

Technical Data Sheet

AMPCO-CORE 200



DESCRIPTION

- ▶ Special cored wire for GMAW
- ▶ Aluminum Bronze weld metal
- ▶ Sound, pore free deposits
- ▶ The deposit has little tendency to cracking

APPLICATIONS

- ▶ Primarily an overlay filler metal
- ▶ This alloy is used in applications involving metal-to-metal wear under heavy loads

Examples

- ▶ Gear teeth, pump shafts, stripper columns, wear plates

TYPICAL ALL-WELD METAL ANALYSIS

Al	Fe	Cu
9.0	4.0	Bal.

TYPICAL MECHANICAL PROPERTIES

- ▶ Hardness - 3-layer deposit on mild steel: 210 HB

SHIELDING GAS

- ▶ 100% ARGON

OPERATING CONDITIONS

Current type	Gasflow rate
DC+ (DCEP)	40 - 50 cfh (19-24 L/min)

OPERATING CONDITIONS

Diameter [inch (mm)]	Intensity [A]		Voltage [V]		Stick-out: [inch (mm)]	
	Range	Optimum	Range	Optimum	Range	Optimum
0.045" (1.2 mm)	200 - 250	220	29 - 31	30	5/8 - 1" (15 - 25 mm)	3/4" (20 mm)
0.062" (1.6 mm)	230 - 300	250	29 - 31	30	5/8 - 1" (15 - 25 mm)	3/4" (20 mm)

- ▶ Stringer or weaved beads
- ▶ Can be welded forehand (pushing) preferred or backhand (trailing)

WELDING POSITION

- ▶ FLAT POSITION

PACKAGING

Diameter	0.045" (1.2 mm)	0.062" (1.6 mm)
Spool type	12 " (300mm)	12 " (300mm)
Weight	30 LB.	13.6 Kg.

CONTACT US FOR ADDITIONAL INFO