



# HI-ALLOY 100

## SPECIAL ALUMINUM BRONZE ELECTRODE

**DESCRIPTION:** Hi-Alloy 100 is alloyed with nickel and manganese making it far superior to common aluminum bronze electrodes. It is an excellent choice for joining and buildup of most steels and copper based metals, for repair of bearing surfaces, and for surfacing of parts subjected to sea water or corrosive chemicals. Deposits are fully machinable and will work harden in service.

**TYPICAL APPLICATIONS:** Stirrer blades, valves, ship propellers, thrust bearings, turbines, hydraulic equipment parts, joining dissimilar metals, structural joining, and machinery construction.

**PROCEDURES:** Maintain a short arc length; apply in thin layers using weave or stringer beads, remove slag between passes. Finished part should cool down slowly. (Preheat copper based metals to 600° F.)

**AVAILABLE SIZES:**                      3/32                      1/8                      5/32

**AMPERAGE RANGES:**                70-100                90 -125                120 - 150

**POLARITY:**                                DC Reverse

**TENSILE STRENGTH:**                Up to 100,000 psi

**HARDNESS:**                                Up to 200 Brinell