

Technical Data Sheet



AMPCO-TRODE[®] 150

Description and Application

AMPCO-TRODE 150 aluminum bronze spooled wire and bare filler rod produce a deposit of high strength and good ductility with a nominal hardness of 166 Brinell as applied with the inert-gas processes. AMPCO-TRODE 150 is recommended for welding AMPCO 18 alloy. It is ideal for piston overlay applications and bearing surfaces requiring high strength and good ductility.

Limiting Chemical Composition,

% (filler metal)

Copper*	balance
Aluminum	10.0-11.50
Iron	2.0-4.50
Silicon	0.10 max.
Others	0.50 max.

* including silver

Mechanical Properties

(nominal all-weld metal values)

Tensile Strength, ksi	90 (621 MPa)
Yield Strength, ksi	40 (276 MPa)
Elongation, % in 2" (51 mm)	20
Reduction of Area, %	22
BHN(3000kg.)	
1/4" (6.4mm) deposit	166

Specifications

AWS A5.7 Class ER CuAl-A3

Typical Applications

hydraulic pistons	bearing overlays
impellers	turbine runners
press rams	cable sheaves
mill slippers	valve seats and parts
breaker blocks	ceiling machine
mandrels	
steel mill rolls	welding AMPCO 18

