



EAGLE 414 Super

Universal Aluminum Arc Electrode

APPLICATIONS

For repair of tanks, engine blocks, truck frames, foundry patterns and fabrication of aluminum.

PROCEDURE

Use DC Reverse [+] Polarity. Clean all weld areas with a stainless steel wire brush and bevel sections thicker than 1/4". Preheat thick sections to 400°F, while maintaining a short arc length, hold electrode vertical to the work piece and travel as fast as possible. Allow weld to cool slowly and remove slag between passes.

GENERAL CHARACTERISTICS

The **EAGLE 414 Super** aluminum electrode produces a low spatter, strong, dense and porosity free weld. The arc is stable and operates at low amperage while having good colour match.

TECHNICAL DATA

Tip Colour: Plain
Tensile Strength: Approx. 34,000 psi
Elongation: Approx. 18%
Hardness: (BH) Approx. 40 - 60

WELDING PARAMETERS

Current:	DC Reverse [+] Polarity			
Sizes:	Inches	3/32	1/8	5/32
	mm	2.50	3.25	4.00
Amperage:	45 - 75	80 - 125	125-160	



≡ HIGH QUALITY WELDING PRODUCTS ≡

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