter and fuming. Amtec 440S has good color match to aluminum, but is not recommended for anodizing. The pure white flux coating outlasts conventional products in moisture resistance.

Procedure

Clean the weld zone of all contaminants. Maintain a short arc with electrode tilted slightly in direction of travel. Weave beads are not usually recommended. On heavy sections over 3/8 of an inch, it is recommended that you bevel to form a 60-75° included angle and preheat to 204°C (400°F). Due to the faster burn off of the aluminum electrode, a faster travel speed is necessary. Remove all slag by chipping hammer and stainless steel wire brush before making additional passes. Let the deposit cool first before removing slag for best results.

Application

For arc and torch welding aluminum alloyed with copper, silicon, and magnesium. Amtec 440S is also excellent for joining dissimilar grades of aluminum. Use this electrode to repair cracks on aluminum castings, maintenance work of aluminum plate and extrusions. Also excellent on foundry patterns, automotive parts, aluminum tanks, railings and stairways, and aluminum tire molds.

Tensile Strength				34,000 PSI
Yield Strength				20,000 PSI
Elongation				18%
Hardness (HB)				40-55

Diameter (Inch)	3/32	1/8	5/32
(mm)	2.5	3.25	4.0

Amps (approx.)	50-80	70-120	110-150
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CONFIDENTIAL INFORMATION
Subject to change without notice

Tip Color - Blue
Amtec 440S Imprint