



...better ways to join metals

®

TECHNICAL SPECIFICATION SHEET

HARRIS PRODUCTS GROUP
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ALUMINUM BRONZE A2 WELDING WIRE

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health.
ARC RAYS can injure eyes and burn skin.
ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

STATEMENT OF LIABILITY — DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. Harris Products Group and its affiliates shall have no liability in respect thereof.

NOMINAL COMPOSITION:

Silicon	.10 % max.	Aluminum	8.0-11.0 %
Lead	.02 % max.	Zinc	.02 % max
Copper	Balance	Iron	1.5 % max
Others	.50 % max.		

PHYSICAL PROPERTIES:

Melting Point	1915 °f (1046 °C)	Reduction of area	28 %
Yield Strength	35,000 psi	Tensile Strength	79,000 psi
Elongation	28 %	Brinell Hardness	140 HB

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All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

For technical support and product information, visit our web site at www.harrisproductsgroup.com

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APPLICATION:

Used to weld base metals of steels and cast iron to copper, brass, and bronze. Ideal for overlays on shafts, propellers, housings, couplings, bushings, valve seats, pumps, and other surfaces needing a bronze wearing surface.

RECOMMENDED WELDING PARAMETERS:

*GMAW(MIG) Parameters (DC Reverse Polarity) Electrode Positive Spray transfer

<u>Wire Diameter</u>	<u>Amps</u>	<u>Volts</u>	<u>Argon (cfh)</u>	<u>Wire Feed ipm</u>
.030	80-140	25-26	25	340-450
.035	130-200	26-27	30	280-400
.045	185-245	27-28	30	200-300
1/16	250-400	28-30	40	150-210

*GTAW(Tig) Parameters (DCSP) ² Electrode negative or ACHF

<u>Material</u>	<u>2%Thoriated ²</u>	<u>Filler Wire Size</u>	<u>Amps (DC)</u>	<u>Amps (AC)</u>	<u>Gas Cup</u>	<u>Argon(cfh)</u>
1/16"	1/16"	1/16"	80-120	80-120	3/8-1/2	15
3/32"-1/8"	3/32"	3/32"	145-205	145-195	7/16-1/2	15
3/16"	1/8"	3/32"-1/8"	300-350	255-300	7/16-1/2	20
1/2"	3/16"	1/8"	515-640	340-485	1/2	25

* All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.

SPECIFICATION COMPLIANCE: ANSI/AWS A5.7 & ASME SFA 5.7 ERCuAl-A2

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