

# AURALLOY RESEARCH

## *Superior Performance Welding Products Designed to Solve the Maintenance and Repair Welders Problems*



- **MAKES WELDING EASIER, EVEN ON INADEQUATE EQUIPMENT**
- **SAVES YOUR COMPANY MONEY**
- **ELIMINATES LARGE INVENTORIES**
- **QUALITY AND VERSATILITY THAT REDUCES DOWN-TIME**

**Auralloy helps improve the ability of the mechanic with limited welding experience, while enabling the highly skilled welder to do an even better job by:**

- Welding metals of unknown analysis.
- Welding through Paint, Rust, Grease and Oil when cleaning is normally required.
- Welding without pre-heat in most applications.
- Salvaging expensive parts that are now being scrapped.
- No guesswork, the right rod for the job everytime.

**Our customers have benefitted from Auralloy's performance with:**

- Reduced Downtime
- Extended Repair Life
- Increased Performance
- Ease of application
- Decreased Costs

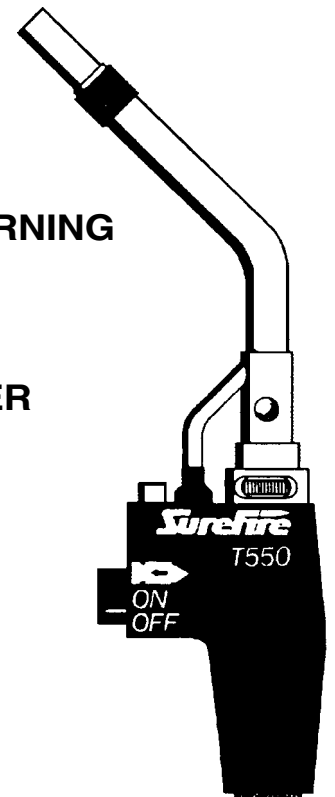
*The  
Auralloy Quality  
Formula will put  
Maintenance and Repair  
Power into your Shop —  
**NOW!***



## **THE SUREFIRE HEAVY DUTY SELF-IGNITING PROPANE OR MAPP TORCH**

- **DESIGNED FOR PROFESSIONAL USE\***
- **IGNITED AUTOMATICALLY AT THE PUSH OF A BUTTON**
- **INSTANT ON — INSTANT OFF!  
NO MATCHES!**
- **VARIABLE FLAME ADJUSTMENT**
- **TRIGGER LOCK PROVIDES CONTINUOUS BURNING**
- **IGNITES AND BURNS UPSIDE DOWN**
- **3400°F AT TIP — BRAZE AND SOLDER COPPER  
PIPE, LIGHT STEEL AND SHEET METAL**
- **PRESSURE REGULATOR PROVIDES  
EVEN FLOW OF GAS IN ALL POSITIONS**
- **SAFE AND EASY TO USE**

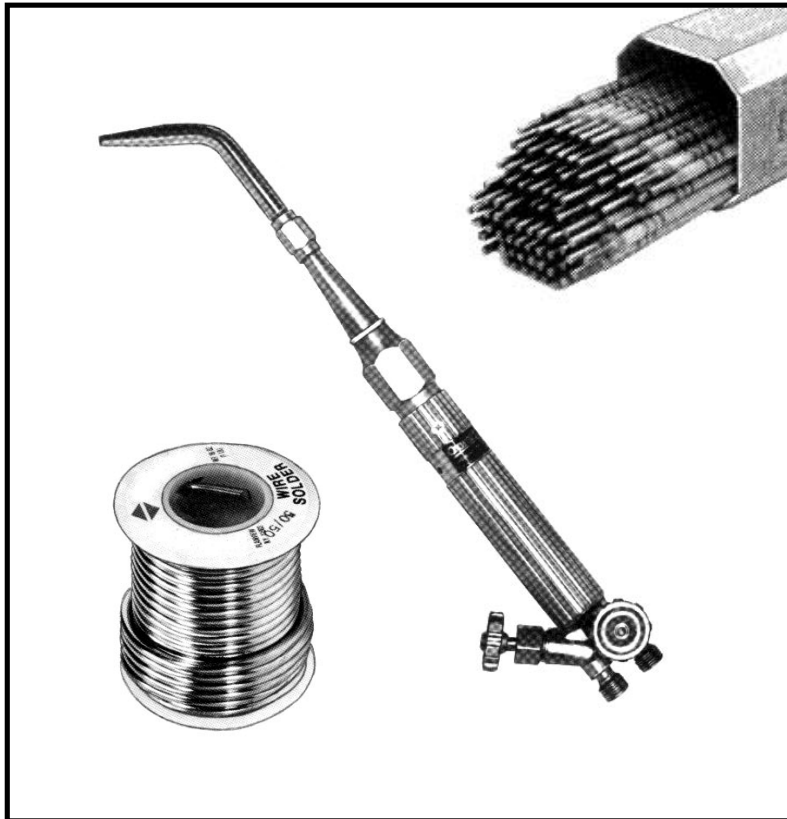
*\*Not Available in Mass-Market Retail Stores*



**P/N 8866**  
**PKG. OF 1**

**MAPP  
OR  
PROPANE**

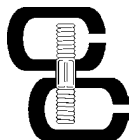
# AURALLOY<sup>®</sup> WELDING PRODUCTS



## **FEATURES:**

- **High Quality, High Purity Welding, Brazing and Soldering Supplies**
- **Engineered Specifically For the Maintenance and Repair Welder**
- **Superior Strength**
- **Full Compliment of Alloys For Most Every Common Maintenance Application**
- **Unmatched Performance and Reliability**

**AURALLOY WELDING, BRAZING AND SOLDERING PRODUCTS ARE DESIGNED FOR THE MAINTENANCE WELDER WHO GENERALLY PERFORMS REPAIRS IN LESS THAN IDEAL CONDITIONS. Overcoming the problems of welding on equipment in place or on oily, greasy or corroded materials – Auralloy products outperform the rest. Always use Auralloy to make tough repairs easy.**



**CHROMATE INDUSTRIAL CORP.**

***Quality ... Service ... Performance***

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# AURALLOY 210

RESEARCH "BLUE VELVET"

## HIGH SPEED WELDING FOR MILD STEELS



SUPERIOR STRENGTH, VERSATILITY AND EASE OF APPLICATION

**FEATURES:** Ideal for all position welding including vertical and overhead applications. Added iron powder in the coating gives this electrode increased deposition. Excellent penetration and quick solidification makes this electrode excellent for poor as well as good fit up work. Features excellent restrike characteristics, easy slag removal and excellent bead appearance.

**TECHNICAL DATA:**

Tensile Strength: 81,000 PSI Elongation: 26%  
AC-DC either polarity. All positions.

**TYPICAL APPLICATIONS:**

- Angles and Beams
- Galvanized, Painted, Rusted and Dirty Steels
- Sheet Metal
- Filling Holes

**WELDING TECHNIQUES:**

While special preparation of the base metal is not necessary, in many cases best results are obtained by first cleaning the weld area of grease, oxides or rust. Maintain a short arc. Use stringer or weave beads. When making stringer beads, a drag type technique may be used.

SIZE	3/32	1/8	5/32
AMPERAGE	80-125	110-150	140-190
PART	e 8700	e 8701	e 8702

# AURALLOY 220

RESEARCH ALL POSITION ELECTRODE FOR LOW & MEDIUM CARBON STEELS & LOW ALLOY STEELS

## HIGH STRENGTH STEEL ELECTRODE



**FEATURES:** Formulated and developed to provide non-cracking high physical properties for welding of low alloy high strength steels, including T-1, HY-80 and others. Welds pass-over-pass without chipping slag.

**TECHNICAL DATA:**

Tensile Strength: 110,000 PSI  
Elongation: 28% Hardness: B.H.N. 237  
AC or DC constant current. On DC use reverse polarity.

**TYPICAL APPLICATIONS:**

- Tanks
- Boilers
- Pressure Tubing
- Structural Steels

**WELDING TECHNIQUES:**

Clean weld area. Set amperage within recommended range for electrode size. Hold a close arc and use either stringer or weave technique. Pause momentarily over each crater before extinguishing arc.

SIZE	3/32	1/8	5/32	3/16
AMPERAGE	80-100	110-150	140-210	200-280
PART	i 8705	i 8706	i 8707	i 8708

# AURALLOY 225

RESEARCH "THUNDERBOLT"

## HIGHEST STRENGTH UNIVERSAL STEEL ELECTRODE



WELDS ALL TYPES & GRADES OF SIMILAR & DISSIMILAR STEELS INCLUDING STAINLESS

**FEATURES:**

The ultimate, multi-purpose steel welding electrode providing a superior combination of tensile strength and elongation.

**WELDING TECHNIQUES:**

Wire brush away loosely adhering metal, oxides, dirt and contaminants. Set amperage within the range prescribed for the electrode size and initiate arc. Vary amperage and arc gap up or down to suit. Use any technique from stringer bead to wide weave. Electrode lead angle is not critical — vary to suit. Self-releasing slag should be brushed away between passes.

**TYPICAL APPLICATIONS:**

- Horizontal fillet welds on all grades of construction steels.
- Welding every known grade of tool steel, including prehardened.
- Joining abrasion, heat and corrosion resistant steels.
- Welding specialized iron-base castings with high carbon content.
- Welding Tools and dies of all types.

**TECHNICAL DATA:**

Tensile Strength: 128,000 PSI Elongation: 36%  
AC or DC constant current. On DC use reverse polarity.

SIZE	1/16	3/32	1/8	5/32
AMPERAGE	30-40	40-90	70-110	90-160
PART	i 8709	i 8710	i 8711	i 8712

# AURALLOY 225-MIG

RESEARCH

## MILD STEEL WELDING WIRE ALL POSITIONS

**FEATURES:** Mild steel welding wire that contains higher levels of manganese and silicon than other standard grades of MIG wire to produce high quality welds when used on dirty, oily or rusty steel. The high silicon content increases the fluidity of the weld pool, thus creating a smoother bead appearance and resulting in minimal post-weld grinding. This wire is engineered to provide porosity-free, x-ray quality welds at the highest tensile strength (as welded) of all the plain carbon steel wires. This product requires a shielding gas: CO<sub>2</sub> and/or CO<sub>2</sub> mix.

**TYPICAL APPLICATIONS:**

- General shop applications with poor fit-up or rusty, oily plates
- Steel castings or forging salvage
- Home projects, tanks, sheet metal and construction work

**TECHNICAL DATA:**

Tensile Strength: 95,000 PSI % Elongation in 2": 25  
Welding Current: DECP (Electrode Positive, Reverse Polarity)

SPOOLED	.035
AMPERAGE	100-150
PART	a 8727

# AURALLOY 225-B

RESEARCH

## HIGH STRENGTH UNIVERSAL BARE STEEL ROD FOR TORCH AND TIG WELDING



**FEATURES:**

Excellent heat, cracking and fatigue resistance and expansion-contraction properties. Easily joins dissimilar steels while low temperature application allows thin metal joining, overlays or repairs. Produces a non-porous, crack-free deposit.

**TYPICAL APPLICATIONS:**

- Hospital Equipment
- Food/Beverage Processing Machinery
- Chemical Mixing and Storage Equip.
- Construction Equipment Repairs
- Research Laboratory Equipment
- Oil and Gas Refineries
- Marine and Aircraft Repairs
- Joining Unknown Steels

**TECHNICAL DATA:**

Tensile Strength: 128,000 PSI Elongation: 36% DC straight polarity

**WELDING TECHNIQUES FOR TIG APPLICATIONS:**

METAL THICKNESS	AMPS	TUNGSTEN DIAMETER	ARGON FLOW		HELIUM FLOW		ALLOY DIA.
			CFH	PSI	CFH	PSI	
1/8"	DC 60-90	1/16"	17	20	—	—	1/16" / 3/32"
3/16"	DC 150-180	3/32"	21	20	—	—	3/32"
1/4"	DC 170-210	1/8"	25	25	—	—	3/32"
1/2"	DC 200-250	1/8"	—	—	—	—	3/32" / 1/8"

For torch application, a small tip on an oxyacetylene torch is recommended. FLUX should be painted along the area to be joined, overlaid or repaired. Adjust flame to a near neutral stage but slightly more acetylene for best results. Hold torch close and apply drop by drop always allowing deposit to solidify under the flame to prevent oxidation. Always keep the rod under the flame so the rod end will not oxidize. Remove excess flux with water and clean with stainless steel brush.

SIZE	1/16	3/32	1/8
AMPERAGE	60-90	150-210	200-250
PART	8728	8729	8730

# AURALLOY 225-V

RESEARCH

## VERTICAL STEEL ELECTRODE



### VERTICAL POSITION HIGH STRENGTH ELECTRODE FOR DISSIMILAR STEELS

**FEATURES:**

Unique "fast-freeze" coating simplifies vertical down and up welding. Welds all steels, reducing welding rod inventory and eliminating guesswork. Exceptionally high tensile strength for added confidence in all high strength applications. Controlled weld puddle allows for filling holes and joining dissimilar steels.

**TECHNICAL DATA:**

Tensile Strength: 128,000 PSI  
Elongation: 32% Use DC Reverse Polarity or AC

**WELDING TECHNIQUES:**

The area in which the weld is to be made should be free of rust, grease, paint and other materials which cause weld contamination. A 90° vee joint should be used when joining heavy sections. Maintain a short arc length and use stringer beads.

**TYPICAL APPLICATIONS:**

- Agitators
- Air tool chucks and jaws
- Armor plates
- Augers
- Axles
- Barker drum staves
- Brake drums, shoes
- Bucket teeth
- Bulldozer frames
- Camshafts
- Castings
- Chipper knives
- Clutch plates
- Coil springs
- Collars
- Crane booms
- Crane rails
- Dies
- Draw bars
- Drills
- Forks
- Foundry racks
- Hole diggers
- Hooks
- Hubs
- Journal bearings
- Journal boxes
- Keyways
- Motor chocks
- Pinions
- Pins
- Pipes
- Propellers
- Pulleys
- Punches
- Pulverizers
- Reamers
- Rollers
- Rotor blades
- Shafts
- Shock absorbers
- Shovel buckets
- Splines
- Spokes
- Spring leaves
- Sprockets
- Thrust bearings
- Tools
- Transmission shafts
- Truck frames
- Valve seats
- Wear plates
- Wheels
- Wobblers
- Worm gears

SIZE	3/32	1/8
AMPERAGE	35-70	60-110
PART	8718	8719

# AURALLOY 230

RESEARCH

## "DIRT DEVIL"

## ADVERSE CONDITIONS MILD STEEL ELECTRODE



### HIGH TENSILE STRENGTH WELDING OF ALL COMMON MILD STEELS

**FEATURES:**

Superior all position design for welding vertical, horizontal and overhead applications. Excels on rusty, greasy poor fitting joints in all positions. Can weld through 1/2" (12mm) of surface contamination without porosity. Can bridge gaps as wide as 3/8" (9mm). Exceptional flexibility – electrode can be bent without flux chipping. Faster and easier to use – Slag can be welded over without removal.

**WELDING TECHNIQUES:**

Weld with a short-medium arc length at low amperage. When surface preparation is impractical, use a medium-long arc and favor high amperages. Multi-pass welds can be made without intermittent slag removal. Use any welding technique from stringer bead to wide weave.

**TECHNICAL DATA:**

Tensile Strength: 88,000 PSI Elongation: 28%  
DC reverse, straight or AC. All position

**TYPICAL APPLICATIONS:**

Ideally suited for difficult maintenance repairs. Easily welds steels that have been galvanized, painted, rusted or otherwise contaminated in service. Misaligned parts or difficult to access areas are also easily remedied with this electrode.

SIZE	3/32	1/8	5/32	3/16
AMPERAGE	25-75	35-125	50-160	75-200
PART	8850	8851	8852	8853

# AURALLOY 240

RESEARCH "HAMMER"

## IMPACT RESISTANT ELECTRODE

FOR JOINING AND SURFACING STEELS



**FEATURES:** Extra high strength welds that do not spall. Outwears ordinary hardfacing alloys in impact conditions as much as 10 to 1.

**TECHNICAL DATA:** Tensile Strength: 119,000 PSI  
Elongation: 41%  
Hardness: Brinell 200-520, Rockwell C10-C50  
Use DC Reverse Polarity or AC

**WELDING TECHNIQUES:** Do not pre-heat. Use the lowest possible amperage and move the electrode as quickly as feasible. Allow to cool slowly.

**TYPICAL APPLICATIONS:** For joining and repairing steel and manganese steel parts used throughout the railroad, construction and related industries.

<b>SIZE</b>	<b>1/8</b>
<b>AMPERAGE</b>	90-150
<b>PART</b>	a 8713

# AURALLOY 250

RESEARCH "STERLING"

## UNIVERSAL STAINLESS STEEL ELECTRODE

HIGH HEAT AND CORROSION RESISTANT



**FEATURES:** Provides the best combination of AC/DC weldability and deposit chemistry.

**WELDING TECHNIQUES:** Deposit at low amperage, holding a close arc. Stringer beads are preferred, but the electrode can be weaved up to three times, if the application requires. For filletting, raise amperage 10% and drag electrode, maintaining light pressure. Backwhip craters and remove slag between passes.

**TECHNICAL DATA:** Tensile Strength: 95,000 PSI  
Elongation: 45% AC-DC reverse polarity

**TYPICAL APPLICATIONS:** Furnace parts including baffle plates, chain links and guides, woven belts and associated hardware. All types of stainless castings, both non-magnetic and magnetic. Crucible tongs, plating baskets and hooks, retorts, vats and other chemical processing components.

<b>SIZE</b>	<b>1/16</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>
<b>AMPERAGE</b>	30-60	60-90	90-120	120-160
<b>PART</b>	a 8714	g 8715	i 8716	i 8717

# AURALLOY 250-B

RESEARCH

## UNIVERSAL STAINLESS STEEL BARE ROD

FOR TORCH AND TIG WELDING



**FEATURES:** Easy to work stainless steel wire with superior corrosion resistant deposits. Excellent strength, impact and abrasion-resistant qualities.

**WELDING TECHNIQUES:** For torch application, clean area of grease and dirt. Apply Flux to repair area. Use slightly excess flame. Keep torch in motion to uniformly heat area. As flux liquifies, hold torch close. Add alloy to joint drop by drop.

**TECHNICAL DATA:** Tensile Strength: 86,000 PSI

**TYPICAL APPLICATIONS:**

- Chemical Mixing and Storage Equipment
- Food and Beverage Processing Machinery
- Marine and Aircraft Repairs
- Research Laboratory Equipment
- Oil and Gas Refineries
- Hospital Equipment

<b>SIZE</b>	<b>1/16</b>	<b>3/32</b>	<b>1/8</b>
<b>PART</b>	i 8740	i 8741	i 8742

# AURALLOY 255

RESEARCH "CASCADE"

## SPECIAL VERTICAL POSITION STAINLESS STEEL ELECTRODE

HIGH HEAT AND CORROSION RESISTANCE



**FEATURES:** Superior combination of AC/DC weldability and deposit chemistry provides smoother deposits with minimum susceptibility to carbide precipitation and cracking. Faster and easier to use with fast deposition rate, no spatter and easy slag removal.

**TYPICAL APPLICATIONS:** Especially suited for vertical down and up welding of thin to medium gauge molybdenum bearing stainless steels. Furnace parts including baffle plates, chain links and guides, woven belts and associated hardware. All types of stainless castings, both non-magnetic and magnetic. Crucible tongs, plating baskets and hooks, retorts, tanks, pipe, tubing, vats and other chemical processing components. Pumps, valves and fittings. Heat exchangers and heat treating boxes.

**TECHNICAL DATA:** Tensile Strength: 80,000 PSI  
Elongation: 42%  
Use DC Reverse Polarity or AC

**WELDING TECHNIQUES:** For vertical welding, set amperage at high end of the scale. Maintain a sharp angle with the electrode pointing upward. Whip the electrode quickly back and forth while moving up or down. Electrode may show a red color from the excess amperage which is normal.

<b>SIZE</b>	<b>3/32</b>	<b>1/8</b>
<b>AMPERAGE</b>	60-80	90-110
<b>PART</b>	i 8737	i 8738

# AURALLOY 300

RESEARCH "MIDNIGHT"

## FULLY MACHINABLE CAST IRON ELECTRODE



HIGHEST QUALITY ELECTRODE FOR JOINING ALL GRADES OF CAST IRON

**FEATURES:**

State-of-the-art coated electrode for welding every known grade of cast iron, heavy or thin, and for joining these to steel.

