



Aluminum Maintenance and
Repair Electrode

EutecTrode® 2101



- Highly active flux coating
- Aluminum-silicon alloy
- Good color match with most casting grades

2101

EutecTrode 2101 is a flux-extruded electrode for heavy aluminum castings, long joints, defect filling and rebuilding missing sections. This universal aluminum-silicon alloy is excellent for 3xxx and 4xxx series aluminum repairs. It can also be used to weld 1xxx series aluminum. Weld deposits are dense and porosity-free. This user-friendly electrode has a smooth and stable arc. Slag is easily removed after the part has cooled down.

TECHNICAL DATA

Typical Values

Hardness as-deposited:	BHN 45
Electrical Conductivity:	IACS%: 39
Tensile Strength:	34,000 psi (235 MPa)
Yield Strength:	28,000 psi (190 MPa)
Color Match Properties:	Good, but will darken after clear anodizing
Current & Polarity:	DCEP (+)

DIAMETER	1/8" (3.2mm)
AMPERAGE	80 - 130

PROCEDURE FOR USE

PREPARATION: Clean weld area to remove contaminants and surface oxides. Parts thicker than 1/8"(3.2mm) should be beveled to have an included angle of 60-75°. Preheat heavy sections or sections thicker than 1/4"(6.4mm) within a 400-500°F(204°-260°C) range.

NOTE: Preheating reduces the need to use high amperage levels.

TECHNIQUE: Start arc either by lightly drawing the electrode across the work piece or use a copper starting block. To help control the arc response, it is important to maintain a very short stand-off distance and to keep the electrode almost perpendicular. Back-whip craters and allow to cool before de-slagging.

POST WELDING: Slag removal is very important. It can become corrosive if not removed. Scrub in hot, soapy water then rinse.

TYPICAL APPLICATIONS

- Engine Blocks
- Cast Differential Housings
- Various Aluminum Pump Casings
- Heavy Gauge Aluminum Truck Bodies
- Foundry Patterns
- Aluminum Rails



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