

# Technical Data Sheet **AMPCO-CORE® 200**

## Description and Application

AMPCO-CORE® 200 is an aluminum bronze flux core wire for use with the Gas Metal Arc Welding process.

AMPCO-CORE® 200 is primarily an overlay filler metal. The high strength values of the deposit combined with excellent wear-resisting characteristics make this alloy unsurpassed for bearing overlays where extreme wear and high pressures are encountered in service.

## Typical Applications

Gear teeth, pump shafts, stripper columns, wear plates. Also, friction plates, bearings, sliders, high speed bearings, etc.

## Limiting Chemical Composition

% (filler metal)

Copper.....	balance
Aluminum.....	9.0
Iron.....	4.0

## Mechanical Properties\*

(Nominal all-weld metal value)

BHN (3000kg.)	
Three layer deposit on mild steel.....	183

## Product availability and packaging

AMPCO-CORE® 200 is available in two diameters:

0.045" (1.2mm)

0,062" (1.6mm).

Both sizes are available in 12" (300mm) spools weighing 33lbs. (15kgs.) each.

*\*Hardness will vary depending on quality of the weld and experience and know-how of the welder.*

## Welding position and deposits

The flat welding position is recommended. Backhand (trailing) welding is preferred rather than forehand (pushing) to make either stringer or weaved beads.

## Shielding gas

100% Argon

## Operating conditions

### Current type

DC+ (DCEP)

### Gas flow rate

25 - 46 cfh (12-22 L/min)

### Intensity [A]

0.045" (1.2 mm) 200-300

0.062" (1.6 mm) 360-400

### Voltage [V]

All diameters 28-30

### Stick-out [inch (mm)]

All diameters 5/8-1" (15-25)

