



## **HI-ALLOY 144**

### **AC/DC BRONZE ELECTRODE**

**DESCRIPTION:** Hi-Alloy 144 is an all position electrode used extensively for the welding of copper, brass, bronze, cast iron, steel, and for joining dissimilar combinations of these metals. It is an excellent overlay and buildup electrode providing good resistance to corrosion from sea water and chemical solutions. This electrode welds smoothly and quietly producing dense, porosity free, fully machinable deposits.

**TYPICAL APPLICATIONS:** Repair and resurfacing of turbines, gear wheels, bearings, valve bodies, impellers, and defects in castings.

**PROCEDURES:** The edges of heavy materials should be beveled to form a 45° vee. Preheat is not required but is always desirable. Normal arc length should produce a good solid weld. Slag is removed easily after the bead is allowed to cool slightly.

<b>AVAILABLE SIZES:</b>	3/32	1/8
<b>AMPERAGE RANGES:</b>	80 - 100	100 - 140
<b>POLARITY:</b>	AC or DC Reverse (Use DC Reverse on cast iron)	
<b>TENSILE STRENGTH:</b>	Up to 55,000 psi	
<b>HARDNESS:</b>	Up to 100 Brinell	