

Welding Procedure

Welding AMPCO[®] 18 Alloy

AMPCO[®] 18 is a popular aluminum bronze which offers good bearing qualities with resistance to wear, abrasion and fatigue. Highly resistant to deformation under load, this alloy is available as sand, centrifugal and shell mold castings, extruded rod and bar, and continuous cast shapes.

Recommended Filler Metal

AMPCO-TRODE[®] 150 with gas tungsten-arc or gas metal-arc welding; AMPCO-TRODE[®] 160 with shielded metal-arc welding.

Preheat

Generally, no preheat is necessary. However, when joining AMPCO[®] 18 to a ferrous metal with the shielded metal-arc process, it may be necessary to slightly preheat the ferrous metal.

Welding Procedure

For joining AMPCO[®] 18 to itself, apply either AMPCO-TRODE[®] 150 or AMPCO-TRODE[®] 160, using a wide groove appropriate to the thickness. Proper restraint will help minimize warpage and distortion when joining pieces end to end.

Postheat

None required except for corrosion service; then a temper anneal is recommended.

