



Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925

4145 ALUMINUM Welding and Brazing wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

4145 (716) is a silicon copper aluminum filler recommended for welding of 2014, 2036, 7050, 201.0, 224.0, 242, 319, 333.0, 354, 355.0, C355, 380.0, A380, 390 and other base metals of aluminum copper or aluminum copper silicon. This welding wire may be used in place of 2319 where higher strengths are not required but a more cosmetic weld.

TYPICAL GMAW WELDING PROCEDURES; DCEP

Wire Diameter	Amps	Volts	Travel speed (ipm)	Argon (cfh)
0.030	60-175	15-24	25-45	25-30
0.035	70-185	15-27	25-40	30-35
3/64	125-260	20-29	24-35	35-45
1/16	170-300	24-30	28-38	45-55
3/32	275-400	26-31	14-20	60-75

TYPICAL GTAW WELDING PROCEDURES; ACHF with Pure or Ziconiated Hemisphere shape tungsten tip

Filler Wire Size	Tungsten	Amps	Volts	Gas Cup Size	Argon (cfh)	Base thickness
1/16"	1/16"	60-80	15	3/8"	20	1/16"
3/32"	3/32"	125-160	15	3/8"	20	1/8"
1/8"	1/8"	190-220	15	7/16"	20	3/16"
5/32"	5/32"	200-300	15	1/2"	25	1/4"
3/16"	3/16"	330-380	15-20	5/8"	25	3/8"
1/4"	1/4"	400-450	25	5/8"	25	1/2"

Procedures are base on flat position and may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL CHEMISTRY AND PROPERTIES;

Silicon	Iron	Copper	Manganese	Magnesium	Chromium	Zinc	Beryllium
9.3-10.7	0.80	3.3-4.7	0.15	0.15	0.15	0.20	0.0008
Aluminum Remainder and others each 0.50 & total 0.15				All values are maximum percentage unless noted			

Solidus:970°F Liquidus:1085°F Density: 0.099 lbs./cu. In. Anodize color: Gray-black

AVAILABLE SIZES: TA 4145= Spools of .035, 3/64,
TB 4145 = Cut lengths of .035, .045, 1/16, 3/32, 1/8
Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.10 ER/ R 4145
ANSI/AWS A5.8 BAISi-3
ASME SFA5.10 ER/ R 4145
AMS 4184

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