

# Technical Data Sheet **AMPCO-TRODE® 150**

## Description and Application

AMPCO-TRODE® 150 aluminum bronze spooled wire and bare filler rod produce a deposit of high strength and good ductility with a nominal hardness of 166 Brinell as applied with the inert-gas processes.

AMPCO-TRODE® 150 is recommended for welding AMPCO® 18 alloy. It is ideal for piston overlay applications and bearing surfaces requiring high strength and good ductility.

## Typical Applications

Hydraulic pistons	Bearing overlays
Impellers	Turbine runners
Press rams	Cable sheaves
Mill slippers	Valve seats and parts
Breaker blocks	Ceiling machine mandrels
Steel mill rolls	Welding AMPCO® 18

## Limiting Chemical Composition,

*% (filler metal)*

Copper*.....	Balance
Aluminum.....	10.0-11.50
Iron.....	2.0-4.50
Silicon.....	0.10 max.
Others.....	0.50 max.

\* including silver

## Mechanical Properties

*(Nominal all-weld metal values)*

Tensile Strength, ksi.....	90 (621 MPa)
Yield Strength, ksi.....	40 (276 MPa)
Elongation, % in 2" (51 mm).....	20
Reduction of Area, %.....	22
BHN (3000kg.)	
1/4" (6.4mm) deposit.....	166

## Specifications

AWS A5.7 Class ER CuAl-A3

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