**TYPICAL APPLICATIONS:**

All grades 30, 40 and 50 gray cast irons in all thicknesses and all positions. All alloy cast irons — ductile, nodular (spheroidal graphitic iron), malleable, meehanite. Engine blocks, diesel heads, gear boxes, transmission housings, differentials, machine bases and presses.

**TECHNICAL DATA:**

Tensile Strength: 70,000 PSI Elongation: 40%  
Use AC or DC. On DC use reverse polarity.

**WELDING TECHNIQUES:**

Remove loosely adhering material. Searing of surface is highly recommended. Cracks should be beveled after piercing holes at either end to prevent propagation. Preheat is not required unless casting is unusually thick. Adjust amperage and deposit beads approximately 2" long. Skip and stagger to suit. Remove slag between passes. Linger momentarily over final crater before extinguishing the arc.

SIZE	3/32	1/8	5/32
AMPERAGE	50-80	70-110	100-140
PART	i 8720	i 8721	i 8722

# AURALLOY 310

RESEARCH

## NON-CONDUCTIVE FLUX COATED CAST IRON ELECTRODE



HIGHEST QUALITY ELECTRODE FOR JOINING ALL GRADES OF CAST IRON

**FEATURES:**

State-of-the-art non-conductive flux coated electrode for welding every known grade of cast iron, heavy or thin, and for joining these to steel.

**TYPICAL APPLICATIONS:**

All grades 30, 40 and 50 gray cast irons in all thicknesses and all positions. All alloy cast irons — ductile, nodular (spheroidal graphitic iron), malleable, meehanite. Engine blocks, diesel heads, gear boxes, transmission housings, differentials, machine bases and presses.

**TECHNICAL DATA:**

Tensile Strength: 55,000 PSI Use AC or DC. Reverse polarity.

**WELDING TECHNIQUES:**

Remove loosely adhering material. Searing of surface is highly recommended. Cracks should be beveled after piercing holes at either end to prevent propagation. Preheat is not required unless casting is unusually thick. Adjust amperage and deposit beads approximately 2" long. Skip and stagger to suit. Remove slag between passes. Linger momentarily over final crater before extinguishing the arc.

SIZE	3/32	1/8
AMPERAGE	60-90	85-120
PART	i 8746	i 8747

# AURALLOY 320

RESEARCH "BLACK BEAUTY"

## COPPER CLAD "TRI-METAL" CORED CAST IRON ELECTRODE



PROPRIETARY COPPER-NICKEL-IRON DEPOSIT CHEMISTRY

**FEATURES:**

Unique copper plated core wire provides unequalled cast iron welding performance. High efficiency weld metal transfer eliminates electrode overheating. Ultimate combination of softness, ductility and tensile strength for ease of use and maximum stress relief.

**TYPICAL APPLICATIONS:**

The high deposition rate of this electrode creates an extremely narrow heat affected zone. This feature is suitable for all weldable cast irons that require posts weld machining.

**TECHNICAL DATA:**

Tensile Strength: 77,000 PSI Elongation: 15%  
DC Reverse (+) or AC. Flat, Vertical Up, Horizontal, Overhead

**WELDING TECHNIQUES:**

Guide the electrode at a steep angle keeping the arc length short. Use short staggered beads when welding restrained parts.

SIZE	3/32	1/8	5/32
AMPERAGE	50-70	70-100	100-130
PART	e 8855	e 8856	e 8857



# AURALLOY 400

RESEARCH "TURBO"

**NEW  
IMPROVED**  
25% stronger blast  
than any other  
chamfering/cutting  
electrode

## CUTTING, GROOVING AND CHAMFERING ELECTRODE

FOR RAPID METAL REMOVAL ON CAST IRON, STAINLESS, INCONEL, MANGANESE AND ALUMINUM

**FEATURES:**

The fastest, most economical method of removing unwanted metal. Uses a common welding machine to save hours of grinding and machining time. Extra deep cut, easy restrike and 20% less smoke.

**TYPICAL APPLICATIONS:**

Dismantling welded structures such as towers, sign supports, and pipe piles. Use for blowing out rivets and for removing old weld overlays on railroad frogs, cross-overs and switches. Ideal for preparing work hardened or heat-treated dies for welding.

**TECHNICAL DATA:**

AC-DC straight polarity

**WELDING TECHNIQUES:**

Point electrode in direction of travel and initiate arc. For a shallow chamfer, move electrode quickly along line of cut. A slower or weaving motion provides deeper groove. The molten metal is pushed ahead as the chamfer is made. For deeper grooves, repeat until the required depth is achieved.

SIZE	3/32	1/8	5/32
AMPERAGE	130-200	160-300	180-400
PART	L 8724	L 8725	L 8726

# AURALLOY 500

RESEARCH

## SUPER STRENGTH SELF-FLUXING SILVER SOLDER

95% TIN 5% SILVER FLUX-CORED SOLDER ALLOY WITH OUTSTANDING STRENGTH

**FEATURES:**

Fast, easy high strength deposits with solder gun, iron or torch. Melts at a low 430°F, eliminating distortion and weakening of base melt. Conductivity 25% greater than ordinary solders. Contains no lead, cadmium or zinc for safe use and compliance with all pure food laws. Available in 1/2 lb and 1 lb spools or in convenient, pocket-size dispenser.

**TECHNICAL DATA:**

Tensile Strength: 15,000 PSI

**TYPICAL APPLICATIONS:**

- Food and Beverage Containers
- Toilet Fixtures
- Sanitary Equipment
- A/C and Refrigeration
- Auto Radiators
- Evaporators
- Regulators and Meters
- Machine Guides
- Chrome Plated Fittings
- Electrical Connections
- Toy and Hobby Repair

SIZE	1/32	1/16	1/16	1/16	1/8	1/8
WEIGHT	.6 oz. Disp. Tube	1.0 oz. Disp. Tube	1/2 lb. Spool	1 lb. Spool	1/2 lb. Spool	1 lb. Spool
PART	F 8781	F 8780	A 8776	A 8775	A 8779	A 8778

# AURALLOY 600

RESEARCH "WHITE LIGHTNING"

## ALL POSITION ALUMINUM ELECTRODE

FOR JOINING AND METAL BUILD-UP OF ALL WELDABLE GRADES OF ALUMINUM

**FEATURES:**

Universal electrode for welding all cast, wrought and extruded aluminum and aluminum alloys.

**WELDING TECHNIQUES:**

Remove oil and grease and sand immediate weld area. Chamfer edges of plates to be joined and open up cracks. Make holes to be filled wider at the top. Preheat heavy sections broadly. In thick-to-thin joining, preheat heavier member. Use any conventional DC coated electrode power source-rectifier type of motor or engine driven generator. Adjust for upper end of recommended amperage range and reduce as welding progresses.

**TECHNICAL DATA:**

Tensile Strength: 34,000 PSI Use DC current. Reverse polarity.

**TYPICAL APPLICATIONS:**

- Truck beds, bodies and frames
- Pipe railings, bannisters, stairs, diamond plate
- Irrigation piping
- Engine and motor blocks
- Traffic light bases, highway signs and supports
- Loading ramps and docks
- Door/window frames
- Transmission housings and gear boxes
- Machine bases and supports
- Bus bars, electrical switch boxes and mounts

SIZE	1/8	5/32
AMPERAGE	70-110	100-150
PART	e 8731	e 8732



## HIGH STRENGTH FLUX-CORED ALUMINUM BRAZING ALLOY

### GENERAL PURPOSE TORCH BRAZING OF ALL WELDABLE ALUMINUM

**FEATURES:**

A specially engineered alloy with flux core center for faster, easier joining of all aluminum and aluminum alloys. Provides deep penetration in tight joints. Excellent for out of position brazing and build-up deposits.

**TYPICAL APPLICATIONS:**

- Motor Housings
- Tools
- Tanks
- Vats
- Ladders
- Utensiles
- Rails
- Beverage Cases
- Pulleys
- Sheaves

**TECHNICAL DATA:**

Tensile Strength: 30,000 PSI

**WELDING TECHNIQUES:**

Clean weld area, removing plating or anodized finish. Leave gap approximately 1/6". For thicker parts, cracks or butt joints, bevel a 60° to 70°vee. Use a carburizing flame (excess acetylene with oxygen) and heat work with flame 1" to 3" from surface. Touch rod to weld area depositing small amounts of alloy and allow to flow out and bond to base metal.

<b>SIZE</b>	<b>1/8</b>
<b>PART</b>	8745



## EASY-FLOW ALUMINUM ALLOY WIRE

### FOR JOINING, FABRICATING AND REPAIRING OF MOST ALUMINUM GRADES

**FEATURES:**

Provides exceptional strength and ductility for general purpose joining, fabricating and repairing of most aluminum grades. Minimum preparation and low melt (950° - 1010° F) for ease of application. Thin flowing for tight fits. Perfect color match.

**TECHNICAL DATA:**

Tensile Strength: 35,000 PSI  
For torch or tig welding.

**TYPICAL APPLICATIONS:**

- Poles
- Frames
- Bus Bars
- Sign Posts
- Guard Rails
- Furniture
- Structural Parts
- Housings

**WELDING TECHNIQUES:**

Clean joint with wire brush removing grease and oxides. Apply Auralloy 620 Flux. Using excess acetylene (carburizing) flame, keep torch in constant motion to uniformly heat area. When flux turns to clear liquid, start adding alloy to the joint.

<b>SIZE</b>	<b>1/16</b>	<b>3/32</b>	<b>1/8</b>
<b>PART</b>	8750	8751	8752



## EZ-WELD ALUMINUM ALLOY

### BRAZING ROD FORMULATED FOR HIGH STRENGTH FABRICATION AND ALUMINUM REPAIR

**FEATURES:** Joints stronger than parent metal. Easy machining of welded areas. Non-corrosive joints. Low heat requirement (propane torch application). Superior strength and adhesion provides permanent seal and strength when subjected to extreme pressure. Contains no lead or cadmium.

**TYPICAL APPLICATIONS:** AUTOMOTIVE: Radiators, manifolds, transmission housings, pump housings, carburetors, motorcycles, running boards, mobile homes, recreational vehicles. TRADES: Plumbing, heating and A/C, power tools, farm equipment, storm shutters, screen enclosures, satellite dishes, sign companies, aluminum awnings, gutters and down spouts. MARINE: Hulls, leaking rivets, props, brass & bronze fittings, engine parts. HOUSEHOLD: Lawn furniture, doors/windows, bicycles, fishing rods, antiques.

**WELDING TECHNIQUES:** Clean the surface with a stainless steel brush. Heat the parent metal surface, NOT the E-Z Weld Aluminum Alloy. Apply the E-Z Weld to the heated surface. Keep flame in motion. Allow weld to air-cool naturally. Never plunge into water.

**TECHNICAL DATA:**

Tensile Strength (lbs./sq. inch): 47,000 PSI  
Melting Range: 715°F - 730°F  
Density: 25  
Elongation: 3%  
Compression Strength (lbs./sq. inch): 60-75,000  
Shear Strength (lbs./sq. inch): 34,000  
Electrical Conductivity: 24.9% of cu  
Impact Strength: (Charpy) 4 ft. lbs. to break 1/4" bar  
Thermal Conductivity: .24 cal/cu.cm  
Hardness: (Brinell 100)  
Corrosion Penetration: 300 x 10 in 11-R  
Ductility: Good

<b>SIZE</b>	<b>1/8</b>
<b>PART</b>	8733 (includes stainless steel wire brush P/N 41340)

# AURALLOY 710

RESEARCH "PINK CADILLAC"

## PREMIUM FLUX COATED SILVER BRAZING ALLOY



### PRECISE THIN FLOW JOINING OF ALL FERROUS AND MOST NON-FERROUS METALS

**FEATURES:**

High 56% silver, cadmium-free formulation provides the ultimate strength for joining all ferrous and most non-ferrous metals. Low working temperature (1120°F to 1185°F) for excellent flowing action and adhesion. Super active, fast-flowing flux coating provides twice the base metal cleansing action of conventional silver flux coatings. Cleans the most oxidized stainless steel surfaces to promote rapid wetting action. Superior performance flux coating is totally flexible and chip resistant.

**TECHNICAL DATA:**

Tensile Strength: 71,000 PSI  
 Elongation: 25%  
 Melting Temperature: 1120°F Solidus, 1200°F Liquidous

**TYPICAL APPLICATIONS:**

All ferrous and non-ferrous metals, except aluminum and magnesium. Manufacturing and repairing of all food and beverage equipment. Thin flow joints on aerospace and aircraft applications. Color matching on stainless steel and nickel. Carbide tipping. Joining medical tools and instruments. Hospital carts and equipment.

<b>SIZE</b>	<b>1/16 x 18" PINK FLUX</b>		
<b>PART</b>	i		8786

# AURALLOY 800

RESEARCH "RUBY"

## FLUX-COATED NICKEL SILVER ALLOY



### HIGH STRENGTH ABRASION-RESISTANT BUILD-UP OF FERROUS AND NON-FERROUS METALS

**FEATURES:**

For oxyacetylene welding of hot or cold rolled steel, tool steel, stainless steel, high carbon steel, cast iron, malleable iron, all alloys of the bronze, copper and nickel family and dissimilar metals (not white metals). Extremely versatile brazing rod with low melt (bonds at approximately 1450°F) and thin flowing for tight fits. Excellent for rapid build-up deposits for cladding or replacing missing metal. Tough, wear-resistant deposits (150-200 BHN) for strong, non-porous, lasting welds. Highly machinable with minimum preparation for rusty, dirty parts.

**TECHNICAL DATA:**

Tensile Strength: 100,000 PSI

**TYPICAL APPLICATIONS:**

Joining and fast build-up of metals and filling holes in steel and cast iron. Ideal for drive shafts, friction plates and gear teeth.

<b>SIZE</b>	<b>3/32</b>		<b>1/8</b>	
<b>PART</b>	i	8755	i	8756

# AURALLOY 810

RESEARCH

## SELF-FLUXING, NON-FUMING STEEL WIRE



### GENERAL PURPOSE JOINING OF STEEL SHEETS, PLATES AND PIPE OF LOW CARBON ANALYSIS

**FEATURES:**

A versatile mild steel bare rod for gas or tig brazing. Copper metallic coating inhibits rust and improves weldability. Provides a dense, smooth, even bead with no weld porosity. Can be used in all positions and is easily machined, filed or sanded. No flux is required for tig or gas brazing.

**TYPICAL APPLICATIONS:**

- Tanks
- Shafts
- Vats
- Machinery Guards
- Hoods
- Brackets
- Frames
- Wire Mesh
- Sheet Metal

**WELDING TECHNIQUES:**

Clean joint area to remove grease, paint, rust, dirt or moisture. Keep neutral flame in constant motion on the repair area. Add alloy to joint insuring weld bead has complete penetration of the joint. No flux is required.

**TECHNICAL DATA:**

Tensile Strength: 70,000 PSI

<b>SIZE</b>	<b>1/16</b>	<b>3/32</b>	<b>1/8</b>
<b>PART</b>	i 8760	i 8761	i 8762

# AURALLOY 820

RESEARCH

## HIGH STRENGTH THIN FLOWING BRONZE BRAZING ALLOY

FOR EASY BRAZING OF COPPER, COPPER ALLOYS, BRONZE, BRASS AND NICKEL ALLOYS

**FEATURES:**

Ideal for joining and repairing thin sheet metal, tubing and fittings of non-ferrous metals. Self-fluxing on copper to copper applications. Ductile deposits withstand vibration. High electrical and heat conductivity. Easily machined. Strong corrosion and wear properties.

**TYPICAL APPLICATIONS:**

- Refrigeration
- Copper Wire and Cable
- Bus Bars
- Electrical Contacts
- Piping
- Air Conditioning
- Plumbing
- Marine Equipment

**TECHNICAL DATA:**

Tensile Strength: 46,000 PSI  
Working Temperature: 1300°F to 1460°F

**WELDING TECHNIQUES:**

Clean joint area to remove grease and dirt. Use a slightly oxidizing flame and keep flame as low as possible to obtain a free-flowing bead. On copper to copper welds, no flux is required. Use Auralloy 825 Flux for other materials. All joints should be tight fitting. As flux liquifies, melt off a small amount of alloy and continue heating until bonding is complete. Do not overheat. Remove excess flux with water and a clean brush.

SIZE	1/16	3/32	1/8
PART	i 8765	i 8766	i 8767

# AURALLOY 830

RESEARCH

## HIGH STRENGTH SILICON BRONZE BRAZING ALLOY

ALL POSITION JOINING OF COPPER, COPPER-SILICON AND COPPER-ZINC BASED METALS

**FEATURES:**

Joins copper, copper-silicon and copper-zinc based metals to themselves or to mild or galvanized steel. Highly corrosion resistant. Eliminates "burn-through" on galvanized coatings. Ideal for dissimilar metal applications. Suitable for thin flow or bead forming deposits. Non-fuming.

**WELDING TECHNIQUES:**

Clean joint area to remove grease and dirt. Use Auralloy 825 Flux. With a slightly oxidizing flame, heat work until flux liquifies. Keep weld puddle small to assure rapid solidification and to avoid contraction strains. Remove flux residue with hot water and a clean stiff brush.

**TECHNICAL DATA:**

Tensile Strength: 64,000 PSI  
Working Temperature: 1450°F to 1600°F

**TYPICAL APPLICATIONS:**

- Galvanized Parts
- Castings
- Marine Repairs
- Joints and overlays on steel, copper, brass, bronze, naval brass and galvanized sections
- Valves and Seats
- Tubing
- Fittings

SIZE	1/16	3/32
PART	i 8770	i 8771

# AURALLOY 840

RESEARCH "SAPPHIRE"

## "SAFE VUE" MOISTURE SEALED FLUX COATED TRIPLE DEOXIDIZED BRONZE BRAZING ALLOY

FOR EASY BRAZING OF STEEL CAST IRON AND COPPER BASE ALLOYS

**FEATURES:**

Unique "Safe Vue" flux coating eliminates harsh chemical odors and the bright orange visibility blocking glare of conventional sodium type flux coatings. Slick, smooth moisture sealed flux has triple the shelf life of similar products. Flux cleansing action is exceptional on dirty steels and cast irons. Can braze copper base alloys without melting base. No cracking – totally flexible coating.

**TYPICAL APPLICATIONS:**

Bearings, bushings, cams, cast iron, carbide tipping, chain saws, drills, jig and fixtures, levers, linkage, piping, racks and shaft repair.

**TECHNICAL DATA:**

Tensile Strength: 71,000 PSI  
Working Temperature: 1595°F

**WELDING TECHNIQUES:**

Clean joint area to remove grease and dirt. Pre-heat general area to 700°F (400°C) and then specific area to 1200°F (650°C). Melt off flux and apply alloy.

SIZE	1/16	3/32	1/8
PART	i 8860	i 8861	i 8862

# AURALLOY 900

RESEARCH "GRANITE"

## HARD SURFACING ELECTRODE



### SUPERIOR IMPACT AND ABRASION RESISTANCE

**FEATURES:** A truly unique electrode combining unsurpassed weldability plus super impact and abrasion resistance and high hardness. It is the ideal alloy combination where hardness and toughness are required on carbon and alloy steels, manganese steels and cast iron.

**TECHNICAL DATA:**

Hardness: RC 56-60  
Use any AC or DC coated electrode power sources.  
On DC use reverse polarity.

**TYPICAL APPLICATIONS:**

Crusher jaws, hammers, bucket lips and teeth. Wear plates, pins, axles, shafts, cams, eccentrics.

**WELDING TECHNIQUES:** Prepare weld surface by chamfering to remove old overlays and loosely adhering metal. Use a cushion, if required. Deposit the electrode using any technique applicable such as stringer beading or weaving up to 4X. Allow each layer to cool somewhat before continuing. Remove slag between passes.

SIZE	1/8	5/32
AMPERAGE	80-135	120-160
PART	8735	8736

# AURALLOY 910

RESEARCH

## HARD FACING CHROMIUM CARBIDE TUBULAR ELECTRODE



### FOR APPLICATIONS SUBJECT TO HIGH ABRASION, COMPRESSIVE IMPACT LOADS AND EROSION

**FEATURES:** For manual application to large parts where deposition rate and job completion times are paramount. Easy to use and offers the greatest range of carbide bearing alloys to overcome a great variety of wear caused by abrasion, erosion, impact and heat. Designed for all position welding and can be used at low amperature to hardface thin edges on tillage tools and similar parts. A proprietary coating formulation is completely moisture-resistant and will survive storage in damp conditions for years. Can be applied to cast iron, manganese steel and mild steel without preheat; high carbon and alloy steels may require preheat.

