



TEXAS \* PENNSYLVANIA \* NORTH CAROLINA  
<http://hi-alloy.com>

## HI-ALLOY 133

### COPPER ELECTRODE

**DESCRIPTION:** Hi-Alloy 133 is an all position, high purity copper electrode. This product welds with a smooth stable arc on all common grades of copper and copper alloys.

**TYPICAL APPLICATIONS:** Hi-Alloy 133 is commonly used in the fabrication, buildup, and surfacing of electrolytic and deoxidized copper parts and in applications where thermal and electrical conductivity or high corrosion resistance is required. Hi-Alloy 133 is also a good choice for copper cladding of steel and cast iron.

**PROCEDURES:** Clean all oxides, contaminants, and weakened metal from the area to be welded. Sections heavier than 3/16" should be beveled and preheated to 750° - 1100° F. Thin sections need not be preheated. For best results maintain a short arc length during welding and allow the part to cool before removing the slag.

AVAILABLE SIZE:	1/8
AMPERAGE RANGE:	100 - 130
POLARITY:	DC Reverse
TENSILE STRENGTH:	Up to 31,000 psi