

CARVER 9011-C

FEATURES

CARVER 9011-C is Aluminium electrode with good strength. Takes very low current. Easy to handle. A special combination of core wire & coating provides high-speed deposition of dense, porosity free welds. Has good colour match and is corrosion resistance. It produces strong joints, upto 120 N/mm².

APPLICATIONS

Recommended for fabrication and repair of cast and wrought aluminium. It is excellent for foundry defects, machining errors and all types of salvaging work. It is widely used on sheets, tubes and extrusions in thicknesses of 3.15 mm or more. It is non heat treatable and will discolor if anodized.

PROCEDURE

Use DC reverse polarity. Weld areas to be cleaned and heavier sections to be beveled. Electrode to be used in downhand position with shortest possible arc. Heavier sections (over 8 mm thickness) to be preheated upto 200° C to get excellent bonding and porosity free joint.

TECHNICAL DATA

Alloy Type	:	Al, Si alloy
Tensile Strength	:	110-130 N/mm ²
Elongation	:	4-8 %
Hardness	:	Rockwell B 60

RECOMMENDED CURRENT RANGE

SIZE (mm)	3.15	4.00
AMPS	80-100	110-130

ELECTRODE FOR WELDING ALUMINIUM.