**TECHNICAL DATA:**

Hardness: RC 55-60  
Use with either AC or DC welding power sources.  
Amperage: 70-125

**TYPICAL APPLICATIONS:** Ideal for hardfacing parts made from austenitic manganese steel. Dredge bucket lips, crusher jaws, crusher mantles and liners, manganese steel swing hammers, quarry screen plates, grizzly bars and feeder spots, and shovel buckets.

SIZE	1/4 x 18"
PART	8739

# AURALLOY

RESEARCH

## HOLD-IT™ JIGGING / HEAT DAM PUTTY

- HOLDS PARTS FIRMLY IN PLACE FOR "HANDS FREE" WELDING, BRAZING AND SOLDERING
- PROTECTS MATERIAL SURFACES FROM HEAT
- ELIMINATES HEAT DAMAGE SUCH AS BUCKLING, WARPING, DISTORTION AND DISCOLORATION
- WITHSTANDS TEMPERATURES OF 3,000°F
- MAINTAINS SHAPE WHEN HEATED
- USE ON ANY HORIZONTAL, VERTICAL OR OVERHEAD SURFACE



**DIRECTIONS:** Apply a thin layer of Hold-It™ putty, covering the entire area to be protected. In extreme heat, use a thicker covering. If surface is affected by moisture, use a sheet of impervious plastic as a barrier and then apply Hold-It™ putty. When using as a jiggling putty, treat each part to be held separately by placing in individual mounds of putty. Wipe off and clean with water.

SIZE	2 LB. CONTAINER
PART	A 8800

# AURALLOY

RESEARCH

## BRAZING/ SOLDERING FLUXES

**500 FLUX: LIQUID SOLDERING** – For difficult soldering applications. Especially active for use on stainless related alloys. Non-fuming. Completely water soluble. Use with Auralloy 500 Silver Solder when additional flux is required.

**620 FLUX: ALUMINUM BRAZING (POWDER)** – Becomes active well below the melting temperature of the aluminum and produces maximum flow of the brazing alloy. Easy to use as a powder or paste with Auralloy 620 aluminum brazing rods.

**700 FLUX: SILVER BRAZING (LIQUID)** – Dissolves surface oxides and protects joint area to improve bonding and wetting action of all silver brazing wires. Particularly useful when joining stainless steel and high alloy steels. When additional power is required use with Auralloy 700 silver brazing rods.

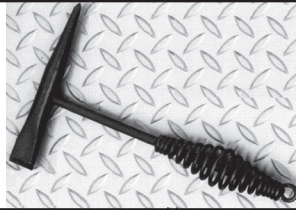
**825 FLUX: GENERAL PURPOSE (LIQUID PASTE)** – "Wide Range" brazing flux designed to improve results when joining cast iron, malleable iron, copper, brass, bronze and steel. For use in applications not requiring specialized fluxes.

	500 FLUX	620 FLUX	700 FLUX	825 FLUX
SIZES	1 Pint Bottle	6 oz. Jar	1 lb. Jar	8 oz. Jar
PART	A 8787	A 8790	A 8796	A 8798

# AURALLOY ACCESSORIES

## WELDER'S CHIPPING HAMMER

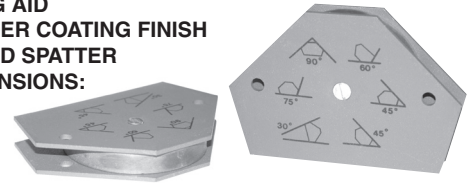
- SOLID STEEL
- SHARP 1" BLADE ON ONE END, TAPERS TO A POINT ON THE OTHER END
- COIL SPRING HANDLE FOR SHOCK AND HEAT DISSIPATION
- RUST RESISTANT, BLACK OXIDE FINISH



BLADE	LENGTH	HEAD WEIGHT	PART
Horizontal	10*	16 oz.	A 8867
Vertical	10*	16 oz.	A 8868

## WELDING MAGNET

- MULTIPLE ANGLES: 30°, 45°, 60°, 75° and 90°
- IDEAL WELDING AID
- SPECIAL POWDER COATING FINISH TO RESIST WELD SPATTER
- OVERALL DIMENSIONS: 3-3/4 X 2-1/2



DESCRIPTION	PART
Multi-Angle Clamping Welding Magnet	A 8869

## SUREFIRE® PROPANE TORCH

- DESIGNED FOR PROFESSIONAL USE\*
- IGNITES AUTOMATICALLY
- INSTANT ON – INSTANT OFF!
- NO MATCHES!
- VARIABLE FLAME ADJUSTMENT
- TRIGGER LOCK PROVIDES CONTINUOUS BURNING
- IGNITES AND BURNS UPSIDE DOWN
- 3400°F AT TIP – BRAZE AND SOLDER COPPER PIPE, LIGHT STEEL AND SHEET METAL
- PRESSURE REGULATOR PROVIDES EVEN FLOW OF GAS IN ALL POSITIONS
- SAFE AND EASY TO USE



\*Not available in mass-market retail stores

DESCRIPTION	PART
Surefire® Self-Igniting Propane or Mapp Torch	A 8866

## MAP-PRO™ GAS CYLINDER

- FOR BRAZING, WELDING OR SOLDERING – BURNS HOTTER THAN PROPANE
- CYLINDER HAS 1" - 20 THREADED FUEL OUTLET VALVE THAT FITS ALL STANDARD PROPANE TORCHES
- NON-REFILLABLE CYLINDER MEETS DOT 39 SPECIFICATIONS
- 14.1 OZ.



DESCRIPTION	PART
MAP-Pro™ Gas Cylinder, 14.1 oz.	A 8874

## SOLDER PRO 180™

- EQUIVALENT TO A 185-WATT SOLDERING IRON AND 2500°F TORCH
- POWERED BY PATENTED REFILLABLE LIQUID ENERGY CELL (LEC)
- COMES WITH 3.4MM CHISEL SOLDERING TIP AND BLOW TORCH HEAD, 2 LECs
- SAFELY TRAVELS ANYWHERE WITHOUT HAZARD
- CORDLESS, SIMPLE AND SAFE TO OPERATE IN ALMOST ANY CONDITION
- READY TO USE IN 30 SECONDS AFTER IGNITION
- TIPS CHANGE IN SECONDS FOR SOLDERING GUN, TORCH OR HOT AIR BLOWER
- REMOVABLE LEC™ CONTAINS POWER FOR UP TO 120 MINUTES
- RECHARGE FROM BUTANE FUEL AVAILABLE ALMOST ANYWHERE
- FREE STANDING – DOES NOT REQUIRE SEPARATE STAND

### SPECIFICATIONS:

Length w/soldering tip ... 203mm (8in)  
 Weight (with LEC™) ..... 560 g  
 Approximate temp. .... 250-550°C  
 soldering tip (480-1000°F)  
 Torch ..... 1300°C (2500°F)  
 Gas container capacity . 40 ml  
 Operating Time ..... 100 min @  
 (one gas filling) mid setting



DESCRIPTION	PART	TIP STYLE	PART	TIP STYLE	PART
Solder Pro 180™ with LEC™ Power Technology	A 8842	Heat Blower	A 8842PS70	Deflector	A 8842PS80

# AURALLOY ACCESSORIES

## EXCALIBER BUTANE SOLDER / TORCH KIT

- BUTANE POWERED, SELF-IGNITING, PORTABLE, MULTI-FUNCTION HEAT TOOL
- 30W TO 100W POWER RANGE
- AUTOMATIC PIEZO IGNITION
- COMPLETE PORTABILITY
- COMFORTABLE GRIP
- RAPID TIP HEAT-UP
- COMPLETE WITH:  
5 TIPS – CONICAL, HOT KNIFE, HEAT BLOWER, REFLECTOR,  
PLUS 2 SPECIALTY SOLDER TIPS, 17 GRAM TUBE 60/40 SOLDER,  
COOLING/CLEANING SPONGE AND HEAVY DUTY ULTRA-BOX

### SPECIFICATIONS:

Approximate Temperatures:	
Soldering Tip .....	250-500°C (480-950°F)
Torch.....	1300°C (2400°F)
Hot Knife.....	200-350°C (400-660°F)
Heat Blower .....	250-500°C (480-950°F)
Gas Container Capacity .....	15 grams
Operating Time (one gas filling).....	70 min at mid-setting



P/N 8843

DESCRIPTION	PART
EXCALIBER BUTANE SOLDER / TORCH KIT	A 8843

## SOLDER GUARD - DESIGNED FOR SOLDERING & BRAZING USING PROPANE & MAPP GAS

### Features

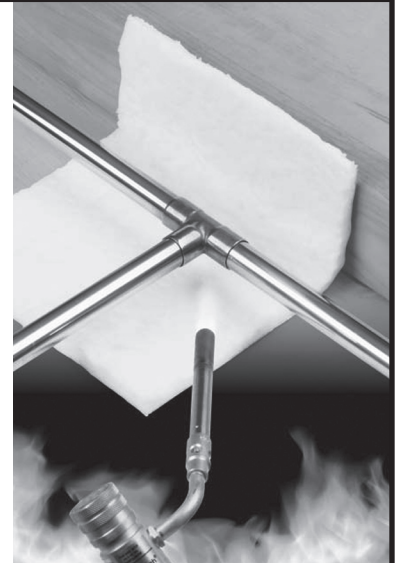
- Protects wood, painted, or metal surfaces from the heat and flame of a torch
- You can't buy a more durable or longer lasting, flexible heat & flame protective product
- Belongs on every service truck, in every tool box, and at every work bench

### Benefits

- Don't burn – always use the Solder Guard
- Non-asbestos
- No smoke & no odor
- Reusable over and over again
- Recommended for use with today's new higher temperature, lead-free solders

### Applications

- Plumbing
- Heating
- Maintenance
- Air conditioning
- Refrigeration
- Fire sprinkler
- Commercial, Industrial, Residential, Institutional



DESCRIPTION	PART
SOLDER GUARD – 9" x 12"	A 66370



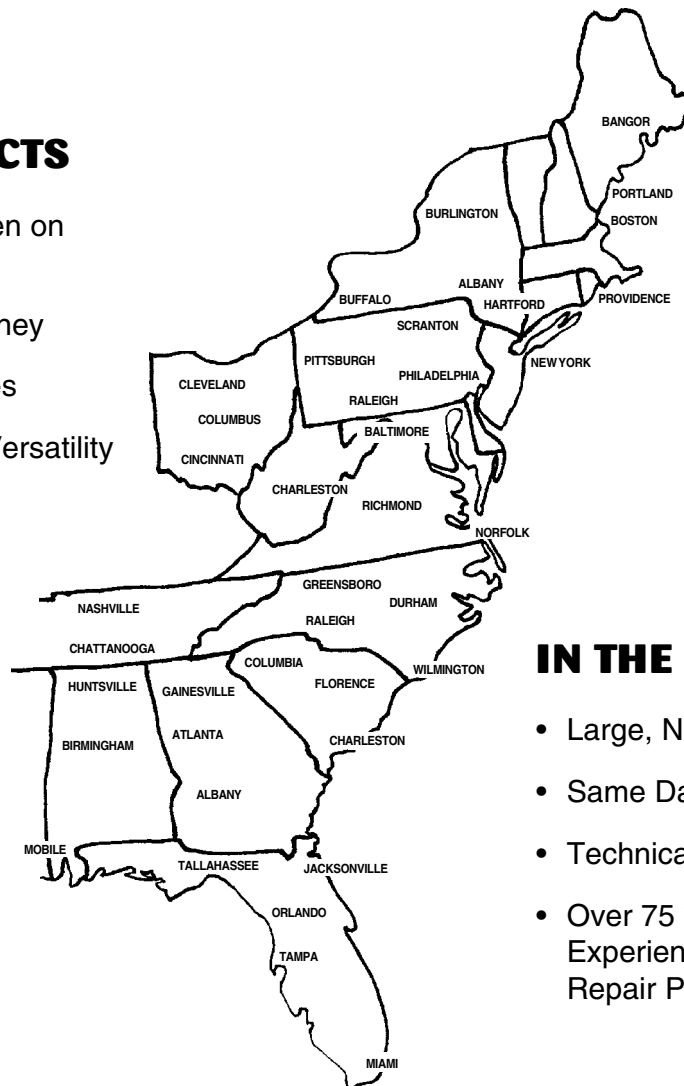


# AURALLOY RESEARCH

## SUPERIOR PERFORMANCE WELDING PRODUCTS DESIGNED TO SOLVE THE MAINTENANCE AND REPAIR WELDERS PROBLEMS

### AURALLOY PRODUCTS

- Make Welding Easier, Even on Inadequate Equipment
- Saves Your Company Money
- Eliminate Large Inventories
- Provide the Quality and Versatility to Reduce Down-Time
- Solves YOUR Problems



### IN THE EAST

- Large, Nearby Inventories
- Same Day Shipments
- Technical Service Support
- Over 75 Years Combined Experience with Welding Repair Problems

# AURALLOY

**QUALITY, SIMPLICITY AND SERVICE THAT WILL PUT MAINTENANCE  
AND REPAIR POWER BACK IN YOUR SHOP — NOW!**

## **Auralloy improves the ability of mechanics with limited welding experience and enables the highly skilled welder to do an even better job by:**

- Welding metals of **unknown analysis**
- Welding through **Paint, Rust, Grease** and **Oil** when cleaning is normally required
- Welding **without Pre-Heat** in most applications
- **Salvaging** expensive parts that are now being scrapped
- **No Guesswork**, the right rod for the job everytime

## **Our customers benefit from Auralloy's performance with:**

- Reduced Downtime
- Extended Repair Life
- Increased Performance
- Ease of Application
- Decreased Costs, by eliminating duplication.



**WHAT DO WE MEAN BY DUPLICATION?**

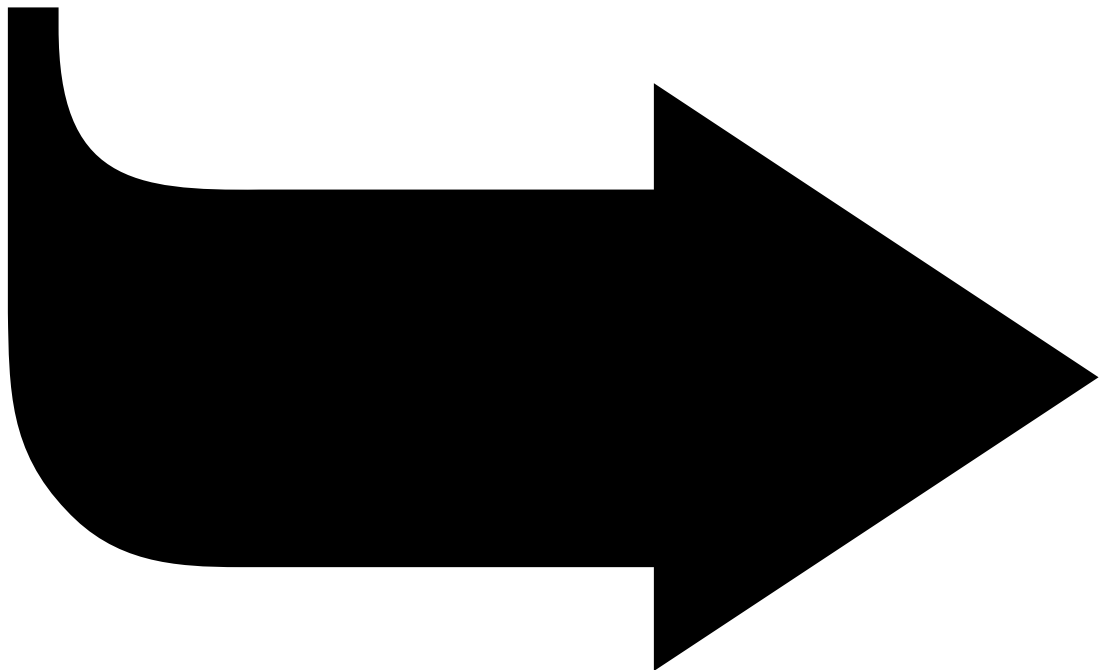
# THE AURALLOY ADVANTAGE

When you compare the products offered by production welding rod manufacturers, you will find that they each offer up to four products, with different numbers or colors that are meant to do the same job. This is **DUPLICATION**, and results in overstock. Auralloy provides you with one product that replaces all four, eliminating the excessive dollar waste. To further illustrate our point, compare and save money.

<b>AURALLOY 210</b>				<b>PRODUCTION RODS</b>			
<b>MILD STEEL ELECTRODE 80,000 PSI</b>				<b>MILD STEEL ELECTRODE</b>			
210 3/32 20 Lbs.	210 1/8 20 Lbs.	210 5/32 20 Lbs.	210 3/16 20 Lbs.	6010 3/32 60 Lbs.	6010 1/8 60 Lbs.	6010 5/32 60 Lbs.	6010 3/16 60 Lbs.
				<b>MILD STEEL ELECTRODE</b>			
				6011 3/32 60 Lbs.	6011 1/8 60 Lbs.	6011 5/32 60 Lbs.	6011 3/16 60 Lbs.
				<b>MILD STEEL ELECTRODE</b>			
				6012 3/32 60 Lbs.	6012 1/8 60 Lbs.	6012 5/32 60 Lbs.	6012 3/16 60 Lbs.
				<b>MILD STEEL ELECTRODE</b>			
				6013 3/32 60 Lbs.	6013 1/8 60 Lbs.	6013 5/32 60 Lbs.	6013 3/16 60 Lbs.
<b>80 LBS. OF ELECTRODES FOR MILD STEEL</b>				<b>960 LBS. OF ELECTRODES FOR MILD STEEL</b>			

**NO MORE CONFUSION**  
**The Right Rod Every Time**

**Here are the  
products that  
will do the job  
for you . . .**



# **AURALLOY** **R** RESEARCH

## **WELDING ELECTRODES**



**The Finest Maintenance and Repair  
Electrodes Available**

AURALLOY RESEARCH • 100 DaVINCI DRIVE, BOHEMIA, NY 11716

# AURALLOY<sup>®</sup> 210

**R** ESEARCH "BLUE VELVET"



## MILD STEEL ELECTRODE

### HIGH TENSILE STRENGTH ARC WELDING OF ALL COMMON MILD STEELS

- **SUPERIOR ALL POSITION DESIGN —**  
FOR WELDING VERTICAL, HORIZONTAL AND OVERHEAD APPLICATIONS.
- **QUICK SOLIDIFICATION —**  
MAKES THIS ELECTRODE IDEAL FOR BOTH POOR AND GOOD FIT UP WORK.
- **INSTANT ARC AND NON-STICKING—**  
PROVIDES FOR EASY APPLICATION AND WELL FORMED FILLETS.
- **NO SPATTER AND EASILY REMOVED SLAG —**  
ASSURES A PROFESSIONAL QUALITY FINISH.
- **WELDS THRU RUSTY, DIRTY, OILY & PAINTED SURFACES —**  
SAVING TIME, MONEY AND LABOR.



### APPLICATIONS

- Joining angle iron, channel, "T", perforated steel sheet, expanded metal, sheet metal and all other shapes and forms of mild steel used in maintenance.
- Repairing and fabricating machine guards, covers, housings and ducts.
- Welding floor plate, diamond plate, black iron, bulkheads and partitions.

### SPECIFICATIONS

SIZE	P/N	AMPERAGE	TENSILE STRENGTH: 80,000 psi
3/32"	8700	50-100	ELONGATION: 29%
1/8"	8701	70-126	CURRENT: AC or DC
5/32"	8702	90-160	POSITION: All

*For All Types of Maintenance and Repair Welding of Mild Steel*



# AURALLOY<sup>®</sup> 210

RESEARCH  
"BLUE VELVET"  
MILD STEEL ELECTRODE

## FEATURES

Ideal for all position welding including vertical and overhead applications. Excellent penetration and quick solidification makes this electrode excellent for poor as well as good fit up work. Features excellent restrike characteristics, easy slag removal and excellent bead appearance.

- Welds on any shape or thickness of mild steel
- Low heat eliminates burn through
- High strength welds with deep penetration
- Easy application, no sticking even at low amps
- Welds equally well on AC or DC, either polarity

## WELDING TECHNIQUES

Use any constant current stick welding power source regardless of open circuit voltage, both AC or DC. Clean surface. Use any technique desirable — short, medium or long arc; stringer beads or weave beads — in all positions. Remove slag between passes.

## WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*Superior Performance with Exceptional Versatility*

# AURALLOY<sup>®</sup> 220

**R** ESEARCH



**SUPER STRENGTH ELECTRODE FOR LOW TO MEDIUM ALLOY STEELS**

## SUPERIOR STRENGTH WITH EXCELLENT MACHINABILITY

- **ALL POSITION DESIGN —**  
FOR WELDING PASS-ON-PASS IN ANY POSITION WITHOUT CHIPPING OF SLAG
- **A UNIQUE COMBINATION OF STRENGTH AND DUCTILITY —**  
FOR HIGH STRENGTH WELDS THAT WON'T CRACK
- **RAPID DEPOSITION —**  
FOR EASY WEAVE AND STRINGER TYPE WELDS
- **HIGH MOISTURE RESISTANCE —**  
ELIMINATES UNDERBEAD CRACKS AND PRE-HEATING OF WELD AREA
- **EXCEPTIONAL MACHINEABILITY —**  
SAVES MONEY IN MACHINING TIME
- **NO SPATTER AND EASILY REMOVED SLAG —**  
ASSURES A SUPERIOR QUALITY FINISH AND LESS CLEAN UP

## HIGH STRENGTH APPLICATIONS

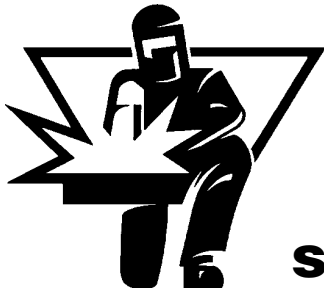
- Truck Body Liners
- Chutes
- Articulated Loaders
- Earth Moving Equipment
- Loading Platforms
- Crane Boom Tips
- Bucket and Boom Front Loader
- Fan Blades
- Wear Plates
- Shovel Boom
- Fork Lifts
- Shutter Car Chassis
- Fifth Wheel Plates
- Dragline Buckets
- Drilling Barges
- Dipper Buckets
- Oil Rigs
- Bulldozers
- Liquid Gas Tanks
- Surge Bin Coal Diverter
- Crawler Frame
- Drilling Masts

## SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<u>TENSILE STRENGTH: 115,000 psi</u>
3/32"	8705	80-110	<u>ELONGATION: 28%</u>
1/8"	8706	110-150	<u>CURRENT: DC Reverse Polarity</u>
5/32"	8707	140-210	<u>POSITION: All</u>
3/16"	8708	200-280	<u>HARDNESS: B.H.N. 237</u>

*High Strength, Crack-Free Welds Every Time*





# AURALLOY<sup>®</sup> 220

## R ESEARCH

### **SUPER STRENGTH ELECTRODE FOR LOW TO MEDIUM ALLOY STEELS**

#### **FEATURES**

A special electrode formulated and developed to provide non-cracking high physical properties for welding of low alloy high strength steels, including Corten, T-1, HY-80 and Mayarir. Welds pass-over-pass without chipping slag.

- Produces welds of x-ray quality
- One electrode covers a wide variety of steels
- Welds "tramp" steels normally considered unweldable
- No spatter means less clean up time
- Flame-cutable electrode
- Easy re-strike
- Can be used in all positions
- Dense deposits eliminates rework
- Slag is easily removed
- Excellent for build-up prior to hard facing

#### **WELDING TECHNIQUES**

Clean weld area. Set amperage within recommended range for electrode size. Hold a close arc and use either stringer or weave technique. Pause momentarily over each crater before extinguishing arc.

#### **WARNING**

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135: OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*Superior Strength, Versatility and Ease of Application . . .  
The Best Choice for the Maintenance Welder*

# AURALLOY<sup>®</sup> 225

R ESEARCH "THUNDERBOLT"



## UNIVERSAL STEEL ELECTRODE

### WELDS ALL TYPES AND GRADES OF SIMILAR AND DISSIMILAR STEELS

- ▶ **WELDS ALL STEELS —**  
REDUCING WELDING ROD INVENTORY AND ELIMINATING GUESSWORK.
- ▶ **EXCEPTIONALLY HIGH TENSILE STRENGTH —**  
FOR ADDED CONFIDENCE IN ALL HIGH STRENGTH APPLICATIONS.
- ▶ **SUPERIOR FLOWING CHARACTERISTICS —**  
PRODUCE SMOOTH FILLETS AND CRACK-FREE, NON-POROUS DEPOSITS.
- ▶ **SELF-LIFTING SLAG —**  
FOR PROFESSIONAL FINISH WITH MINIMUM CLEAN UP.

### HIGH STRENGTH APPLICATIONS

Journal bearings	Shafts	Crane booms	Drills	Air tool chucks
Spring leaves	Shock absorbers	Crane rails	Hubs	and jaws
Sprockets	Keyways	Truck frames	Hooks	Valve seats
Spokes	Barker drum staves	Draw bars	Armor plates	Wear plates
Splines	Brake drums, shoes	Pins	Augers	Wheels
Pulleys	Bucket teeth	Pinions	Axles	Wobblers
Punches	Bulldozer frames	Pipes	Foundry racks	Worm gears
Pulverizers	Camshafts	Propellers	Thrust bearings	and drives
Rollers	Castings	Motor chocks	Transmission	Journal boxes
Rotor blades	Clutch plates	Coil springs	shafts	Hole diggers
Reamers	Forks	Chipper knives	Tools	
Shovel buckets	Collars	Dies	Agitators	

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<b>TENSILE STRENGTH: 128,000 psi</b>
1/16"	8709	30-40	<b>ELONGATION: 36%</b>
3/32"	8710	40-90	<b>CURRENT: AC or DC</b>
1/8"	8711	70-110	<b>POSITION: All</b>
5/32"	8712	90-160	

*The Ultimate Strength, Multi-Purpose Steel Welding Electrode*



# AURALLOY<sup>®</sup> 225

RESEARCH "THUNDERBOLT"

## UNIVERSAL STEEL ELECTRODE

### FEATURES

- Can run at lower amperage for steels prone to cracking
- Easily applied in all positions
- Eliminates undercutting
- Stronger than stainless rods
- High shock resistance
- Minimum deposit with maximum weld strength
- Smooth, even fillets without spatter
- Welds any steel and any combination of dissimilar steels
- Retains elongation properties by not "work-hardening" significantly

### WELDING TECHNIQUES

Remove loosely adhering metal and wire brush away oxides, dirt and contaminants. Use any stick electrode welding machine available. Set the amperage within the range prescribed for the electrode size and initiate the arc. Vary the amperage and the arc gap up or down to suit. Use any technique from stringer bead to wide weave. The electrode lead angle is not critical — vary to suit application. Self-releasing slag should be brushed away between passes.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*A Superior Combination of  
Tensile Strength and Elongation*

# AURALLOY<sup>®</sup> 225-B

R ESEARCH



## UNIVERSAL BARE STEEL ROD

### STEEL ELECTRODE FOR TORCH AND TIG WELDING

- ▶ **WELDS ALL STEELS —**  
REDUCING WELDING ROD INVENTORY AND ELIMINATING GUESSWORK
- ▶ **EXCEPTIONALLY HIGH TENSILE STRENGTH —**  
FOR ADDED CONFIDENCE IN ALL HIGH STRENGTH APPLICATIONS
- ▶ **SUPERIOR FLOWING CHARACTERISTICS —**  
PRODUCING A NON-POROUS, CRACK-FREE DEPOSIT
- ▶ **EASILY JOINS DISSIMILAR STEELS —**  
WHILE LOW TEMPERATURE APPLICATION ALLOWS THIN METAL JOINING, OVERLAYS OR REPAIRS

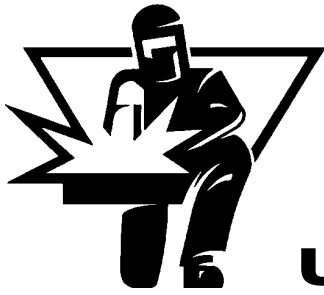
### HIGH STRENGTH APPLICATIONS

- Hospital Equipment
- Food/Beverage Processing Machinery
- Chemical Mixing and Storage Equipment
- Construction Equipment Repairs
- Research Laboratory Equipment
- Oil and Gas Refineries
- Marine and Aircraft Repairs
- Joining Unknown Steels

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<b>TENSILE STRENGTH: 128,000 psi</b>
1/16"	8728	60-90	<b>ELONGATION: 36%</b>
3/32"	8729	150-210	<b>CURRENT: DC straight polarity</b>
1/8"	8730	200-250	

*Ultimate Strength, Multi-Purpose Torch or TIG Steel Welding Rod*



# AURALLOY<sup>®</sup> 225-B

R ESEARCH

## UNIVERSAL BARE STEEL ROD

### FEATURES

- Excellent heat, cracking and fatigue resistance and expansion contraction properties.
- Easily joins dissimilar steels while low temperature application allows thin metal joining, overlays or repairs.
- Produces a non-porous, crack-free deposit.

### WELDING TECHNIQUES

For torch application, a small tip on an oxyacetylene torch is recommended. FLUX should be painted along the area to be joined, overlaid or repaired. Adjust flame to a near neutral stage but slightly more acetylene for best results. Hold torch close and apply drop by drop always allowing deposit to solidify under the flame to prevent oxidation. Always keep the rod under the flame so the rod end will not oxidize. Remove excess flux with water and clean with stainless steel brush.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*A Superior Combination of  
Tensile Strength and Elongation*

**AURALLOY**<sup>®</sup>  
**R** ESEARCH

**225-**  
**MIG**



**MILD STEEL WELDING WIRE**

### MILD STEEL WELDING WIRE

- **WELDS ALL STEELS THAT CONTAIN HIGHER LEVELS** OF MANGANESE AND SILICON THAN OTHER STANDARD GRADES OF MIG WIRE TO PRODUCE HIGH QUALITY WELDS WHEN USED ON DIRTY, OILY OR RUSTY STEEL.
- **THE HIGH SILICON CONTENT INCREASES THE FLUIDITY OF THE WELD POOL —** THUS CREATING A SMOOTHER BEAD APPEARANCE AND RESULTING IN MINIMAL POST-WELD GRINDING.
- **THIS WIRE IS ENGINEERED TO PROVIDE POROSITY-FREE,** X-RAY QUALITY WELDS AT THE HIGHEST STRENGTH (AS WELDED) OF ALL THE PLAIN CARBON STEEL WIRES.
- **REQUIRES A SHIELDING GAS: CO<sub>2</sub> AND/OR CO<sub>2</sub> MIX**

### TYPICAL APPLICATIONS

- General shop applications with poor fit-up or rusty, oily plates
- Steel castings or forging salvage
- Home projects, tanks, sheet metal and construction work

### SPECIFICATIONS

<u>SPOOLED</u>	<u>P/N</u>	<u>AMPERAGE</u>	<b>TENSILE STRENGTH: 95,000 psi</b>
.035	8727	100-150	<b>ELONGATION IN 2": 25%</b>
			<b>WELDING CURRENT: DECP</b> (Electrode Positive, Reverse Polarity)

*Requires a Shielding Gas: CO<sub>2</sub> and/or CO<sub>2</sub> Mix*



# AURALLOY<sup>®</sup> 225- RESEARCH MIG

## MILD STEEL WELDING WIRE

### FEATURES

- Mild steel welding wire that contains higher levels of manganese and silicon than other standard grades of MIG wire to produce high quality welds when used on dirty, oily or rusty steel.
- The high silicon content increases the fluidity of the weld pool, thus creating a smoother bead appearance and resulting in minimal post-weld grinding.
- Engineered to provide porosity-free, x-ray quality welds at the highest tensile strength (as welded) of all the plain carbon steel wires.
- This product requires a shielding gas: CO<sub>2</sub> and/or CO<sub>2</sub> mix.

### WELDING TECHNIQUES

Always clean weld joint with a wire brush or grinding wheel. Always insure good fit up. Direct current electrode is used for all modes of metal transfer. Suited for spray or pulse spray general purpose welding using CO<sub>2</sub> gas as a shielding medium. Recommended for single or multi-pass welds on low carbon steel plate, tubing, piping, structural members, steel castings, pressure vessels, etc.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*All Positions*

# AURALLOY<sup>®</sup> 225-V

**R** RESEARCH



## VERTICAL STEEL ELECTRODE

### VERTICAL POSITION HIGH STRENGTH ELECTRODE FOR DISSIMILAR STEELS

- **UNIQUE "FAST-FREEZE" COATING —**  
SIMPLIFIES VERTICAL DOWN AND UP WELDING.
- **WELDS ALL STEELS —**  
REDUCING WELDING ROD INVENTORY AND ELIMINATING GUESSWORK.
- **EXCEPTIONALLY HIGH TENSILE STRENGTH —**  
FOR ADDED CONFIDENCE IN ALL HIGH STRENGTH APPLICATIONS.
- **CONTROLLED WELD PUDDLE —**  
ALLOWS FOR FILLING HOLES AND JOINING DISSIMILAR STEELS.

### HIGH STRENGTH APPLICATIONS

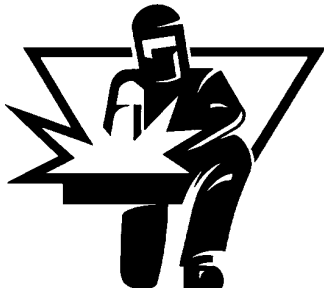
Agitators	Chipper knives	Hooks	Pulverizers	Tools
Air tool chucks and jaws	Clutch plates	Hubs	Reamers	Transmission shafts
Armor plates	Coil springs	Journal bearings	Rollers	Truck frames
Augers	Collars	Journal boxes	Rotor blades	Valve seats
Axles	Crane booms	Keyways	Shafts	Wear plates
Barker drum staves	Crane rails	Motor chocks	Shock absorbers	Wheels
Brake drums, shoes	Dies	Pinions	Shovel buckets	Wobblers
Bucket teeth	Draw bars	Pins	Splines	Worm gears and drives
Bulldozer frames	Drills	Pipes	Spokes	
Camshafts	Forks	Propellers	Spring leaves	
Castings	Foundry racks	Pulleys	Sprockets	
	Hole diggers	Punches	Thrust bearings	

### SPECIFICATIONS

<b>SIZE</b>	<b>P/N</b>	<b>AMPERAGE</b>	<b>TENSILE STRENGTH:</b> 128,000 psi
3/32"	8718	35-70	<b>ELONGATION:</b> 32%
1/8"	8719	60-110	<b>CURRENT:</b> DC Reverse Polarity or AC
			<b>POSITION:</b> All

*Ideal for Poor Fit Up Joints in All Positions*





# AURALLOY<sup>®</sup> 225-V

## R ESEARCH

### VERTICAL STEEL ELECTRODE

#### FEATURES

- Unique "fast-freeze" coating simplifies vertical down and up welding
- Runs at lower amperage for steels prone to cracking
- Easily applied in all positions
- Eliminates undercutting
- Stronger than stainless rods
- High shock resistance
- Minimum deposit with maximum weld strength
- Smooth, even fillets without spatter
- Welds any steel and any combination of dissimilar steels
- Retains elongation properties by not "work-hardening" significantly

#### WELDING TECHNIQUES

The area in which the weld is to be made should be free of rust, grease, paint and other materials which cause weld contamination. A 90° vee joint should be used when joining heavy sections. Maintain a short arc length and use stringer beads.

#### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*A Superior Combination of  
Tensile Strength and Elongation*

# AURALLOY<sup>®</sup> 230

R ESEARCH

"DIRT DEVIL"



## ADVERSE CONDITIONS MILD STEEL ELECTRODE

### HIGH TENSILE STRENGTH WELDING OF ALL COMMON MILD STEELS

- **SUPERIOR ALL POSITION DESIGN —**  
FOR WELDING VERTICAL, HORIZONTAL AND OVERHEAD APPLICATIONS
- **WELDS THRU RUSTY, GREASY, POOR FITTING JOINTS  
IN ALL POSITIONS —**  
SAVING TIME, MONEY AND LABOR
- **EXCEPTIONAL FLEXIBILITY —**  
ELECTRODE CAN BE BENT WITHOUT FLUX CHIPPING
- **FASTER AND EASIER TO USE —**  
SLAG CAN BE WELDED OVER WITHOUT REMOVAL
- **QUICK SOLIDIFICATION —**  
WELDS THROUGH 1/2 INCH OF SURFACE CONTAMINATION WITHOUT POROSITY

### APPLICATIONS

- Ideally suited for difficult maintenance repairs.
- Easily welds steels that have been galvanized, painted, rusted or otherwise contaminated in service.
- Misaligned parts or difficult to access areas are also easily remedied with this electrode.

### SPECIFICATIONS

SIZE	P/N	AMPERAGE	TENSILE STRENGTH: 88,000 psi
3/32"	8850	25-75	ELONGATION: 28%
1/8"	8851	35-125	CURRENT: DC Reverse, Straight or AC
5/32"	8852	50-160	POSITION: All
3/16"	8853	75-200	

*Ideally Suited for Difficult Maintenance Repairs*



# AURALLOY<sup>®</sup> 230

RESEARCH "DIRT DEVIL"

## ADVERSE CONDITIONS MILD STEEL ELECTRODE

### FEATURES

- Superior all position design for welding vertical, horizontal and overhead applications
- Excels on rusty, greasy poor fitting joints in all positions
- Can weld through 1/2 inch (12mm) of surface contamination without porosity
- Can bridge gaps as wide as 3/8 inch (9mm)
- Electrode can be bent without flux chipping
- Slag can be welded over without removal

### WELDING TECHNIQUES

Weld with a short-medium arc length at low amperage. When surface preparation is impractical, use a medium-long arc and favor high amperages. Multi-pass welds can be made without intermittent slag removal. Use any welding technique from stringer bead to wide weave.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away from your breathing zone and the general area.
- Wear correct eye, ear and body protection.
- Do not touch live electrical parts.
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*Superior Performance With Exceptional Versatility*

# AURALLOY<sup>®</sup> 240

**R** ESEARCH "HAMMER"



## IMPACT RESISTANT ELECTRODE

### HIGH HEAT AND CORROSION RESISTANCE

- ▶ **EXTRA HIGH STRENGTH WELDS —**  
THAT DO NOT SPALL
- ▶ **OUTWEARS ORDINARY HARDFACING ALLOYS —**  
IN IMPACT CONDITIONS AS MUCH AS 10 TO 1

### APPLICATIONS

- For joining and repairing steel and manganese steel parts used throughout the railroad, construction and related industries

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<b>TENSILE STRENGTH:</b> 119,000 psi
1/8"	8713	90-150	<b>ELONGATION:</b> 41%
			<b>CURRENT:</b> AC or DC Reverse Polarity
			<b>HARDNESS:</b> Brinell 200-520, Rockwell C10-C50

*For Joining and Surfacing Steels*



# AURALLOY<sup>®</sup> 240

RESEARCH

**"HAMMER"**

## IMPACT RESISTANT ELECTRODE

### FEATURES

- Extra high strength welds that do not spall.
- Outwears ordinary hardfacing alloys in impact conditions as much as 10 to 1.

### WELDING TECHNIQUES

Do not pre-heat. Use the lowest possible amperage and move the electrode as quickly as feasible. Allow to cool slowly.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*For Joining and Surfacing Steels*

# AURALLOY<sup>®</sup> 250

**R** ESEARCH "STERLING"



## UNIVERSAL STAINLESS STEEL ELECTRODE

### HIGH HEAT AND CORROSION RESISTANCE

➤ **SUPERIOR COMBINATION OF AC/DC WELDABILITY AND DEPOSIT CHEMISTRY —**

PROVIDES SMOOTHER DEPOSITS WITH MINIMUM SUSCEPTIBILITY TO CARBIDE PRECIPITATION AND CRACKING

➤ **FASTER AND EASIER TO USE —**

WITH FAST DEPOSITION RATE, NO SPATTER AND EASY SLAG REMOVAL

### APPLICATIONS

- Furnace Parts — baffle plates, chain links and guides, woven belts and associated hardware
- All types of stainless castings, both non-magnetic and magnetic
- Crucible tongs, plating baskets and hooks, retorts, tanks, pipe, tubing, vats and other chemical processing components
- Pumps, valves and fittings
- Heat exchangers and heat treating boxes

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<b>TENSILE STRENGTH: 95,000 psi</b>
1/16"	8714	30-60	<b>ELONGATION: 45%</b>
3/32"	8715	60-90	<b>CURRENT: AC or DC Reverse Polarity</b>
1/8"	8716	90-120	<b>POSITION: All</b>
5/32"	8717	120-160	

*For Maintenance and Repair Applications*



# AURALLOY<sup>®</sup> 250

RESEARCH  
"STERLING"

## UNIVERSAL STAINLESS STEEL ELECTRODE

### FEATURES

- Corrosion and heat resistance superior to ordinary stainless steel electrodes
- Smooth deposits with minimum susceptibility to carbide precipitation and cracking
- Easy to use — no spatter, fast deposition rate, easy slag removal
- Used on most stainless steel applications assigned for maintenance and repair
- Excellent for joining or overlays on most grades of stainless steel, carbon and alloy steel and stainless steel of unknown analysis.

