



UNITED STATES WELDING CORPORATION

USW ALLOY DESIGNATION AND DESCRIPTION	RR250 GTAW SOLID WELDING WIRE ALUMINUM BASE	ISO 9001 AS 9100	DATA SHEET 1323																														
		Revision A																															
CROSS-REFERENCE CONFORMANCE SPECIFICATIONS	MSRR 9500/34 RR 250 USW 1323 USWC 1323 (C) OMAT 335 A																																
METALLURGICAL BACKGROUND INFORMATION	<p>ALLOY 1323 is a solid welding wire produced conventionally and then surface cleaned to remove standard metal working lubricants.</p> <p>ALLOY 1323 is an Al-Cu-Ni-Mn-Sb-Co heat treatable alloy used for welding similar composition sand casting materials.</p>																																
MATERIALS TO BE WELDED AND APPLICATIONS	RR 250 BS L119 MSRR 8040, 8009, 8010 Casting refurbishment, repair, reclaim. Beware of Antimony fumes when fabricating castings.																																
WIRE CHEMISTRY WT%	<table> <tr> <td>Copper</td> <td>4.5 - 5.5</td> <td>Iron</td> <td>-</td> <td>0.50</td> </tr> <tr> <td>Silicon</td> <td>- 0.30</td> <td>Nickel</td> <td>0.8</td> <td>1.2</td> </tr> <tr> <td>Manganese</td> <td>0.2 0.3</td> <td>Titanium</td> <td>0.15</td> <td>0.25</td> </tr> <tr> <td>Antimony</td> <td>0.1 0.4</td> <td>Aluminum</td> <td></td> <td>Balance</td> </tr> <tr> <td>Cobalt</td> <td>0.1 0.4</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Co + Antimony</td> <td>0.2 0.6</td> <td></td> <td></td> <td></td> </tr> </table>			Copper	4.5 - 5.5	Iron	-	0.50	Silicon	- 0.30	Nickel	0.8	1.2	Manganese	0.2 0.3	Titanium	0.15	0.25	Antimony	0.1 0.4	Aluminum		Balance	Cobalt	0.1 0.4				Co + Antimony	0.2 0.6			
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WELD PROPERTIES	Melting range (approx) 1015° - 1202°F Hardness 85 HV Density 2.84gm/cc																																
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PACKAGING	Sealed, air-evacuated, argon purged Vapor Barrier envelopes with desiccants ensure full protection from atmospheric contamination and prolonged shelf-life.																																
DFARS Compliant		www.usweldingcorp.com																															