

Addifix 420

A SUPERIOR DUCTILE EXTRUDED ALUMINUM ELECTRODE (DC+)

Tensile Strength: 28,000-38,000 PSI
Diameters: 3/32 1/8 5/32
Amperages: 65 100 115

A superior high-strength aluminum electrode featuring an exclusive moisture resistant coating for welding most common aluminum alloys. Rapid deposition, excellent arc stability, dense and porosity-free deposits. Rapid solidification of weld metal, all position. Must be applied with reverse polarity.

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- **Double deoxidized core wire.**
 - **Extruded flux coating.**
 - **Welds most common aluminums, including low magnesium grades.**
 - **Smooth arc operation.**
 - **Welds in all positions.**
 - **Good color match.**
 - **Dense, strong, porosity free deposits.**
 - **Use only DC reverse polarity.**

MADE IN USA

Typical Industrial Applications: Machinery parts, molds, furniture, tanks, motor housings, pump jackets, power tool housings, gear cases, mixer paddles, beater arms, bakery bowls, piping, dock plates, chutes, hand trucks, foundry flasks, doors, door casting, ornamental items, extrusions, tanks, hoppers and vats, transmission housing, crank cases, transmission end plates, aluminum motor blocks, cylinder heads, truck bodies, bus bodies, bell housings, ramps, mounting brackets, trailer parts and truck door hinges.

Operation: Preheating is always helpful to smooth operation, as is smoking with a very rich flame. The carbon deposit helps initiate the arc. For very heavy parts, a 300 to 400°F preheat will provide optimum performance. Hold the electrode in a vertical position, maintain a very short arc and move quickly in the desired direction. Always wash with water to remove residual flux.