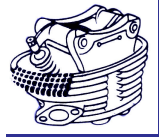


# SHUBER E 470

## ALUMINUM ALLOY ELECTRODE



### DESCRIPTION

HIGH QUALITY ALUMINUM ELECTRODE FOR WELDING ALUMINUM AND ITS ALLOYS WITH A WELDABILITY FAR SUPERIOR THAN ANY OTHER ALUMINUM ELECTRODE. Produces dense, crack and porosity-free weld deposit even on difficult-to-weld aluminum alloys. Strength and ductility of the weld metal are excellent and corrosion resistance matches that of the base metal. Ideal for fabrication of structurals, sheet material, repair of castings and build-up of missing sections. Special treatment of the core wire and carefully controlled coating chemistry give long shelf life.

### SPECIAL FEATURES

- Easy to apply due to exceptional arc stability.
- Spatter-free deposit requiring minimum post cleaning.
- Permits high speed welding due to high rate of deposition.
- Excellent moisture resistance due to anti-hygroscopic additives in coating.

### APPLICATION INSTRUCTIONS

Clean weld area. Bevel sections 3.2 mm or heavier to a 75° vee. Thinner sections require no preparation. On heavier sections, a preheat of 200°C (400°F) will produce faster and flatter deposit at reduced amperage. The arc is best started by drawing the electrode on the surface of the base metal or copper starting block. Maintain a short arc and backwhip craters.

### TECHNICAL DATA

TENSILE STRENGTH: 25 kg/mm<sup>2</sup> (34,000 psi)

RECOMMENDED CURRENT:

DC +(Reverse Polarity)	DIAMETER	AMPS
	3.2 mm (1/8")	90 - 140
	4.0 mm (5/32")	105 - 160

Tip Colour: Red

DIN 1732:  
**S - AISi 12**