### WELDING TECHNIQUES

Deposit at low amperage, holding a close arc. Stringer beads are preferred, but electrode can be weaved up to 3 times if the application requires. For filletting, raise amperage 10% and drag the electrode, maintaining light pressure. Back-whip craters, removing slag between passes.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away from your breathing zone and the general area.
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*The Only Stainless Steel Electrode for the  
Maintenance and Repair Welder*

# AURALLOY<sup>®</sup> 250-B

**R** ESEARCH



## UNIVERSAL STAINLESS STEEL BARE ROD

### STAINLESS STEEL ELECTRODE FOR TORCH AND TIG WELDING

- ▶ **EASY TO WORK STAINLESS WIRE —**  
PROVIDES SUPERIOR RESISTANCE TO CORROSION, HEAT AND ABRASION
- ▶ **WELDS ALL TYPES OF STAINLESS STEEL —**  
REDUCING WELDING ROD INVENTORY AND ELIMINATING GUESSWORK
- ▶ **HIGH TENSILE STRENGTH —**  
FOR ADDED CONFIDENCE IN ALL HIGH STRENGTH APPLICATIONS
- ▶ **SUPERIOR FLOWING CHARACTERISTICS —**  
PRODUCING A NON-POROUS, CRACK-FREE DEPOSIT

### HIGH STRENGTH APPLICATIONS

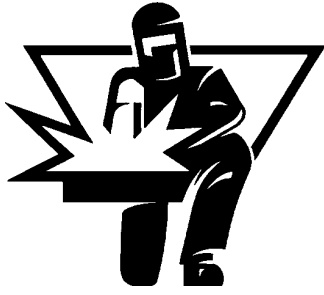
- Chemical Mixing and Storage Equipment
- Construction Equipment Repairs
- Food and Beverage Processing Machinery
- Marine and Aircraft Repairs
- Research Laboratory Equipment
- Oil and Gas Refineries
- Hospital Equipment

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	TENSILE STRENGTH: 86,000 psi
1/16"	8740	
3/32"	8741	
1/8"	8742	

*Multi-Purpose Torch or TIG Stainless Steel Welding Rod*





# AURALLOY<sup>®</sup> 250-B

R ESEARCH

## UNIVERSAL STAINLESS STEEL BARE ROD

### FEATURES

- Easy to work stainless steel wire with superior corrosion resistant deposits.
- Excellent strength, impact and abrasion-resistant qualities.

### WELDING TECHNIQUES

For torch application, clean area of grease and dirt. Apply flux to repair area. Use slightly excess flame. Keep torch in motion to uniformly heat area. As flux liquifies, hold torch close. Add alloy to joint drop by drop.

### WARNING

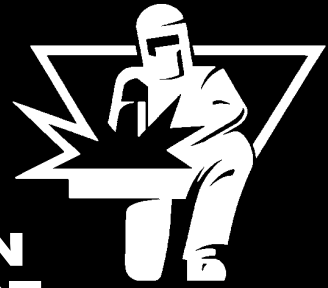
Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*Universal Stainless Steel Electrode  
For Torch and TIG Welding*

# AURALLOY<sup>®</sup> 255

**R** ESEARCH "CASCADE"



## SPECIAL VERTICAL POSITION STAINLESS STEEL ELECTRODE

### HIGH HEAT AND CORROSION RESISTANCE

➤ **SUPERIOR COMBINATION OF AC/DC WELDABILITY  
AND DEPOSIT CHEMISTRY —**

PROVIDES SMOOTHER DEPOSITS WITH MINIMUM SUSCEPTIBILITY TO CARBIDE  
PRECIPITATION AND CRACKING

➤ **FASTER AND EASIER TO USE —**

WITH FAST DEPOSITION RATE, NO SPATTER AND EASY SLAG REMOVAL

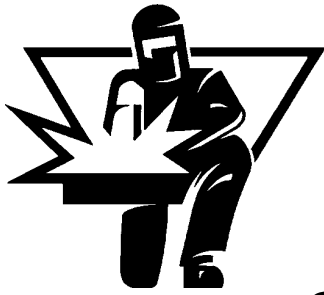
### APPLICATIONS

- Especially suited for vertical down and up welding of thin to medium gauge molybdenum bearing stainless steels
- Furnace Parts — baffle plates, chain links and guides, woven belts and associated hardware
- All types of stainless castings, both non-magnetic and magnetic
- Crucible tongs, plating baskets and hooks, retorts, tanks, pipe, tubing, vats and other chemical processing components
- Pumps, valves and fittings
- Heat exchangers and heat treating boxes

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<b>TENSILE STRENGTH: 80,000 psi</b>
3/32"	8737	60-80	<b>ELONGATION: 42%</b>
1/8"	8738	90-110	<b>CURRENT: DC Reverse Polarity or AC</b>
			<b>POSITION: All</b>

*For Maintenance and Repair Applications*



# AURALLOY<sup>®</sup> 255

RESEARCH "CASCADE"

## SPECIAL VERTICAL POSITION STAINLESS STEEL ELECTRODE

### FEATURES

- Unique "fast-freeze" coating simplifies vertical down and up welding.
- Ideal for poor fit up joints in all positions.
- Controlled weld puddle allows for filling holes on stainless steels.

### WELDING TECHNIQUES

For vertical welding, set amperage at high end of the scale. Maintain a sharp angle with the electrode pointing upward. Whip the electrode quickly back and forth while moving up or down. Electrode may show a red color from the excess amperage which is normal.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*Vertical Position Stainless Steel Electrode  
for the Maintenance and Repair Welder*

# AURALLOY<sup>®</sup> 300

**R** ESEARCH "MIDNIGHT"



**ULTIMATE ELECTRODE FOR WELDING ALL GRADES OF CAST IRON**

## STRONG, RELIABLE REPAIRS OF HOUSINGS AND CASTINGS

- **SUPERIOR ALL POSITION DESIGN —**  
FOR WELDING PASS-ON-PASS, WITHOUT CHIPPING OF SLAG
- **ULTIMATE TENSILE STRENGTH —**  
ASSURES CRACK-FREE WELDS ON ALL CAST IRON
- **OUTSTANDING ELONGATION —**  
PROVIDES BUILT-IN STRESS RELIEF, REDUCING WELD FAILURES AND CRACKING
- **NO PREHEATING REQUIRED —**  
REDUCING TIME AND LABOR COSTS
- **SUPER STRONG ARC DRIVE —**  
FOR EASY PENETRATION OF CONTAMINATED CASTINGS
- **UNIFORM, HIGH-LUSTER DEPOSITS —**  
ASSURES A SUPERIOR QUALITY FINISH AND LESS CLEAN UP TIME

## HIGH STRENGTH APPLICATIONS

- All grades 30, 40 and 50 gray cast irons in all thicknesses and all positions.
- All alloy cast irons — ductile, nodular (spheroidal graphitic iron), malleable and meehanite.
- Engine blocks, diesel heads, gear boxes, transmission housings, differentials, machine bases and presses.

## SPECIFICATIONS

SIZE	P/N	AMPERAGE	TENSILE STRENGTH: 70,000 psi
3/32"	8720	50-80	ELONGATION: 40%
1/8"	8721	70-110	CURRENT: AC or DC
5/32"	8722	100-140	On DC use Reverse Polarity
			POSITION: All

*Highest Quality, Fully Machinable Cast Iron Electrode . . .  
The Best Choice for the Maintenance Welder*



# AURALLOY<sup>®</sup> 300

RESEARCH "MIDNIGHT"

## ULTIMATE ELECTRODE FOR WELDING ALL GRADES OF CAST IRON

### FEATURES

- Exceptional machinability — easily ground, filed or shaped
- Welds through paint, rust, grease and oil — without porosity
- High resistant to hydrostatic pressure

### WELDING TECHNIQUES

Remove loosely adhering material in area to be welded (use Auralloy 400). Searing of the surface is highly recommended. Cracks should be beveled after piercing holes at either end to prevent propagation. Preheating is not required unless casting is unusually thick. Adjust the welding machine within the prescribed amperage range and deposit beads approximately 2" long. Skip and stagger to suit. Remove slag by lightly chipping and brushing. Linger momentarily over the final crater before extinguishing the arc.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*High Strength, Crack-Free Welding on All Cast Iron*

# AURALLOY<sup>®</sup> 310

**R** ESEARCH



**ULTIMATE CAST IRON ELECTRODE  
WITH NON-CONDUCTIVE FLUX COATING**

## **STRONG, RELIABLE REPAIRS OF HOUSINGS AND CASTINGS**

- **UNIQUE, NON-CONDUCTIVE FLUX COATING —**  
ALLOWS WELDING IN TIGHT SPOTS WITHOUT ARCING ON SIDE OF ROD
- **SUPERIOR ALL POSITION DESIGN —**  
FOR WELDING PASS-ON-PASS, WITHOUT CHIPPING OF SLAG
- **ULTIMATE TENSILE STRENGTH —**  
ASSURES CRACK-FREE WELDS ON ALL CAST IRON
- **OUTSTANDING ELONGATION —**  
PROVIDES BUILT-IN STRESS RELIEF, REDUCING WELD FAILURES AND CRACKING
- **NO PREHEATING REQUIRED —**  
REDUCING TIME AND LABOR COSTS
- **SUPER STRONG ARC DRIVE —**  
FOR EASY PENETRATION OF CONTAMINATED CASTINGS
- **UNIFORM, HIGH-LUSTER DEPOSITS —**  
ASSURES A SUPERIOR QUALITY FINISH AND LESS CLEAN UP TIME

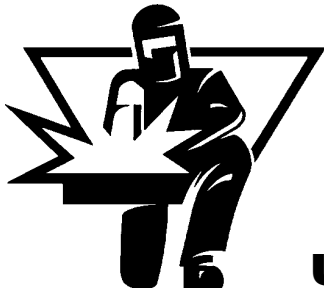
## **HIGH STRENGTH APPLICATIONS**

- All grades 30, 40 and 50 gray cast irons in all thicknesses and all positions.
- All alloy cast irons — ductile, nodular (spheroidal graphitic iron), malleable and meehanite.
- Engine blocks, diesel heads, gear boxes, transmission housings, differentials, machine bases and presses.

## **SPECIFICATIONS**

<b>SIZE</b>	<b>P/N</b>	<b>AMPERAGE</b>	<b>TENSILE STRENGTH: 55,000 psi</b>
3/32"	8746	60-90	<b>CURRENT: AC or DC Reverse Polarity</b>
1/8"	8747	85-120	<b>POSITION: All</b>

*Highest Quality Electrode for Joining All Grades of Cast Iron*



# AURALLOY<sup>®</sup> 310

## R ESEARCH

### ULTIMATE CAST IRON ELECTRODE WITH NON-CONDUCTIVE FLUX COATING

#### FEATURES

- State-of-the-art non-conductive flux coated electrode for welding every known grade of cast iron, heavy or thin, and for joining these to steel
- Will not arc on side of electrode when contacting metals
- Exceptional machinability — easily ground, filed or shaped
- Welds through paint, rust, grease and oil — without porosity
- High resistant to hydrostatic pressure

#### WELDING TECHNIQUES

Remove loosely adhering material in area to be welded (use Auralloy 400). Searing of the surface is highly recommended. Cracks should be beveled after piercing holes at either end to prevent propagation. Preheating is not required unless casting is unusually thick. Adjust the welding machine within the prescribed amperage range and deposit beads approximately 2" long. Skip and stagger to suit. Remove slag by lightly chipping and brushing. Linger momentarily over the final crater before extinguishing the arc.

#### WARNING

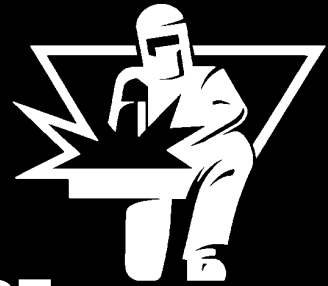
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- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away from your breathing zone and the general area.
- Wear correct eye, ear and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1. Safety in Welding and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*High Strength, Crack-Free Welding on All Cast Iron*

# AURALLOY<sup>®</sup> 320

**R** ESEARCH  
"BLACK BEAUTY"



## COPPER CLAD "TRI-METAL" CORED CAST IRON ELECTRODE

### PROPRIETARY COPPER-NICKEL-IRON DEPOSIT CHEMISTRY

- **UNIQUE COPPER PLATED CORE WIRE —**  
PROVIDES UNEQUALED CAST IRON WELDING PERFORMANCE
- **HIGH EFFICIENCY WELD METAL TRANSFER —**  
ELIMINATES ELECTRODE OVERHEATING
- **ULTIMATE COMBINATION OF SOFTWARE, DUCTILITY AND TENSILE STRENGTH —**  
FOR EASE OF USE AND MAXIMUM STRESS RELIEF

### APPLICATIONS

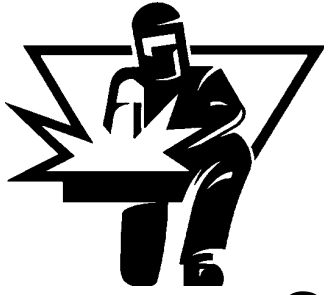
The high deposition rate of this electrode creates an extremely narrow heat affected zone. This feature is suitable for all weldable cast irons that require post weld machining.

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<u>TENSILE STRENGTH: 77,000 psi</u>
3/32"	8855	50-70	<u>ELONGATION: 15%</u>
1/8"	8856	70-100	<u>CURRENT: DC Reverse (+) or AC</u>
5/32"	8857	100-130	<u>POSITION: Flat, Vertical Up, Horizontal, Overhead</u>

*Ultimate Combination of Softness,  
Ductility and Tensile Strength*





# AURALLOY<sup>®</sup> 320

RESEARCH  
"BLACK BEAUTY"

## COPPER CLAD "TRI-METAL" CORED CAST IRON ELECTRODE

### FEATURES

- Unique core wire for ultimate cast iron performance.
- High efficiency weld metal transfer totally eliminates electrode overheating.
- Proprietary copper-nickel-iron deposit chemistry yields the ultimate combination of softness, ductility and tensile strength.

### WELDING TECHNIQUES

Guide the electrode at a steep angle keeping the arc length short. Use short staggered beads when welding restrained parts.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*Suitable for All Weldable Cast Irons  
that Require Post Weld Machining*

# AURALLOY<sup>®</sup> 400

**R** ESEARCH "TURBO"



## CUTTING, GROOVING AND CHAMFERING ELECTRODE

### FOR RAPID METAL REMOVAL

- **SUPERIOR ALL POSITION DESIGN —**  
QUICKLY REMOVES UNWANTED METAL WITHOUT GRINDING OR MACHINING
- **WORKS WITH STANDARD ARC WELDING MACHINES —**  
NO ACCESSORIES OR ATTACHMENTS NECESSARY
- **SAFER AND EASIER TO USE —**  
CAN BE USED WHERE TORCH CUTTING IS DIFFICULT OR IMPOSSIBLE
- **EXCELLENT FOR PRE-WELD PREPARATION —**  
EASILY PREPARES CRACKED AND FATIGUED METAL FOR WELDING
- **LEAVES A CLEAN, SCALE-FREE SURFACE —**  
ASSURING A PROFESSIONAL QUALITY FINISH WITHOUT GRINDING TO REMOVE CARBON DEPOSITS

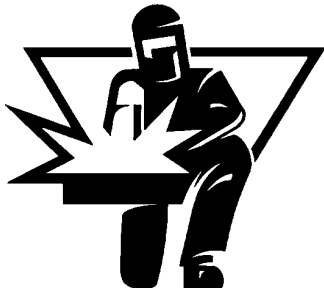
### APPLICATIONS

- Dismantling welded structures such as towers, sign supports and pipe piles.
- Use for blowing out rivets and for removing old weld overlays on railroad frogs, cross-overs and switches.
- Ideal for preparing work-hardened or heat-treated dies for welding.

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<u>CURRENT: AC or DC Straight Polarity</u>
3/32"	8724	90-170	
1/8"	8725	150-300	
5/32"	8726	175-400	

*The Maintenance and Repair Welders "Third Hand"*



# AURALLOY<sup>®</sup> 400

RESEARCH  
R

**"TURBO"**

## CHAMFERING / CUTTING ELECTRODE

### FEATURES

- Quickly prepares cracks and fatigued metal for welding.
- Metal removal where cutting by torch is either difficult or impossible
- A clean, scale-free surface which rarely requires further finishing
- Use on your present arc welding machine — no additional accessories or attachments necessary.
- 3/32" diameter works on same machine adjustments as 1/8" steel welding rod . . . no need to adjust.

### WELDING TECHNIQUES

Point electrode in direction of travel and initiate arc. For a shallow chamfer, move electrode quickly along line of cut. A slower or weaving motion provides deeper groove. The molten metal is pushed ahead as the chamfer is made. For deeper grooves, repeat until the required depth is achieved.

### WARNING

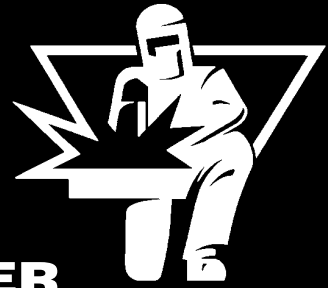
Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

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- Do not touch live electrical parts.
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*Fastest, Most Economical Method of Removing  
Unwanted Metal Using a Common Welding Machine*

# AURALLOY<sup>®</sup> 500

**R** ESEARCH



## SUPER STRENGTH SELF-FLUXING SILVER SOLDER

### 95% TIN 5% SILVER FLUX-CORED SOLDER ALLOY

- **MELTS AT A LOW 430°F —**  
ELIMINATING DISTORTION AND WEAKENING OF BASE MELT
- **FAST, EASY HIGH STRENGTH DEPOSITS —**  
WITH SOLDER GUN, IRON OR TORCH
- **SELF-FLUXING —**  
FOR ONE-STEP APPLICATION
- **CONTAINS NO LEAD, CADMIUM OR ZINC —**  
FOR SAFE USE AND COMPLIANCE WITH ALL PURE FOOD LAWS

### APPLICATIONS

- Food and Beverage Containers
- Toilet Fixtures
- Sanitary Equipment
- A/C and Refrigeration
- Auto Radiators
- Evaporators
- Regulators and Meters
- Machine Guides
- Chrome Plated Fittings
- Electrical Connections
- Toy and Hobby Repair

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>WEIGHT</u>	
1/32"	8781	.6 oz. Disp. Tube	<b>TENSILE STRENGTH:</b> 15,000 psi <b>MELTING TEMP.:</b> 430°F
1/16"	8780	1.0 oz. Disp. Tube	
1/16"	8776	1/2 lb. Spool	
1/16"	8775	1 lb. Spool	
1/8"	8779	1/2 lb. Spool	
1/8"	8778	1 lb. Spool	

*The Ideal Maintenance Solder*



# AURALLOY<sup>®</sup> 500

## R ESEARCH

### **SUPER STRENGTH SELF-FLUXING SILVER SOLDER**

#### **FEATURES**

- Fast, easy high strength deposits with solder gun, iron or torch.
- Melts at a low 430°F, eliminating distortion and weakening of base melt.
- Conductivity 25% greater than ordinary solders.
- Contains no lead, cadmium or zinc for safe use and compliance with all pure food laws.
- Available in 1/2 lb. and 1 lb. spools or convenient pocket-size dispenser.

#### **SOLDERING TECHNIQUES**

Heat both surfaces to be joined with solder gun, iron or torch. Touch end of solder wire to joint allowing solder to flow evenly into joint.

