

AMPCO-TRODE® 10

Aluminium-Bronze

Classifications

AWS A5.6 Class E CuAl-A2
 AWS A5.13 Class E CuAl-A2
 ASME SFA 5.6 E CuAl-A2

Description

- AMPCO-TRODE® 10 aluminum bronze is the most versatile welding electrode in AMPCO's family of alloys.
- AMPCO-TRODE® 10 contains an additive to inhibit inter-granular stress corrosion cracking. This is particularly important when welding on C61300 and C61400 base metal.
- AMPCO-TRODE® 10 will weld and join many ferrous and nonferrous metals and combinations of dissimilar metals. These metals include the more weld-able grades of cast iron, high and low carbon steels, copper, bronzes and copper-nickel alloys.
- Applications for AMPCO-TRODE® 10 include; building up bearing surfaces, joining and fabricating copper alloys, overlaying for resistance to corrosion and erosion and general maintenance and repair welding.



Limiting chemical composition of all-weld metal (%)

Cu*	Al	Fe	Si	Others
Rem.	6.5-9.0	0.50-5.0	1.5 max	0.5 max

*Including silver

Mechanical properties (nominal all-weld metal values)

	Y.S. (MPa)	T.S. (MPa)	El. (% in 51mm)	Area Reduction %	BHN (3000 kg) (6.4 mm deposit)
Example	241	531	27	27	119

Sizes available

Diameter	(mm)	3.2	4.0
Length	(mm)	305	356

Recommended welding parameters

Refer to AMPCO® welding products brochure or website for recommended welding parameters.