

Technical Data Sheet



AMPCO-TRODE® 7

Description and Application

AMPCO-TRODE 7 is an iron-free, aluminum bronze alloy available in spooled wire and 36" (1000 mm) bare-filler metal rod for use with the gas metal-arc and gas tungsten-arc welding processes respectively.

AMPCO-TRODE 7 deposits are used primarily to overlay bearing and wear-resistant surfaces requiring a hardness of approximately 125 BHN and to resist corrosion especially from salt water, metal salts and many commonly used acids in varying concentrations and temperatures. This alloy is not recommended for joining since the deposit does have a tendency to be hot short.

Typical Applications

tube sheets, pickling hooks, impellers
valve seats, chemical plants, pulp mills

Limiting Chemical Composition,

% (filler metal)

Copper*	balance
Aluminum	6.0- 8.50
Manganese	0.50 max.
Silicon	0.10 max.
Others	0.50 max.

* including silver

Mechanical Properties

(nominal all-weld metal values)

Tensile Strength, ksi	68 (469 MPa)
Yield Strength, ksi	28 (193 MPa)
Elongation, % in 2" (51 mm)	47
Reduction of Area, %	53
BHN (3000kg.)	
1/4" (6.4 mm) deposit	125

Specifications

AWS A5.7 Class ER CuAl-A1
ASME SFA 5.7 Class ER CuAl-A1

