

# ALLOYS

## ALUMINUM 340 ELECTRODES (DC-REVERSE)

- Features a precise combination of core wire and coating, providing high speed deposition of dense, machineable welds
- Tensile strength – up to 34 000 PSI
- Good colour match and corrosion resistance
- **Priced per 5-lb. tube (5 - 1-lb. bags)**



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### Applications:

Recommended for fabrication and repair of cast and wrought aluminum. Excellent for foundry defects, machining errors and all types of salvage work. Widely used on sheets, tubes and extrusions in thicknesses of 1/8" or more. Also well-suited to torch applications.

Priced per Tube

| Model No. | Mfg. No.        | Dimensions<br>Dia." x Length" | Wt. lbs. | Price /Each |
|-----------|-----------------|-------------------------------|----------|-------------|
| TTU856    | ALSM00TH340332E | 3/32 x 14                     | 5        | 219.00      |
| TTU857    | ALSM00TH34018E  | 1/8 x 14                      | 5        | 199.00      |
| TTU858    | ALSM00TH340532E | 5/32 x 14                     | 5        | 199.00      |

## NICKEL 55 ELECTRODES

- A general purpose, nickel-iron electrode for production, salvage and repair of all cast irons (AWS A5.15, ENiFeCl)
- Tensile strength – up to 70 000 PSI
- Suited to joining, filling and buildup of grey and alloyed cast irons
- **Priced per 10-lb. tube**

**Applications:** Can be used for fabrication and repair of pump housings, valves, castings, cast and malleable fittings, and for general repair of all cast irons. Deposits are machineable and have high strength.



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Priced per Tube

| Model No. | Mfg. No. | Dia." | Wt. lbs. | Price /Each |
|-----------|----------|-------|----------|-------------|
| TTU862    | NI55332E | 3/32  | 10       | 319.00      |
| TTU863    | NI5518E  | 1/8   | 10       | 319.00      |
| TTU864    | NI5532E  | 5/32  | 10       | 319.00      |
| TTU865    | NI55316E | 3/16  | 10       | 319.00      |

## HIGH SILVER BRAZING ALLOYS

**Weldcote 45CF** - General purpose silver brazing alloy with a wide melting range and widely used in many brazing operations. Commonly used to join any combinations of copper, brass, steel and bronze. Colour is yellow white to light gold.

### Chemical Composition (Wt. percent):

|                |             |
|----------------|-------------|
| Silver         | 44.0 – 46.0 |
| Copper         | 29.0 – 31.0 |
| Zinc           | 23.0 – 27.0 |
| Other Elements | 0.15        |

**Weldcote 56CF** - Cadmium free silver brazing alloy with a narrow melting range and the lowest working temperature in the cad-free family yielding premium flow, wetting, ductility, penetration. Commonly used to join any combinations of copper, brass, steel, bronze and stainless steel. Great choice for food handling equipment and color match on stainless and nickel alloys while minimizing stress corrosion cracking. Colour is white to light gold.

### Chemical Composition (Wt. percent):

|                |             |
|----------------|-------------|
| Silver         | 55.0 – 57.0 |
| Copper         | 21.0 – 23.0 |
| Zinc           | 15.0 – 19.0 |
| Tin            | 4.5 – 5.5   |
| Other Elements | 0.15        |

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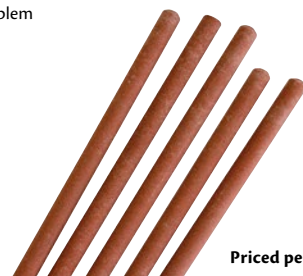
### WELDCOTE 45CF

