

# 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.

## 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

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

## Specifications

AWS A5.7 Class ER CuAl-A3

## 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

