

Technical Data Sheet **AMPCO-CORE® 250**

Description and Application

AMPCO-CORE® 250 is an aluminum bronze flux core wire for use with the Gas Metal Arc Welding process.

AMPCO-CORE® 250 is primarily an overlay filler metal. The characteristics of this filler metal make the deposit adaptable for use in those extreme bearing applications where very high pressures are encountered operating against hardened steel surfaces.

AMPCO-CORE® 250 often use for overlaying in applications where its unusual wear-resistant qualities increase service life of wearing parts.

Typical Applications

Friction plates, bearings, sliders, high speed bearings, etc.

Limiting Chemical Composition

% (filler metal)

Copper.....	balance
Aluminum.....	11.5
Iron.....	4.0

Mechanical Properties*

(Nominal all-weld metal value)

BHN (3000kg.)	
Three layer deposit on mild steel.....	250

Product availability and packaging

AMPCO-CORE® 250 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)

