

## TECHNICAL DATA SHEET

 **Starweld 54**

**DC +**

### ALUMINUM

#### Description :

High-quality electrode for assembly, repair and rebuilding of aluminum and its alloys. Thanks to its high-quality coating, Starweld 54 is easy to strike and re-strike, and can be used in all positions.

#### Characteristics :

- **Very high recovery**
- Porosity-free and smooth deposit
- Excellent cracking resistance
- May be used with torch
- Works only in polarity DC+

#### Applications :

Highly recommended for welding aluminum-magnesium alloys. Commercial aluminum welding. Excellent for welding cast or forged aluminum alloys. Truck frames, molds, pistons, heat exchangers, fabrication, maintenance, plates, tubes, naval industries, armor and reinforcement, tanks, scaffolding, etc.

#### Mechanical properties :

Polarity DC +  
Tensile strength : 35 000 psi (241 MPa)  
Elongation : 23 %

#### Procedure :

Remove the oxide layer prior to welding. Preheating of thick sections is recommended to facilitate welding. Weld while holding the electrode almost vertical while maintaining a short arc so the coating almost touches the base metal. Remove slag between each pass and cool slowly. The deposit may not be anodized.

+ <b>Diameter</b>	2.5 mm	3.2 mm	4.0 mm
+ <b>Amperage</b>	70 A	90 A	120 A

**Also available in TIG Starweld T1054 and in MIG Starweld 2054M.**

**1 800 361 9097**