#### **WARNING**

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- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
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*95% Tin 5% Silver Flux-Cored Solder Alloy  
with Outstanding Strength*

# AURALLOY<sup>®</sup> 600

RESEARCH

"WHITE  
LIGHTNING"



**UNIVERSAL ALUMINUM ALLOY ELECTRODE**

## FOR JOINING AND METAL BUILD-UP OF ALL WELDABLE GRADES OF ALUMINUM

- **LOW MELT COATING —**  
ALLOWS FOR USE AS A TORCH BRAZING ALLOY
- **UNUSUALLY SMOOTH ARC TRANSFER —**  
FOR MINIMAL SPATTER AND CONSISTENT DEPOSITIONS
- **STABILIZED AND DE-OXIDIZED CORE WIRE —**  
PREVENTS POROSITY
- **SPECIAL, BAKED-ON COATING —**  
CONTROLS ALUMINUM OXIDE FORMATION AND ASSURES LONG SHELF LIFE
- **EXCELLENT WELDABILITY —**  
FOR EASY APPLICATION IN ALL POSITIONS INCLUDING VERTICAL AND OVERHEAD
- **STABLE ARC —**  
FOR SMOOTH APPLICATION WITH NO SPATTER
- **DENSE DEPOSITS —**  
ASSURE FLATTER BEADS WITH NO POROSITY

## APPLICATIONS

- Truck beds, bodies and frames
- Pipe railings, bannisters, stairs, diamond plate
- Irrigation piping
- Engine and motor blocks
- Traffic light bases, highway signs and supports
- Loading ramps and docks
- Door/window frames
- Transmission housings and gear boxes
- Machine bases and supports
- Bus bars, electrical switch boxes and mounts

## SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<b>TENSILE STRENGTH: 34,000 psi</b>
1/8"	8731	70-110	<b>CURRENT: DC Reverse Polarity</b>
5/32"	8732	100-150	<b>POSITION: All</b>

*Superior Performance With Exceptional Versatility*



# AURALLOY<sup>®</sup> 600

RESEARCH  
R

**"WHITE LIGHTNING"**

## UNIVERSAL ALUMINUM ALLOY ELECTRODE

### FEATURES

- Universal electrode welds all cast, wrought and extruded aluminum and aluminum alloys.
- Smooth arc transfer
- Minimum spatter
- Can also be used as a torch brazing alloy

### WELDING TECHNIQUES

Remove oil and grease with wire brush or sand/grind immediate weld area. Chamfer edges of plates to be joined and open up cracks. Make holes to be filled wider at the top. Preheat heavy sections broadly. In thick-to-thin joining, preheat heavier member. Use any conventional DC coated electrode power source-rectifier type of motor or engine driven generator. Adjust for upper end of the recommended amperage range and reduce amperage as welding progresses and base metal absorbs heat. Feed the electrode quickly and move fast. When picking up each bead, weld into the previous crater before continuing.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away from your breathing zone and the general area.
- Wear correct eye, ear and body protection.
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*Arc Welding of All Aluminum and Aluminum Alloys*

# AURALLOY® 610

RESEARCH



## HIGH STRENGTH FLUX-CORED ALUMINUM BRAZING ALLOY

### GENERAL PURPOSE TORCH BRAZING OF ALL WELDABLE ALUMINUM

- ▶ **SPECIALLY ENGINEERED ALLOY WITH FLUX CORE —**  
FOR FASTER, EASIER JOINING OF ALL ALUMINUM AND ALUMINUM ALLOYS.
- ▶ **EXCELLENT FOR OUT OF POSITION BRAZING AND BUILD-UP DEPOSITS —**  
PROVIDING DEEP PENETRATION IN TIGHT JOINTS
- ▶ **LOW MELT TEMPERATURE —**  
FOR EASIER, FASTER TORCH BRAZING

### APPLICATIONS

- Motor Housings
- Ladders
- Beverage Cases
- Tools
- Utensils
- Pulleys
- Tanks
- Rails
- Sheaves
- Vats

### SPECIFICATIONS

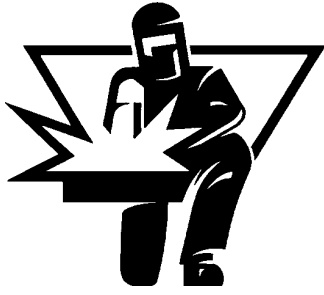
**SIZE**  
1/8"

**P/N**  
8745

**TENSILE STRENGTH:** 30,000 psi

*High Strength Deposits on Sheet, Wrought or Cast Aluminum*





# AURALLOY® 610

RESEARCH

## HIGH STRENGTH FLUX-CORED ALUMINUM BRAZING ALLOY

### FEATURES

- Flux-cored aluminum alloy for high strength deposits at low temperatures.
- Superior results on all types of aluminum.
- A specially engineered alloy with flux core center for faster, easier application.
- Provides deep penetration in tight joints.
- Excellent for out of position brazing and build-up deposits.

### WELDING TECHNIQUES

Clean weld area, removing plating or anodized finish. Leave gap approximately 1/16". For thicker parts, cracks or butt joints, bevel a 60° to 70° vee. Use a carburizing flame (excess acetylene with oxygen) and heat work with flame 1" to 3" from surface. Touch rod to weld area, depositing small amounts of alloy and allow to flow out and bond to base metal.

### WARNING

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*Ultimate Aluminum Maintenance Rod*

# AURALLOY<sup>®</sup> 620

**R** ESEARCH



## EASY-FLOW ALUMINUM ALLOY WIRE

### FOR TORCH OR TIG WELDING

- **EXCEPTIONAL STRENGTH AND DUCTILITY —**  
FOR GENERAL PURPOSE JOINING, FABRICATING AND REPAIRING OF MOST ALUMINUM GRADES
- **MINIMUM PREPARATION AND LOW MELT (950° - 1010°F) —**  
FOR EASE OF APPLICATION
- **THIN FLOWING —**  
ALLOWS FOR APPLICATION IN TIGHT FITS

### APPLICATIONS

- Poles
- Guard Rails
- Frames
- Furniture
- Bus Bars
- Structural Parts
- Sign Posts
- Housings
- Tools
- Ladders
- Utensils
- Tubing
- Vats
- Tanks
- Rails
- Patterns
- Fixtures
- Truck Bodies
- Evaporators
- Castings
- Marine Equipment
- Pipe

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<b>TENSILE STRENGTH: 35,000 psi</b>
1/16"	8750	
3/32"	8751	
1/8"	8752	

*High Strength Aluminum Alloy*



# AURALLOY<sup>®</sup> 620

## R ESEARCH

### EASY-FLOW ALUMINUM ALLOY WIRE

#### FEATURES

- Provides exceptional strength and ductility for general purpose joining, fabricating and repairing of most aluminum grades.
- Minimum preparation and low melt (950° - 1010°F) for ease of application.
- Thin flowing for tight fits.
- Excellent color match.

#### WELDING TECHNIQUES

Clean joint with wire brush removing grease and oxides. Apply Auralloy 620 Flux. Using excess acetylene (carburizing) flame, keep torch in constant motion to uniformly heat area. When flux turns to clear liquid, start adding alloy to the joint.

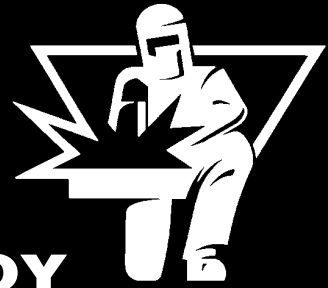
#### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

# AURALLOY<sup>®</sup> 630

**R** ESEARCH



## EZ-WELD ALUMINUM ALLOY

### PROPRIETARY BRAZING ROD FOR HIGH STRENGTH ALUMINUM REPAIR

- **SUPERIOR STRENGTH AND ADHESION** —  
PROVIDES PERMANENT SEAL AND STRENGTH WHEN SUBJECTED TO EXTREME PRESSURE
- **JOINTS STRONGER THAN PARENT METAL** —  
FOR STRENGTH AND DURABILITY
- **LOW HEAT REQUIREMENT (PROPANE TORCH APPLICATION)** —  
IS IDEAL FOR FIELD INSTALLATIONS AND REPAIRS
- **NON-CORROSIVE JOINTS** —  
WILL NOT DETERIORATE IN SALT WATER ENVIRONMENTS

### APPLICATIONS

**AUTOMOTIVE:** • Radiators • Manifolds • Transmission Housings • Pump Housings • Carburetors  
• Motorcycles • Running Boards • Mobile Homes • Recreational Vehicles

**TRADES:** • Plumbing • Heating and A/C • Power Tools • Farm Equipment • Storm Shutters • Screen Enclosures • Satellite Dishes • Sign Companies • Aluminum Awnings • Gutters and Down Spouts

**MARINE:** • Hulls • Leaking Rivets • Props • Brass & Bronze Fittings • Engine Parts

**HOUSEHOLD:** • Lawn Furniture • Lawn Mowers • Doors/Windows • Exercise Equipment • Bicycles  
• Fishing Rods • Antiques and Metal Work

### SPECIFICATIONS

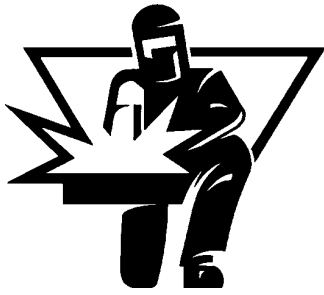
**SIZE**  
1/2 x 18"

**P/N**  
8733  
(includes s/s wire  
brush P/N 41340)

**MELTING RANGE:** 715°F - 730°F  
**DENSITY:** 25  
**ELONGATION:** 3%  
**TENSILE STRENGTH:** 47,000  
**COMPRESSION STRENGTH:** 60-75,000  
**SHEAR STRENGTH:** 34,000  
**ELECTRICAL CONDUCTIVITY:**  
24.9% of cu

**IMPACT STRENGTH:**  
(Charpy) 4 ft. lbs. to break 1/4" bar  
**THERMAL CONDUCTIVITY:**  
.24 cal/cu.cm  
**HARDNESS:** (Brinell 100)  
**CORROSION PENETRATION:**  
300 x 10 in 11-R  
**DUCTILITY:** Good

*No Specialty Equipment - No Flux or Scale - No Lead or Cadmium*



# AURALLOY<sup>®</sup> 630

RESEARCH

## EZ-WELD ALUMINUM ALLOY

### FEATURES

- Joints stronger than parent metal
- Easy machining of welded areas
- Non-corrosive joints
- Low heat requirement (propane torch application)
- No specialty equipment
- No flux or scale
- Contains no lead or cadmium
- Environmentally friendly

### WELDING TECHNIQUES

Clean the surface with a stainless steel brush. With a propane torch, heat the parent metal surface, NOT the EZ-Weld Aluminum Alloy. Apply EZ-Weld to the heated surface. Keep flame in motion. Allow weld to air-cool naturally. Never plunge into water.

**T-JOINTS:** For maximum strength, tin both members. Again, heat the parts, NOT the EZ-Weld and flow into the intersection. Stir solid end of EZ-Weld stick through the molten EZ-Weld to remove any trapped oxide.

**BUTT-JOINTS:** Bevel both ends and bring together. Tin both beveled surfaces, then lay bead of EZ-Weld into groove.

**LAP JOINTS:** Parts can be tinned and slid together while EZ-Weld is molten, or a generous fillet of EZ-Weld can be applied around the edges of the lap joint. Make sure of tinning by running the stock through the molten E-Z Weld Aluminum Alloy.

### WARNING

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- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*Alloy Brazing Rod for High Strength Aluminum Repair*

# AURALLOY<sup>®</sup> 710

**R** ESEARCH "PINK CADILLAC"



## PREMIUM FLUX COATED SILVER BRAZING ALLOY

### FOR TORCH BRAZING

- **HIGH 56% SILVER, CADMIUM-FREE FORMULATION** — PROVIDES THE ULTIMATE STRENGTH FOR JOINING ALL FERROUS AND MOST NON-FERROUS METALS
- **LOW WORKING TEMPERATURE (1120°F to 1185°F)** — FOR EXCELLENT FLOWING ACTION AND ADHESION
- **SUPER ACTIVE, FAST-FLOWING FLUX COATING** — PROVIDES TWICE THE BASE METAL CLEANSING ACTION OF CONVENTIONAL SILVER FLUX COATINGS. CLEANS THE MOST OXIDIZED STAINLESS STEEL SURFACES TO PROMOTE RAPID WETTING ACTION
- **SUPERIOR PERFORMANCE** — FLUX COATING IS TOTALLY FLEXIBLE AND CHIP RESISTANT

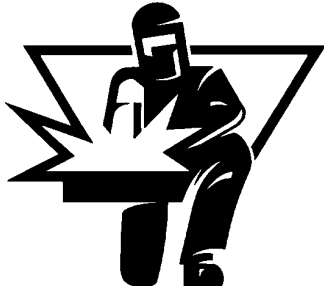
### APPLICATIONS

- All ferrous and non-ferrous metals, except aluminum and magnesium
- Manufacturing and repairing of all food and beverage equipment
- Thin flow joints on aerospace and aircraft applications
- Color matching on stainless steel and nickel
- Carbide tipping
- Joining medical tools and instruments
- Hospital carts and equipment

### SPECIFICATIONS

<b>SIZE</b>	<b>P/N</b>	<b>TENSILE STRENGTH:</b> 71,000 psi
1/16" x 18" (Pink Flux)	8786	<b>ELONGATION:</b> 25%
		<b>CORROSION RESISTANCE:</b> Excellent
		<b>MELTING TEMP.:</b> 1120°F Solidus, 1200°F Liquidus

*Precise Thin Flow Joining of All Ferrous and Most Non-Ferrous Metals*



# AURALLOY<sup>®</sup> 710

RESEARCH  
R

**"PINK  
CADILLAC"**

## **PREMIUM FLUX COATED SILVER BRAZING ALLOY**

### **FEATURES**

- Cadmium, lead and zinc-free
- High 56% silver content
- Precise thin flowing formulation
- Low working temperature (1120°F to 1185°F)
- Fast-flowing action
- Cleans oxidized surfaces to promote rapid wetting action
- Fast-flowing flux is bendable and chip resistant

### **WELDING TECHNIQUES**

Joint must be clean. For maximum strength, joint clearance should not exceed .003". Maintain alignment by use of fixtures and jigs. Preheat parts broadly with a slightly carburizing flame to 350°F. Then heat joint area to 800°F. Melt off some flux and allow to flow throughout joint. Melt a small amount of alloy onto the joint. **BASE METAL MUST NOT BE OVERHEATED.** After the part has cooled slowly, remove flux residue with warm water.

### **WARNING**

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- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away from your breathing zone and the general area.
- Wear correct eye, ear and body protection.
- Do not touch live electrical parts.
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*Super Active Flux Coated Silver Brazing Alloy  
High 56% Silver Content*

# AURALLOY<sup>®</sup> 800

**R** ESEARCH "RUBY"



**HIGH STRENGTH, NICKEL SILVER BRAZING ALLOY**

## EXTREMELY VERSATILE AND ABRASION RESISTANT

- **LOW MELT, OXYACETYLENE WELDING —**  
FOR FASTER, EASIER APPLICATION
- **THIN FLOWING —**  
FOR TIGHT FIT UP WORK
- **DENSE, TOUGH DEPOSITS —**  
ENSURES STRONG, NON-POROUS AND DURABLE WELDS
- **RAPIDLY BUILDS UP DEPOSITS —**  
FOR CLADDING OR REPLACING MISSING METAL
- **HIGHLY MACHINABLE —**  
SAVING TIME AND MONEY

## APPLICATIONS

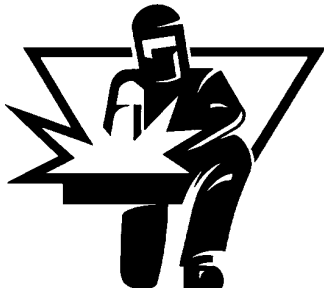
- Truck Body Liners
- Chutes
- Loading Platforms
- Crane Boom Tips
- Fan Blades
- Wear Plates
- Shovel Boom
- Fork Lifts
- Fifth Wheel Plates
- Dragline Buckets
- Dipper Buckets
- Oil Rigs
- Liquid Gas Tanks
- Hot or Cold Rolled Steel
- Tool Steel
- Stainless Steel
- High Carbon Steel
- Cast Iron
- Malleable Iron
- All Alloys of the Bronze, Copper and Nickel Family

## SPECIFICATIONS

SIZE	P/N	TENSILE STRENGTH: 100,000 psi
3/32"	8755	MELTING TEMP: 1,450°F
1/8"	8756	

*The Perfect Rod for the Most Difficult Applications*





# AURALLOY<sup>®</sup> 800

R ESEARCH  
"RUBY"

## HIGH STRENGTH, NICKEL SILVER BRAZING ALLOY

### FEATURES

For oxyacetylene welding of hot or cold rolled steel, tool steel, stainless steel, high carbon steel, cast iron, malleable iron, all alloys of the bronze, copper and nickel family and dissimilar metals (not white metals). Extremely versatile brazing rod with low melt (bonds at approximately 1450°F) and thin flowing for tight fits. Excellent for rapid build-up deposits for cladding or replacing missing metal. Tough, wear-resistant deposits (150 to 200 BHN) for strong, non-porous, lasting welds. Highly machinable and minimum preparation for rusty, dirty parts. Joining and fast build-up of metals and filling holes in steel and cast iron. Ideal for drive shafts, friction plates and gear teeth.

### WELDING TECHNIQUES

Heat the base metal until red hot and flux is liquid. Dip the rod into the base metal just behind the flame. Then back up the flame to "wet out" the deposit.

### WARNING

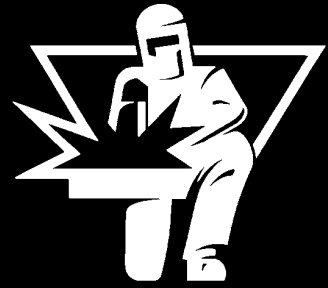
Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

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- Do not touch live electrical parts.
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*The Most Versatile Brazing Alloy . . .  
The Best Choice for the Maintenance Welder*

# AURALLOY<sup>®</sup> 810

**R** ESEARCH



**SELF-FLUXING,  
NON-FUMING STEEL WIRE**

## VERSATILE MILD STEEL BARE ROD FOR TORCH OR TIG BRAZING

- **COPPER METALLIC COATING —**  
INHIBITS RUST AND IMPROVES WELDABILITY
- **UNIQUE SELF-FLUXING DESIGN —**  
PROVIDES A SMOOTH, EVEN BEAD WITH NO WELD POROSITY
- **DENSE, TOUGH DEPOSITS —**  
ENSURES STRONG, NON-POROUS AND DURABLE WELDS
- **CAN BE USED IN ALL POSITIONS —**  
FOR EASE OF MACHINING, FILING OR SANDING

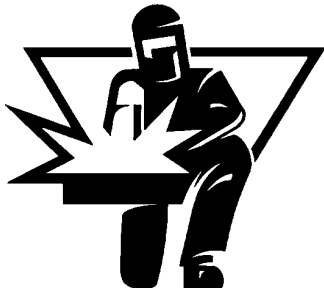
## APPLICATIONS

- Tanks
- Shafts
- Frames
- Hoods
- Brackets
- Machinery Guards
- Sheet Metal
- Vats
- Wire Mesh

## SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	TENSILE STRENGTH: 70,000 psi
1/16"	8760	
3/32"	8761	
1/8"	8762	

*High Quality, General Purpose Brazing Alloy*



# AURALLOY<sup>®</sup> 810

## R ESEARCH

### SELF-FLUXING, NON-FUMING STEEL WIRE

#### FEATURES

- General purpose joining of steel sheets, plates and pipe of low carbon analysis.
- Versatile mild steel bare rod for torch or tig brazing.
- Copper metallic coating inhibits rust and improves weldability.
- Provides a dense, smooth, even bead with no weld porosity.
- Can be used in all positions and is easily machined, filed or sanded.
- No flux is required for torch or tig brazing.

#### WELDING TECHNIQUES

Clean joint area to remove grease, paint, rust, dirt or moisture. Keep neutral flame in constant motion on the repair area. Add alloy to joint insuring weld bead has complete penetration of the joint. Flux is not required.

#### WARNING

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- Do not touch live electrical parts.
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*Versatility and Performance*

# AURALLOY® 820

RESEARCH



## HIGH STRENGTH THIN FLOWING BRONZE BRAZING ALLOY

### EASY BRAZING OF COPPER, BRONZE, BRASS AND NICKEL ALLOYS

- ▶ **SPECIAL FORMULATION —**  
JOINS AND REPAIRS NON-FERROUS METALS
- ▶ **PROVIDES DUCTILE DEPOSITS —**  
FOR VIBRATION RESISTANCE
- ▶ **SELF-FLUXING ON COPPER TO COPPER APPLICATIONS —**  
ASSURES EASE OF USE

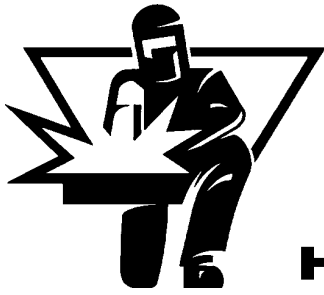
### APPLICATIONS

- Refrigeration
- Copper Wire and Cable
- Bus Bars
- Electrical Contacts
- Piping
- Air Conditioning
- Plumbing
- Marine Equipment

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<b>TENSILE STRENGTH: 46,000 psi</b>
1/16"	8765	<b>WORKING TEMP.: 1300°F to 1460°F</b>
3/32"	8766	
1/8"	8767	

*Superior Non-Ferrous Metal Brazing*



# AURALLOY<sup>®</sup> 820

## R ESEARCH

### HIGH STRENGTH THIN FLOWING BRONZE BRAZING ALLOY

#### FEATURES

- Ideal for joining and repairing thin sheet metal, tubing and fittings made of non-ferrous metals.
- Self-fluxing on copper to copper applications.
- Ductile deposits withstand vibration.
- High electrical and heat conductivity.
- Easily machined.
- Strong corrosion and wear properties.

