



WA. ALLOY CO.

WASHINGTON ALLOY'S Quality Management System is Certified to **ISO 9001:2008** Cert # 05-R0925

RAINIER 40 Coated Electrode

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



American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

Rainier 40 is a multipurpose flux-coated electrode used to join or repair casting and wrought alloys in the manganese, nickel, aluminum bronze family. Suited for ship propellers, marine components and similar analysis where resistance to corrosion, erosion and cavitation is required. Also found in joining and surfacing dissimilar alloys as well as grey cast iron.

TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps	Diameter	Amps
1/16"	25-50	1/8"	95-150
5/64"	30-60	5/32"	120-200
3/32"	50-115	3/16"	180-260

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. When welding vertical reduce amperage 10-20%

TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Tin ^(O)		Silicon	1.5 max.
Lead	0.02 max.	Iron	2.0-4.0
Aluminum	6.0-8.5	Others	0.50
Zinc ^(O)		Copper ^(Ag)	Balance
Nickel ^(Co)	1.5-3.0	Manganese	11.0-14.0

^(Ag)Includes Silver ^(O)Included in other elements ^(Co)Includes Cobalt

Elongation	15% min.
Yield Strength (psi)	up to 55,000
Tensile Strength (psi)	75,000 min.
Brinell Hardness	160-200
Machinability	Good - Excellent

AVAILABLE SIZES: TU RAINIER 40 1/8", 5/32"

SPECIFICATIONS; ANSI/AWS A5.6 ECuMnNiAl
ASME SFA 5.6 ECuMnNiAl

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WA. ALLOY CO.

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