

Technical Data Sheet **AMPCO-TRODE[®] 250**

Description and Application

AMPCO-TRODE[®] 250 aluminum bronze bare filler rod is available for use with the gas tungsten arc welding process. The weld deposit has a nominal hardness of 250 Brinell and has higher yield strength and hardness than AMPCO-TRODE[®] 200 with lower tensile strength and ductility typical of the aluminum bronzes.

These characteristics make this deposit adaptable for use in extreme bearing applications where very high pressures are encountered.

AMPCO-TRODE[®] 250 is primarily used for overlay welding in applications where unusual wear-resistant qualities increase service life of wearing parts.

Limiting Chemical Composition,

% (filler metal)

Copper*	Balance
Aluminum	13.0 - 14.0
Iron	3.0 - 5.0
Silicon	0.04 max.
Others	0.50 max.

* including silver

Mechanical Properties

(Nominal all-weld metal values)

Tensile Strength, ksi (MPa)	78 (538)
Yield Strength, ksi (MPa)	56 (386)
Elongation, % in 2" (51 mm)	0
BHN (3000kg) 1/4" (6.4 mm) deposit	340

Specifications

AWS Class RCuAl-D

Typical Applications

Wear shoes	Chafing plates
Clutch fingers	Screw conveyors
Forming dies	Sleeves
Cams	Welding AMPCO [®] 22

**Hardness will vary depending on quality of the weld and experience and knowhow of the welder.*