| Model No. | Mfg. No.      | Description              | Specifications | Solidus | Liquidus | Brazing Range | Price /Each |
|-----------|---------------|--------------------------|----------------|---------|----------|---------------|-------------|
| TTU870    | 45CF132X1T0C  | 1/32" x 1 T.O.           | AWS A5.8       | 1225°F  | 1370°F   | 1370-1550°F   | 43.40       |
| TTU871    | 45CF132X5T0C  | 1/32" x 5 T.O.           | Bag-5          | 663°C   | 743°C    | 743-843°C     | 189.00      |
| TTU872    | 45CF364X1T0C  | 3/64" x 1 T.O.           | -              | -       | -        | -             | 49.90       |
| TTU873    | 45CF116X1T0C  | 1/16" x 1 T.O.           | -              | -       | -        | -             | 49.00       |
| TTU874    | 45CF116X5T0C  | 1/16" x 5 T.O.           | -              | -       | -        | -             | 169.00      |
| TTU875    | 45CF332X1T0C  | 3/32" x 1 T.O.           | -              | -       | -        | -             | 55.20       |
| TTU876    | 45CF332X5T0C  | 3/32" x 5 T.O.           | -              | -       | -        | -             | 169.00      |
| TTU877    | 45FCF116X18L4 | Flux-Coated              | -              | -       | -        | -             | 135.00      |
|           |               | 1/16" x 18" x 4 oz. Tube | -              | -       | -        | -             |             |
| TTU878    | 45FCF332X18L4 | Flux-Coated              | -              | -       | -        | -             | 145.00      |
|           |               | 3/32" x 18" x 4 oz. Tube | -              | -       | -        | -             |             |

## SUPER 120 ELECTRODES

- Ultimate electrodes for welding steel with highest strength and maximum ductility (AC-DC)
- Assures dense, non-cracking welds on problem steels such as: high carbon, tool, spring, manganese, and dissimilar steels
- Tensile strength – up to 120 000 PSI
- Yield strength – up to 85 000 PSI
- Ductility – up to 35% elongation in 2"
- **Priced per 5 or 10-lb. tube**

**Applications:** Particularly advantageous when the alloy content of the steel to be welded is unknown.



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Priced per Tube

| Model No. | Mfg. No.     | Dia." | Wt. lbs. | Price /Each |
|-----------|--------------|-------|----------|-------------|
| TTU859    | SUPER120332E | 3/32  | 5        | 169.00      |
| TTU860    | SUPER12018E  | 1/8   | 10       | 299.00      |
| TTU861    | SUPER120532E | 5/32  | 10       | 299.00      |

## NICKEL 99 ELECTRODES

- A general purpose, high nickel electrode for production and repair of cast iron (AWS A5.15, ENiCl)
- Tensile strength - up to 50 000 PSI
- **Priced per 10-lb. tube**

**Applications:** Ideal for building up, joining, filling holes, breaks and cracks in all types of cast iron. It has very good out-of-position welding characteristics. Parts are frequently repaired without dismantling.



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Priced per Tube

| Model No. | Mfg. No. | Dia." | Wt. lbs. | Price /Each |
|-----------|----------|-------|----------|-------------|
| TTU866    | NI99332E | 3/32  | 10       | 439.00      |
| TTU867    | NI9918E  | 1/8   | 10       | 439.00      |
| TTU868    | NI99532E | 5/32  | 10       | 439.00      |
| TTU869    | NI99316E | 3/16  | 10       | 439.00      |

TTU870



TTU879



TTU878

### WELDCOTE 56CF

| Model No. | Mfg. No.      | Description              | Specifications | Solidus | Liquidus | Brazing Range | Price /Each |
|-----------|---------------|--------------------------|----------------|---------|----------|---------------|-------------|
| TTU879    | 56CF132X1T0C  | 1/32" x 1 T.O.           | AWS A5.8       | 1145°F  | 1205°F   | 1205-14006°F  | 47.40       |
| TTU880    | 56CF132X5T0C  | 1/32" x 5 T.O.           | Bag-7          | 618°C   | 652°C    | 652-760°C     | 218.00      |
| TTU881    | 56CF364X1T0C  | 3/64" x 1 T.O.           | -              | -       | -        | -             | 45.70       |
| TTU882    | 56CF116X1T0C  | 1/16" x 1 T.O.           | -              | -       | -        | -             | 40.90       |
| TTU883    | 56CF116X5T0C  | 1/16" x 5 T.O.           | -              | -       | -        | -             | 189.00      |
| TTU884    | 56CF332X1T0C  | 3/32" x 1 T.O.           | -              | -       | -        | -             | 60.90       |
| TTU885    | 56CF332X5T0C  | 3/32" x 5 T.O.           | -              | -       | -        | -             | 189.00      |
| TTU886    | 56FCF116X18L4 | Flux-Coated              | -              | -       | -        | -             | 159.00      |
|           |               | 1/16" x 18" x 4 oz. Tube | -              | -       | -        | -             |             |
| TTU887    | 56FCF332X18L4 | Flux-Coated              | -              | -       | -        | -             | 167.00      |
|           |               | 3/32" x 18" x 4 oz. Tube | -              | -       | -        | -             |             |