

HABCO AX 444

A UNIVERSAL PREMIUM ALUMINUM ELECTRODE WITH SPECIALLY FORMULATED EXTRUDED FLUX COATING

FEATURES

HABCO AX 444 provides industry with an electric arc aluminum alloy of unequaled weldability. A specially formulated **anti-hydroscopic coating**, along with high compression compactness of the coating **assures resistance to moisture pick-up**. **HABCO AX 444** can be used on most all weldable grades of aluminum and offers good weld control and easy re-strike. **HABCO AX 444 can also be used as a flux coated aluminum brazing alloy** for low heat, high strength joining of wrought and cast aluminum alloys.

APPLICATIONS

Repairing of automotive, truck, and bus parts. Also for tanks, pipes, ladders, shelves, refrigeration, foundry patterns and many other aluminum structures. Repair of machining errors and build-up of missing or worn sections of castings, extrusions, plates, etc.

INSTRUCTIONS

Clean weld area. Parts 1/8" or heavier should be beveled 70-90°. No preheat is necessary on thin gauges, but faster, flatter, smoother welds are produced on heavier sections if they are preheated to approx. 400°F (205°C). Hold electrode vertical to work piece, maintain a short arc and fast travel speed. Use either stringer beads or a weave technique. Remove slag between passes. Re-start arc on existing weld deposits. Allow part to cool slowly. Chip off all slag before quenching. For complete slag removal use a stainless steel wire brush with a 10% sulphuric acid and hot water solution. Rinse with clean, hot water.

Tensile Strength: 34,000 Psi (24 kg/mm²)

Current: DC +

Amperage:	50-80	75-130	100-160
Diameters: (in)	3/32	1/8	5/32
(mm)	2.5	3.25	4.0