#### WELDING TECHNIQUES

Clean joint area to remove grease and dirt. Use a slightly oxidizing flame and keep flame as low as possible to obtain a free-flowing bead. On copper to copper welds, flux is not required. Use Auralloy 825 Flux for other materials. All joints should be tight fitting. As flux liquifies, melt off a small amount of alloy and continue heating until bonding is complete. Do not overheat. Remove excess flux with water and a clean brush.

#### WARNING

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*Easy Brazing of Copper,  
Bronze, Brass and Nickel Alloys*

# AURALLOY<sup>®</sup> 830

**R** ESEARCH



## HIGH STRENGTH SILICON BRONZE BRAZING ALLOY

### IDEAL FOR DISSIMILAR METAL APPLICATIONS

- ▶ **HIGHLY CORROSION RESISTANT DEPOSITS —**  
INHIBITS RUST AND IMPROVES WELDABILITY
- ▶ **EXTREMELY VERSATILE —**  
JOINS COPPER BASED METALS TO THEMSELVES OR GALVANIZED STEEL
- ▶ **SUITABLE FOR THIN FLOW OR BEAD FORMING DEPOSITS —**  
ENSURING STRONG, NON-POROUS AND DURABLE WELDS

### APPLICATIONS

- Galvanized Parts
- Castings
- Marine Repairs
- Valves and Seats
- Tubing
- Fittings
- Joints and overlays on steel, copper, brass, bronze, naval brass and galvanized sections

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<b>TENSILE STRENGTH:</b> 64,000 psi
1/16"	8770	<b>WORKING TEMP.:</b> 1450°F to 1600°F
3/32"	8771	

*High Strength, Versatility and Ease of Application*



# AURALLOY<sup>®</sup> 830

## R ESEARCH

### HIGH STRENGTH SILICON BRONZE BRAZING ALLOY

#### FEATURES

- Joins copper, copper-silicon and copper-zinc based metals to themselves or to mild or galvanized steel.
- Highly corrosion resistant.
- Eliminates "burn-through" on galvanized coatings.
- Ideal for dissimilar metal applications.
- Suitable for thin flow or bead forming deposits.
- Non-fuming.

#### WELDING TECHNIQUES

Clean joint area to remove grease and dirt. Use Auralloy 825 Flux. With a slightly oxidizing flame, heat work until flux liquifies. Keep weld puddle small to assure rapid solidification and to avoid contraction strains. Remove flux residue with hot water and a clean stiff brush.

#### WARNING

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*Join or Repair Copper, Copper-Silicon  
and Copper-Zinc Based Metals*

# AURALLOY<sup>®</sup> 840

R ESEARCH

"SAPPHIRE"



**"SAFE VUE" MOISTURE SEALED FLUX  
COATED BRONZE BRAZING ALLOY**

## EASY BRAZING OF STEEL CAST IRON AND COPPER BASE ALLOYS

- **UNIQUE "SAFE VUE" FLUX COATING —**  
ELIMINATES HARSH CHEMICAL ODORS AND THE BRIGHT ORANGE VISIBILITY  
BLOCKING GLARE OF CONVENTIONAL SODIUM TYPE FLUX COATINGS
- **SLICK, SMOOTH MOISTURE SEALED FLUX —**  
HAS TRIPLE THE SHELF LIFE OF SIMILAR PRODUCTS
- **FLUX CLEANSING ACTION —**  
EXCEPTIONAL ON DIRTY STEELS AND CAST IRONS
- **CAN BRAZE COPPER BASE ALLOYS —**  
WITHOUT MELTING BASE
- **NO CRACKING —**  
TOTALLY FLEXIBLE COATING

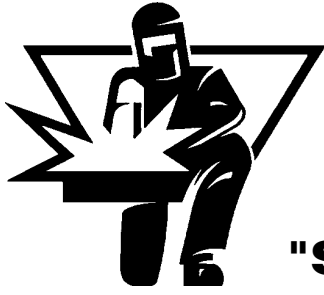
## APPLICATIONS

- Bearings
- Bushings
- Cams
- Cast Iron
- Carbide Tipping
- Chain Saws
- Drills
- Jig and Fixtures
- Levers
- Linkage
- Piping
- Racks
- Shaft Repair

## SPECIFICATIONS

SIZE	P/N	TENSILE STRENGTH: 71,000 psi
1/16"	8860	WORKING TEMP.: 1595°F
3/32"	8861	
1/8"	8862	





# AURALLOY<sup>®</sup> 840

RESEARCH  
"SAPPHIRE"

## "SAFE VUE" MOISTURE SEALED FLUX COATED BRONZE BRAZING ALLOY

### FEATURES

- Unique "Safe Vue" flux coating eliminates harsh chemical odors and the bright orange visibility blocking glare of conventional sodium type flux coatings.
- Slick, smooth moisture sealed flux has triple the shelf life of similar products.
- Flux cleansing action is exceptional on dirty steels and cast irons.
- Can braze copper base alloys without melting base.
- No cracking – totally flexible coating.

### WELDING TECHNIQUES

Clean joint area to remove grease and dirt. Pre-heat general area to 700°F (400°C) and then specific area to 1200°F (650°C). Melt off flux and apply alloy.

### WARNING

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*Triple Deoxidized Bronze Brazing Alloy*

# AURALLOY<sup>®</sup> 900

R ESEARCH "GRANITE"



## HARD SURFACING ELECTRODE

### SUPERIOR IMPACT AND ABRASION RESISTANCE

- **EXCEPTIONAL HARD SURFACING ALLOY —**  
PRODUCES OUTSTANDING IMPACT AND ABRASION RESISTANCE
- **IDEAL ALLOY COMBINATION —**  
PROVIDES SUPERIOR HARDNESS AND TOUGHNESS ON CARBON AND ALLOY STEELS, MANGANESE STEELS AND CAST IRON
- **HIGH DEPOSITION RATE —**  
FOR MAXIMUM WEAR RESISTANCE WITH LITTLE OR NO SPATTER
- **PROLONGS SERVICE LIFE OF NEW AND WORN PARTS —**  
AVOIDING EXPENSIVE REPLACEMENT COSTS

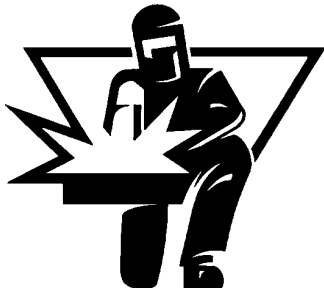
### APPLICATIONS

- Agricultural, Construction, Industrial, Mining and Municipal Equipment of all types where wear is a problem
- Crusher Jaws; Hammers; Bucket Lips and Teeth
- Wear plates; Pins; Axles; Shafts; Cams; Eccentrics

### SPECIFICATIONS

<u>SIZE</u>	<u>P/N</u>	<u>AMPERAGE</u>	<b>HARDNESS:</b> RC 56-60
1/8"	8735	80-135	<b>CURRENT:</b> AC or DC
5/32"	8736	120-160	On DC use reverse polarity
			<b>POSITION:</b> All

*For All Hard Surfacing Applications*



# AURALLOY<sup>®</sup> 900

RESEARCH  
"GRANITE"

## HARD SURFACING ELECTRODE

### FEATURES

- A truly unique electrode combining unsurpassed weldability plus superior impact and abrasion resistance and high hardness.
- The ideal alloy combination where hardness and toughness are required on carbon and alloy steels, manganese steels and cast iron.

### WELDING TECHNIQUES

Prepare weld surface by chamfering to remove old overlays and loosely adhering metal. Use a cushion, if required. Deposit the electrode using any technique applicable such as stringer beading or weaving up to 4X. Allow each layer to cool before continuing. Remove slag between passes.

### WARNING

Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*Superior Hardness and Protection Against Wear*

# AURALLOY<sup>®</sup> 910

**R** RESEARCH

## HARD FACING CHROMIUM CARBIDE TUBULAR ELECTRODE



### SUPERIOR IMPACT AND ABRASION RESISTANCE

- **FOR MANUAL APPLICATION TO LARGE PARTS —**  
WHERE DEPOSITION RATE AND JOB COMPLETION TIMES ARE PARAMOUNT
- **EASY TO USE —**  
AND OFFERS THE GREATEST RANGE OF CARBIDE BEARING ALLOYS TO OVERCOME A GREAT VARIETY OF WEAR CAUSED BY ABRASION, EROSION, IMPACT AND HEAT
- **DESIGNED FOR ALL POSITION WELDING —**  
AND CAN BE USED AT LOW AMPERATURE TO HARDFACE THIN EDGES ON TILLAGE TOLS AND SIMILAR PARTS
- **A PROPRIETARY COATING FORMULATION IS COMPLETELY MOISTURE RESISTANT —**  
AND WILL SURVIVE STORAGE IN DAMP CONDITIONS FOR YEARS
- **CAN BE APPLIED TO CAST IRON, MANGANESE STEEL —**  
AND MILD STEEL WITHOUT PREHEAT; HIGH CARBON AND ALLOY STEELS MAY REQUIRE PREHEAT

### APPLICATIONS

- Ideal for hardfacing parts made from austenitic manganese steel.
- Dredge bucket lips, crusher jaws, crusher mantles and liners, manganese steel swing hammers, quarry screen plates, grizzly bars and feeder spots and shovel buckets.

### SPECIFICATIONS

**SIZE**  
1/4 x 18"

**P/N**  
8739

**HARDNESS:** RC 55-60

**CURRENT:** AC or DC Welding Power Sources

**POSITION:** All

*For Applications Subject to High Abrasion,  
Compressive Impact Loads and Erosion*



# AURALLOY<sup>®</sup> 910

## R ESEARCH

### **HARD FACING CHROMIUM CARBIDE TUBULAR ELECTRODE**

#### **FEATURES**

- For manual applications to large parts where deposition rate and job completion times are paramount.
- Easy to use and offers the greatest range of carbide bearing alloys to overcome a great variety of wear caused by abrasion, erosion, impact and heat.
- Designed for all position welding and can be used at low amperature to hardface thin edges on tillage tools and similar parts.
- A proprietary coating formulation is completely moisture-resistant and will survive storage in damp conditions for years.
- Can be applied to cast iron, manganese steel and mild steel without preheat; high carbon and alloy steels may require preheat.

#### **WELDING TECHNIQUES**

Prepare weld surface by chamfering to remove old overlays and loosely adhering metal. Use a cushion, if required. Deposit the electrode using any technique applicable such as stringer beading or weaving up to 4X. Allow each layer to cool before continuing. Remove slag between passes.











#### **WARNING**











Protect yourself and others. Read and understand this label. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can kill.

- Read and understand the manufacturer's instructions and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases away 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 and Cutting published by the American Welding Society, 550 North LeJeune Road, Miami, Florida, 33135; OSHA Safety and Health Standards, 29 CFR 1910, available from the U.S. Government Printing Office, Washington, D.C. 20402.

*For Applications Subject to High Abrasion,  
Compressive Impact Loads and Erosion*

# IDENTIFICATION OF METALS

TEST	METAL			
	Manganese Steel	Stainless Steel	Cast Iron	Wrought Iron
 <i>Appearance</i>	DULL CAST SURFACE	BRIGHT, SILVERY SMOOTH	DULL GREY EVIDENCE OF SAND MOLD	LIGHT GREY SMOOTH
 <i>Magnetic</i>	NON-MAGNETIC	DEPENDS ON EXACT ANALYSIS	STRONGLY MAGNETIC	STRONGLY MAGNETIC
 <i>Chisel</i>	EXTREMELY HARD TO CHISEL	CONTINUOUS CHIP SMOOTH BRIGHT COLOR	SMALL CHIPS ABOUT 1/8 INCH. NOT EASY TO CHIP, BRITTLE	CONTINUOUS CHIP SMOOTH EDGES SOFT AND EASILY CUT AND CHIPPED
 <i>Fracture</i>	COARSE GRAINED	DEPENDS ON TYPE BRIGHT	BRITTLE	BRIGHT GREY FIBROUS APPEARANCE
 <i>Flame</i>	MELTS FAST BECOMES BRIGHT RED BEFORE MELTING	MELTS FAST BECOMES BRIGHT RED BEFORE MELTING	MELTS SLOWLY BECOMES DULL RED BEFORE MELTING	MELTS FAST BECOMES BRIGHT RED BEFORE MELTING
 <i>Spark</i> <small>*For best results, use at least 5,000 surface feet per minute on grinding equipment. (Cir. x R.P.M. = S.F. per Min.) 12</small>	 Bright White Fan-Shaped Burst	 1. Nickel-Black Shape close to wheel. 2. Moly-Short Arrow Shape Tongue (only). 3. Vanadium-Long Spearpoint Tongue (only).	 Red Carrier Lines (Very little carbon exists)	 Long Straw Color Lines (Practically free of bursts or sprigs)

TEST	METAL			
	Low Carbon Steel	Medium Carbon Steel	High Carbon Steel	High Sulphur Steel
 <i>Appearance</i>	DARK GREY	DARK GREY	DARK GREY	DARK GREY
 <i>Magnetic</i>	STRONGLY MAGNETIC	STRONGLY MAGNETIC	STRONGLY MAGNETIC	STRONGLY MAGNETIC
 <i>Chisel</i>	CONTINUOUS CHIP SMOOTH EDGES CHIPS EASILY	CONTINUOUS CHIP SMOOTH EDGES CHIPS EASILY	HARD TO CHIP CAN BE CONTINUOUS	CONTINUOUS CHIP SMOOTH EDGES CHIPS EASILY
 <i>Fracture</i>	BRIGHT GREY	VERY LIGHT GREY	VERY LIGHT GREY	BRIGHT GREY FINE GRAIN
 <i>Flame</i>	MELTS FAST BECOMES BRIGHT RED BEFORE MELTING	MELTS FAST BECOMES BRIGHT RED BEFORE MELTING	MELTS FAST BECOMES BRIGHT RED BEFORE MELTING	MELTS FAST BECOMES BRIGHT RED BEFORE MELTING
 <i>Spark</i> <small>*For best results, use at least 5,000 surface feet per minute on grinding equipment. (Cir. x R.P.M. = S.F. per Min.) 12</small>	 Long Yellow Carrier Lines (Approx. .20% carbon or below)	 Yellow Lines Sprigs Very Plain Now (Approx. .20% to .45% carbon)	 Yellow Lines Bright Burst Very Clear Numerous Star Burst (Approx. .45% carbon and above)	 Swelling Carrier Lines Cigar Shape



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# AURALLOY CROSS REFERENCE TABLE

AURALLOY PRODUCT	TS ALLOYS	PART #	DIAMETER	DESCRIPTION	TENSILE STRENGTH	BOWMAN	CERTANIUM	CRONATRON	EUTECTIC	X-ERGON
<b>210</b>	Blue Velvet	8700, 8701, 8702	3/32, 1/8, 5/32	<b>General Purpose Steel Electrode</b> Welding all mild steels. Flux coated.	85,000 psi 29% elongation	25120	702, 704	338	Beautyweld 666, 3001, 6000	106
<b>220</b>	—	8705, 8706, 8707, 8708	3/32, 1/8, 5/32, 3/16	<b>Superior Strength Steel Electrode</b> Welding low alloy, carbon and cast steels. Flux coated.	120,000 psi 28% elongation	—	705	375	110	102
<b>225</b>	Thunder-bolt	8709, 8710, 8711, 8712	1/16, 3/32, 1/8, 5/32	<b>High Tensile Strength Steel Electrode</b> Welding all types and grades of similar and dissimilar steels. Flux coated.	128,000 psi 36% elongation	25180	707, 770 MOX	333	Fantastec 680, 3026, 680 CGS	100XL, 171B, Unique 100, 1000 HPM
<b>225-B</b>	—	8728, 8729, 8730	1/16, 3/32, 1/8	<b>High Tensile Strength Bare Steel Rod</b> Welding all steels.	128,000 psi	—	76SL	388 TIG	Tigtectic BMO	122 TIG 1000 HPM
<b>225-V</b>	—	8718, 8719	3/32, 1/8	<b>Vertical Position Steel Electrode</b> Special vertical position high strength electrode for dissimilar steels.	128,000 psi 32% elongation	25180	707, 770 MOX	333	Fantastec 680, 3026, 680 CGS	100XL, 171B, Unique 100
<b>250</b>	Sterling	8714, 8715, 8716, 8717	1/16, 3/32, 1/8, 5/32	<b>Universal Stainless Steel Electrode</b> Welding most grades of stainless steels, carbon steels, alloy steels and stainless steels of unknown analysis. Flux coated.	95,000 psi 45% elongation	25370	709	377	Stainrode D, 57, 670	—
<b>250-B</b>	—	8740, 8741, 8742	1/16, 3/32, 1/8	<b>Universal Stainless Steel Bare Rod</b> Welding all types of stainless steels.	86,000 psi 45% elongation	—	707 TIG	333 TIG	Tigtectic 680 57, 670	Xinect 100XL
<b>255</b>	Cascade	8737, 8738	3/32, 1/8	<b>Vertical Position Stainless Steel Electrode</b> Vertical down/up welding of stainless steels. Flux coated.	80,000 psi 42% elongation	—	—	—	—	—
<b>300</b>	Midnight	8720, 8721, 8722, 8723	3/32, 1/8, 5/32, 3/16	<b>Ductile Cast Iron Electrode</b> Welding all grades of cast iron and alloyed cast iron. Flux coated.	70,000 psi 40% elongation	25250	889	211	223, 225, 232, 2233, 3055, 2255	131
<b>310</b>	—	8746, 8747	3/32, 1/8	<b>Machinable Cast Iron Electrode</b> Welding all grades of cast iron and alloyed cast iron. Flux coated.	55,000 psi	25270	887	222	224, 244, 240, 2240, 3099	—
<b>400</b>	Turbo	8724, 8725, 8726	3/32, 1/8, 5/32	<b>Cutting and Chamfering Electrode</b> Rapid metal removal on cast iron, stainless steel, inconel, manganese and aluminum. Flux coated.	—	25310	100	110	Chamferrode, Cuttrode, Exotrode	161
<b>500</b>	—	8775, 8776, 8778, 8779, 8780	1/16 - 1/2 & 1 lb. 1/8 - 1/2 & 1 lb. 1.0 oz. tube	<b>Super Strength Self-Fluxing Silver Solder</b> Soldering all steels, including stainless and chrome plated, copper and nickel alloys and dissimilar combinations of these metals. No white metals. (Use Auralloy 500 Flux)	15,000 psi	—	—	—	—	—
<b>600</b>	White Lightning	8731, 8732	1/8, 5/32	<b>Aluminum Arc Welding / Brazing Rod</b> Welding all types and grades of aluminum.	34,000 psi	25360	608	510	2101, 3021, 2109	141
<b>610</b>	—	8745	1/8	<b>High Strength Flux-Cored Aluminum Brazing Alloy</b> Torch brazing of all weldable aluminum.	30,000 psi	877	—	54C	21FC-E	—
<b>620</b>	—	8750, 8751, 8752	1/16, 3/32, 1/8	<b>Easy Flow Aluminum Alloy Wire</b> Welding most grades of aluminum. (Use Auralloy 620 Flux)	35,000 psi	24970	65/66	55	190	241
<b>710</b>	Pink Cadillac	8786	1/16 Pink Flux	<b>Premium Flux Coated Silver Brazing Alloy</b> Brazing alloy for use on all ferrous and most non-ferrous metals, except aluminum and magnesium. (Use Auralloy 700 Flux)	71,000 psi	24870	54	43F, 40F	1030FC, 1020FC, 1020XFC, 1801FC	261, 262
<b>800</b>	Ruby	8755, 8756	3/32, 1/8	<b>High Tensile Strength Brazing Rod</b> Brazing hot or cold rolled steels, tool steels, stainless and high carbon steels, cast iron, malleable iron, all alloys of bronze, copper and nickel and dissimilar metals. (Use Auralloy 825 Flux)	100,000 psi	908, 914	87F, 70F	30F	185FC, 185XFC, 16, 16FC, 16XFC	201
<b>810</b>	—	8760, 8761, 8762	1/16, 3/32, 1/8	<b>Self-Fluxing, Non-Fuming Steel Wire</b> Brazing steel sheets, plates and pipe of low carbon analysis. (Use 825 Flux)	70,000 psi	—	—	—	—	—
<b>820</b>	Sapphire	8765, 8766, 8767	1/16, 3/32, 1/8	<b>High Strength Bronze Brazing Alloy</b> Brazing copper, copper alloys, bronze, brass and nickel. (Use 825 Flux)	46,000 psi	—	50	44	180	263
<b>830</b>	—	8770, 8771	1/16, 3/32	<b>High Strength Silicon Bronze Brazing Alloy</b> Brazing copper based metals, galvanized steel and dissimilar metals. (Use Auralloy 825 Flux)	64,000 psi	25000	71F, 83F	21, 23F	18FC, 146FC, 18FXC, 146XFC, 145FC, 3046XFC	205, 207
<b>900</b>	Granite	8735, 8736	1/8, 5/32	<b>Abrasion Resistant Hard Surfacing Electrode</b> Welding carbon and alloy steels, manganese steels & cast iron. Flux coated.	Rockwell "C" Hardness 56-60	25350	250	—	3005, N5005, N6006 N6712, N6715	174, 176, 178

