



SMOOTH 340

DESCRIPTION: Smooth 340 features a precise combination of core wire and coating, providing high speed deposition of dense, machinable welds. It is recommended for fabrication and repair of cast and wrought aluminum. It is excellent for foundry defects, machining errors and all types of salvage work. It is widely used on sheets, tubes and extrusions in thicknesses of 1/8" or more. Smooth 340 is also well-suited to torch application.

Procedure: Use DC-reverse polarity. Weld areas should be clean and heavier sections should be beveled. Best results will be obtained on heavier sections when preheated to approximately 500°F. The electrode should be held in a vertical position. Slag is easily removed and should be brushed or chipped before multiple passes. Clean with hot water; add 10% sulphuric acid to water if additional cleaning is required.

SPECIFICATION: AWS A5.3 E4043

CHEMICAL COMPOSITION

ALUMINUM	BALANCE
MAGNESIUM	.05% MAX.
MANGANESE	.05% MAX
SILICON	1-11%
MAGNESIUM FLUORIDE	1-11%
POTASSIUM CHLORIDE	1-11%
SODIUM CHLORIDE	1-11%
ALUMINUM FLUORIDE	1-11%
COPPER	.40% MAX
LITHIUM FLUORIDE	1-11%
ZINC	.10% MAX
IRON	.80% MAX
POTASSIUM FLUORIDE	2-12%

PHYSICAL PROPERTIES

TENSILE STRENGTH 34,000 PSI

***RECOMMENDED AMPERAGES (DC REVERSE POLARITY)**

3/32" x 14" (2.4 mm x 350mm)	50-85 amps
1/8" x 14" (3.2 mm x 350mm)	80-135 amps
5/32" x 14" (4.0 mm x 350mm)	100-165 amps

***All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.**

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.