

Technical Data Sheet **AMPCO-TRODE® 200**

Description and Application

AMPCO-TRODE® 200 aluminum bronze bare filler rod is available for use with the gas tungsten arc welding process. The weld deposit has a nominal hardness of 200 Brinell and has high strength.

AMPCO-TRODE® 200 is primarily an overlay filler metal. The high strength values of the deposit combined with excellent wear-resisting characteristics make this alloy unsurpassed for bearing overlays where extreme wear and high pressures are encountered in service.

Limiting Chemical Composition

% (filler metal)

Copper*	balance
Aluminum	12.0 - 13.0
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)	97 (669)
Yield Strength, ksi (MPa)	44 (304)
Elongation, % in 2" (51 mm)	1
Reduction of Area, %	1
BHN (3000 kg) 1/4" (6.4mm) deposit	269

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

Specifications

AWS Class RCuAl-C

Typical Applications

Wear plates	Split bearings
Crane hooks	Propeller shafts
Forming dies	Cable sleeves
Gear teeth	Thrust bearing faces
Feed screws	Wheel flanges
Cams	Welding AMPCO® 21