# AURALLOY PRODUCT APPLICATIONS

AURALLOY PRODUCT #	TYPE OF ACCOUNTS	TYPICAL APPLICATIONS
<b>210</b>	<ul style="list-style-type: none"> <li>• Airlines • Asphalt/Cement Plants • Contractors • Farms, Golf Courses, Parks, Cemeteries</li> <li>• Fleets, Bus Lines • Food Processing • Garages/Body Shops • Hospitals, Hotels, Schools</li> <li>• Mines, Quarries • Plant Maintenance • Welding Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Brackets • Ducts • Floor Plates • Frames • Galvanized Iron • Guards • Piping</li> <li>• Scaffolding • Shelving • Tanks • Trucks</li> </ul>
<b>220</b>	<ul style="list-style-type: none"> <li>• Airlines • Asphalt/Cement Plants • Contractors • Farms, Golf Courses, Parks, Cemeteries</li> <li>• Fleets, Bus Lines • Food Processing • Garages/Body Shops • Hospitals, Hotels, Schools</li> <li>• Mines, Quarries • Plant Maintenance • Welding Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Axles • Bearings • Blades • Brackets • Bumpers • Chain • Conveyors</li> <li>• Fork Lift Tines • Floor Plates • Gears • Hoppers • Levers • Rails • Scaffolding</li> <li>• Shafts • Shelves • Tanks • Tow Bars • Wheels</li> </ul>
<b>225 225-B 225-V</b>	<ul style="list-style-type: none"> <li>• Airlines • Asphalt/Cement Plants • Contractors • Farms, Golf Courses, Parks, Cemeteries</li> <li>• Fleets, Bus Lines • Food Processing • Garages/Body Shops • Hospitals, Hotels, Schools</li> <li>• Mines, Quarries • Plant Maintenance • Welding Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Arms • Asphalt Mixer Paddles • Augers • Axles • Bars • Bearings • Blades</li> <li>• Bucket Teeth • Bumpers • Cases • Chain • Chisels • Conveyors • Crane Booms</li> <li>• Drills • Fork Lift Tines • Frames • Hoppers • Housings • Impellers • Levers</li> <li>• Lift Truck Tines • Mowers • Pneumatic Bits • Rails • Rams • Shafts • Skids</li> <li>• Snow Plows • Springs • Tools • Tow Bars/Hooks • Wheels</li> </ul>
<b>250 250-B 255</b>	<ul style="list-style-type: none"> <li>• Farms, Golf Courses, Parks, Cemeteries • Food Processing</li> <li>• Hospitals, Hotels, Schools • Welding Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Agitator Blades • Cafeteria Equipment • Dairy Equipment • Heat Exchangers • Impellers</li> <li>• Keyways • Paddles • Processing Equipment • Tanks • Tubing • Vats</li> </ul>
<b>300 310</b>	<ul style="list-style-type: none"> <li>• Airlines • Asphalt/Cement Plants • Contractors • Farms, Golf Courses, Parks, Cemeteries</li> <li>• Fleets, Bus Lines • Food Processing • Garages/Body Shops • Hospitals, Hotels, Schools</li> <li>• Mines, Quarries • Plant Maintenance • Welding Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Arms • Bell Housings • Bosses • Cylinder Heads • Dollies • Engine Blocks</li> <li>• Exhaust Manifolds • Farm Implements • Flywheels • Gears • Housings • Landing Gear</li> <li>• Levers • Machine Bases • Molds • Mowers • Oil Pans • Ornamental Iron Work</li> <li>• Pulleys • Pumps • Valves • Water Jackets • Wheels</li> </ul>
<b>400</b>	<ul style="list-style-type: none"> <li>• Contractors • Electronic/Electrical Repair Shops • Farms, Golf Courses, Parks, Cemeteries</li> <li>• Fleets, Bus Lines • Garages/Body Shops • Mines, Quarries • Plant Maintenance</li> <li>• Welding Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Cutting • Grooving • Gouging • Piercing • Bolt Removal • Sheet Cutting</li> <li>• Fabrication</li> </ul>
<b>500</b>	<ul style="list-style-type: none"> <li>• Airlines • Contractors • Farms, Golf Courses, Parks, Cemeteries • Fleets, Bus Lines</li> <li>• Garages/Body Shops • Mines, Quarries • Plant Maintenance • Welding Repair Shops</li> <li>• Electronic / Electrical Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Air Conditioning and Refrigeration • Auto Radiators • Chrome Plated Fittings</li> <li>• Electrical Connections • Evaporators • Food and Beverage Containers • Machine Guides</li> <li>• Regulations and Meters • Sanitary Equipment • Toilet Fixtures • Toy and Hobby Repair</li> </ul>
<b>600 610 620</b>	<ul style="list-style-type: none"> <li>• Farms, Golf Courses, Parks, Cemeteries • Fleets, Bus Lines • Food Processing</li> <li>• Garages/Body Shops • Plant Maintenance • Welding Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Blocks • Cafeteria Equipment • Cases • Cylinder Heads • Housings • Mixers</li> <li>• Paddles • Piping • Structural Members • Tanks • Truck &amp; Trailer Bodies • Vats</li> </ul>
<b>710</b>	<ul style="list-style-type: none"> <li>• Airlines • Farms, Golf Courses, Parks, Cemeteries • Fleets, Bus Lines</li> <li>• Food Processing • Garages/Body Shops • Hospitals, Hotels, Schools</li> <li>• Plant Maintenance • Welding Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Manufacturing and Repairing Food and Beverage Equipment • Carbide Tipping</li> <li>• Color Matching Stainless Steel and Nickel • Joining Medical Tools and Instruments</li> <li>• Hospital Carts and Equipment • Thin Flow Joints on Aerospace and Aircraft Applications</li> </ul>
<b>800 810 820 830</b>	<ul style="list-style-type: none"> <li>• Airlines • Farms, Golf Courses, Parks, Cemeteries • Fleets, Bus Lines</li> <li>• Garages/Body Shops • Hospitals, Hotels, Schools</li> <li>• Plant Maintenance • Welding Repair Shops</li> </ul>	<ul style="list-style-type: none"> <li>• Arms • Bearings • Brackets • Cams • Cast Legs • Chain • Coils • Cylinder Heads</li> <li>• Drill Bit Extensions • Drill Tangs • Elongated Holes • Faucets • Floor Plates • Furniture</li> <li>• Gears • Guards • Guides • Hand Rails • Housings • Hubs • Impellers • Keyways</li> <li>• Levers • Lugs • Machining Errors • Manifolds • Mild Steel Piping • Missing Sections</li> <li>• Mufflers • Oil Pans • Piping • Pulleys • Pumps • Shafts • Sheet Repair • Tail Pipes</li> <li>• Tools • Trucks • Tubes • Valves</li> </ul>
<b>900</b>	<ul style="list-style-type: none"> <li>• Asphalt/Cement Plants • Contractors • Mines, Quarries</li> </ul>	<ul style="list-style-type: none"> <li>• Augers • Blades • Buckets • Chutes • Concrete Cutter Wheels • Crusher Concaves</li> <li>• Feeder Sprockets • Hammers • Hoppers • Impellers • Jaws</li> </ul>



**WELDING ELECTRODES**

AURALLOY 210		
SIZE	PART	
3/32 x 12"	E	8936
1/8 x 14"	E	8937
5/32 x 14"	E	8938

AURALLOY 220		
SIZE	PART	
3/32 x 12"	B	8940
1/8 x 14"	B	8941
5/32 x 14"	B	8942
3/16 x 14"	B	8943

AURALLOY 225 & 225MIG		
SIZE	PART	
3/32 x 10"	E	8945
1/8 x 14"	E	8946
5/32 x 14"	E	8947
.035 (1 lb.)	A	98727

AURALLOY 225-V		
SIZE	PART	
3/32 x 10"	B	8944
1/8 x 14"	B	8948

AURALLOY 230		
SIZE	PART	
3/32 x 14"	B	8953
1/8 x 14"	B	98851
5/32 x 14"	B	98852
3/16 x 14"	B	8957

AURALLOY 240		
SIZE	PART	
1/8 x 14"	A	8939

AURALLOY 250		
SIZE	PART	
1/16 x 9-1/2"	A	8949
3/32 x 12"	B	8950
1/8 x 14"	B	8951
5/32 x 14"	B	8952

AURALLOY 255		
SIZE	PART	
3/32 x 14"	B	98737
1/8 x 14"	B	98738

AURALLOY 300		
SIZE	PART	
3/32 x 14"	B	8954
1/8 x 14"	B	8955
5/32 x 14"	B	8956

AURALLOY 310		
SIZE	PART	
3/32 x 10"	B	8998
1/8 x 14"	B	8999

AURALLOY 320		
SIZE	PART	
3/32 x 14"	B	98855
1/8 x 14"	B	98856
5/32 x 14"	B	98857

AURALLOY 400		
SIZE	PART	
1/8 x 14"	B	8959
5/32 x 14"	B	8960
3/32 x 14"	B	8958

AURALLOY 600		
SIZE	PART	
1/8 x 14"	B	8962
5/32 x 14"	B	8963

AURALLOY 900		
SIZE	PART	
1/8 x 14"	B	8965
5/32 x 14"	B	8966

AURALLOY 910		
SIZE	PART	
1/4 x 18"	A	8961

**BRAZING/SOLDER/TIG ALLOYS**

AURALLOY 225-B		
SIZE	PART	
1/16 x 36"	B	8995
3/32 x 36"	B	8996
1/8 x 36"	B	8997

AURALLOY 250-B		
SIZE	PART	
1/16 x 36"	B	8968
3/32 x 36"	B	8969
1/8 x 36"	B	8970

AURALLOY 810		
SIZE	PART	
1/16 x 36"	E	8984
3/32 x 36"	E	8985
1/8 x 36"	E	8986

AURALLOY 620		
SIZE	PART	
1/16 x 36"	B	8974
3/32 x 36"	B	8975
1/8 x 36"	B	8976

AURALLOY 710		
SIZE	PART	
1/16 x 18" (Pink Flux)	F	8980

AURALLOY 800		
SIZE	PART	
3/32 x 18"	B	8981
1/8 x 18"	B	8982

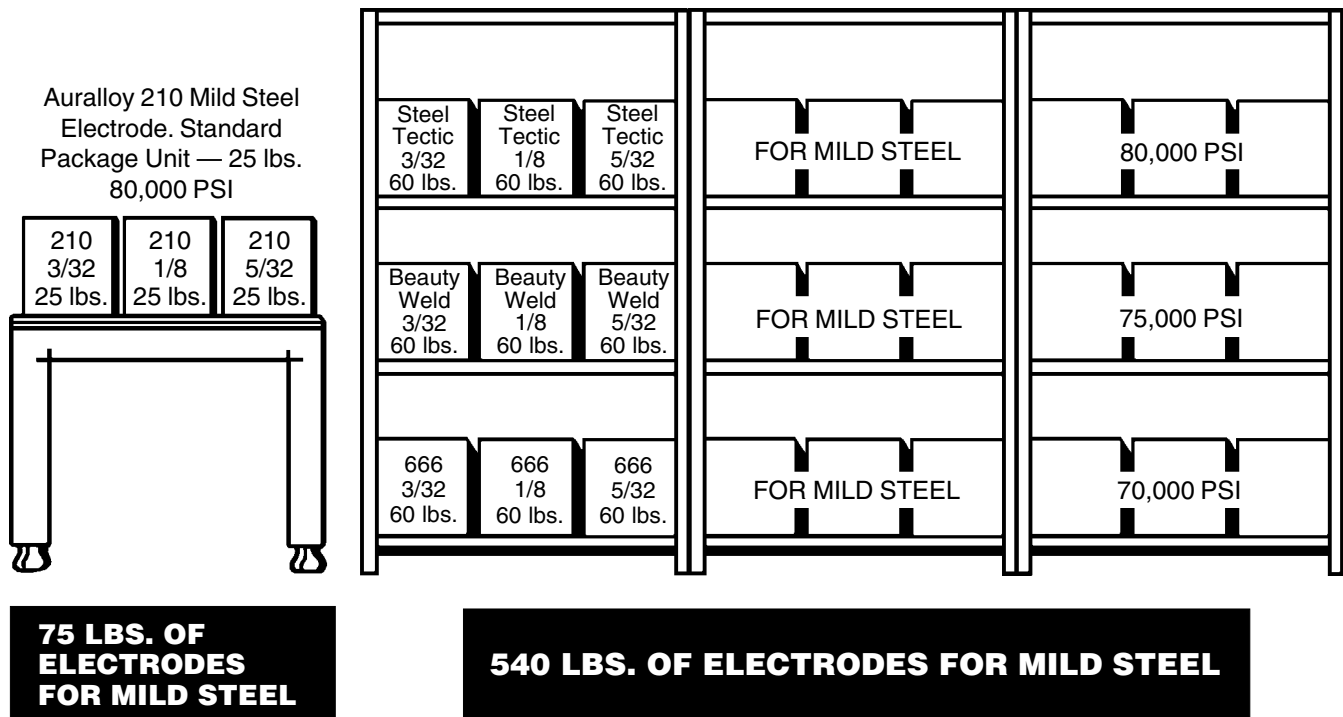
AURALLOY 610		
SIZE	PART	
1/8 x 32"	B	8972

AURALLOY 820		
SIZE	PART	
1/16 x 36"	B	8988
3/32 x 36"	B	8989
1/8 x 36"	B	8990

AURALLOY 830		
SIZE	PART	
1/16 x 36"	B	8992
3/32 x 36"	B	8993

AURALLOY 840		
SIZE	PART	
1/16 x 36"	B	98860
3/32 x 36"	B	98861
1/8 x 36"	B	98862

When you compare the products offered by Eutectic, Certanium, Cronatron and Nassau, you will find that they each offer up to 3 or more products with different numbers or colors that are meant to do the same job. This is **Duplication**, and results in overstock. Auralloy will supply you with only one product to avoid duplication and eliminate the excessive dollar waste. To further illustrate our point, compare and save dollars.



*With Auralloy — No More Confusion —  
The Right Rod Every Time*

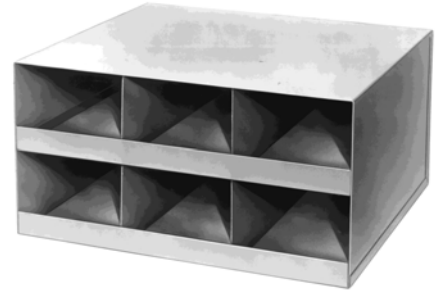
### AURALLOY OFFERS:

- **The Best Materials for the Best Results.**
- **The Right Tool for the Right Job.**
- **Quality Alloys Researched and Developed Strictly for the Maintenance and Repair Welder . . . See For Yourself.**



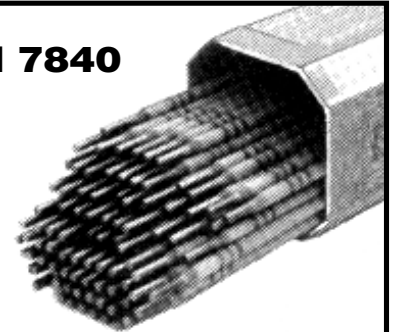
# MAINTENANCE WELDING ROD STARTER ASSORTMENT

*Five Of Our Most Popular  
Maintenance Welding Rods  
Used By Our Customers*



- A TOTAL OF 13 LBS. OF ROD
- LABELED CABINET
- EASY IDENTIFICATION

**P/N 7840**



**AURALLOY 210**  
1/8" - 85,000 PSI

***General Purpose Steel Electrode***  
Welding all mild steels. Flux coated.

**AURALLOY 220**  
1/8" - 120,000 PSI

***Superior Strength Steel Electrode***  
Welding low alloy, carbon and cast steels. Flux coated.

**AURALLOY 225**  
1/8" - 128,000 PSI

***High Tensile Strength Steel Electrode***  
Welding all types and grades of similar and dissimilar steels. Flux coated.

**AURALLOY 300**  
1/8"  
40% ELONGATION

***Ductile Cast Iron Electrode***  
Welding all grades of cast iron and alloyed cast iron.  
Flux coated.

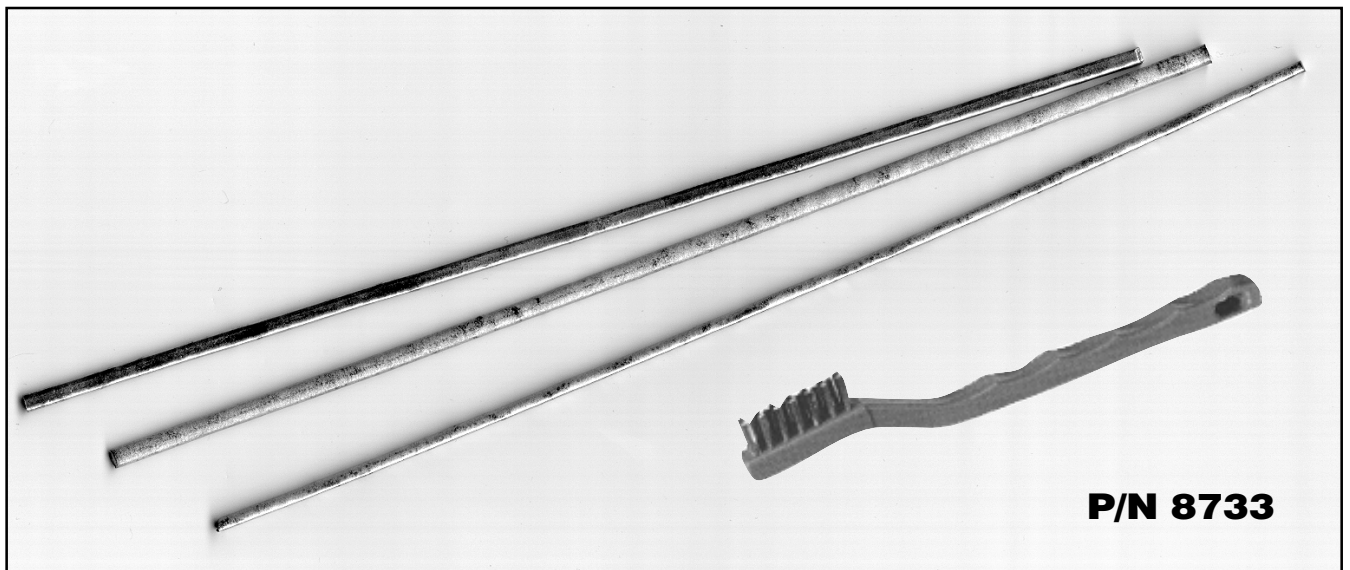
**AURALLOY 800**  
3/32" - 100,000 PSI

***High Tensile Strength Brazing Rod***  
Brazing hot or cold rolled steels, tool steels, stainless and high carbon steels, cast iron, malleable iron, all alloys of bronze, copper and nickel and dissimilar metals. *(Use Auralloy 825 Flux)*



# EZ-WELD ALUMINUM ALLOY KIT

*Now You Can Weld Aluminum "Easily"  
with a Common Propane Torch!*



- **A TOTAL OF 1/2 LB OF AURALLOY 630 (P/N 8734) –**  
Approximately ten (10) 18" sticks of proprietary brazing rod formulated for high strength fabrication and aluminum repair.
- **STAINLESS STEEL WIRE BRUSH (P/N 41340)**  
Constructed of heavy gauge wire embedded in a plastic handle.  
7-7/8" overall length
- **PACKAGED IN A PROTECTIVE PLASTIC TUBE**