

Technical Data Sheet

AMPCO-CORE 250



DESCRIPTION

- ▶ Special cored wire for GMAW
- ▶ Aluminum Bronze weld metal
- ▶ Sound, pore free deposits
- ▶ Good resistance to metal-to-metal wear

APPLICATIONS

- ▶ Primarily an overlay filler metal
- ▶ Cladding components undergoing metal-to-metal wear under heavy loads

Examples

- ▶ Friction plates, bearings, sliders, high speed bearings etc.

TYPICAL ALL-WELD METAL ANALYSIS

| Al | Fe | Cu |
|------|-----|------|
| 11.5 | 4.0 | Bal. |

TYPICAL MECHANICAL PROPERTIES

- ▶ Hardness - 3-layer deposit on mild steel: 320 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