SuperGlaze®

Aluminum MIG Wire Product Catalog

www.lincolnelectric.com

LINCOLN® ELECTRIC
THE WELDING EXPERTS®

About The Lincoln Electric Company

Lincoln Electric is the world's leading manufacturer of welding equipment and consumables. Our focus is on helping companies make their welding operations more effective, more efficient, more profitable.
We are dedicated to two equally important goals: exceptional quality and exceptional service. Our field support team — with hundreds of field sales engineers and thousands of knowledgeable and responsive Lincoln distributors in countries all over the world — is the largest in the industry.
Innovative thinking.
A quality, service-first attitude.
Fresh approaches to design, manufacturing, and packaging.
Worldwide strength.
Choose Lincoln.

About SuperGlaze® Aluminum MIG Wire

For superior welding performance, turn to SuperGlaze® aluminum MIG wire from Lincoln Electric.

SuperGlaze® prevents the problems usually associated with aluminum wire feeding such as birdnesting, tangling and burnback to provide a stable arc, great feedability and exceptional control — every time you weld! The keys are SuperGlaze®'s smooth surface finish and consistent chemical composition. What this means for you is quality wire that produces a quality weld.

Let Us Put Our Experience to Work for You

As a major supplier of welding wire, Lincoln Electric is the leader in MIG wire manufacturing technology. We carry that same technology and expertise to our aluminum MIG wire manufacturing. Our fully integrated aluminum MIG wire facility uses state-of-the-art equipment to produce a complete range of aluminum alloys including 1100, 4043 4047, 5183, 5356, 5554 and 5556.

SuperGlaze®

What Makes Our SuperGlaze® Stand Out From the Rest?

Three unique features:

1. A proprietary process which gives SuperGlaze® a superior surface finish for optimum surface integrity.
2. A manufacturing process that precisely controls the alloy chemical composition to produce consistent physical characteristics.
3. State-of-the-art testing equipment to evaluate the surface condition and feedability of the wire to ensure problem-free welding.

What all this means to you is outstanding welding characteristics, spool to spool, time after time. Lincoln's aluminum MIG wire coupled with our advanced MIG welding equipment makes aluminum as easy to weld as any other material... and makes Lincoln the one source for all your aluminum welding needs.

Important Information On Our Website

Consumable AWS Certificates:
http://www.lincolnelectric.com/products/certificates/

Material Safety Data Sheets (MSDS):
http://www.lincolnelectric.com/product/msds/

ANSI Z49.1, E205 Safety Booklet, and other Arc Welding Safety Materials:
http://www.lincolnelectric.com/community/safety/

Safe Practices Article:
http://www.lincolnelectric.com/knowledge/articles/content/lenstaybl.asp

Contents

Here's How Our Process Works

Controlling Alloys
The process of making aluminum MIG wires is a complex one, but one in which Lincoln has a clear and distinct advantage. First, we utilize automated titling furnaces to efficiently produce the proper aluminum alloys. With this equipment, we are able to hold tight tolerances in the composition. The alloy is carefully refined prior to casting to minimize hydrogen, alkaline metals, and inclusions.

Continuous Casting
Second, we use a continuous casting process specially configured to high alloy materials. This process keeps the surface free from imperfections and impurities.

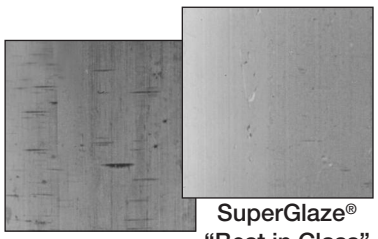
Drawing the Wire
In the last manufacturing step of the process, we use advanced wire drawing technology to preserve both surface integrity and internal soundness.

Testing the Wire
To ensure superior quality of welding wire, continuous finished product inspection is done. Surface quality is evaluated along with feedability and welding performance. This guarantees every spool of wire is problem-free.

Welding Performance
Most aluminum MIG welding problems are caused by poor feeding. Since aluminum is relatively soft, it is important that the wire surface be as smooth as possible for best feedability. SuperGlaze® products provide easier feeding than competitive products because they have fewer surface imperfections as shown at the right. SuperGlaze® wire also feeds with less force than typical competitive products as the feedability test graph shows. What this means is better control of the weld puddle for the operator. It also means longer gun liner and contact tip life as burn-backs do not occur.

The SuperGlaze® Advantage

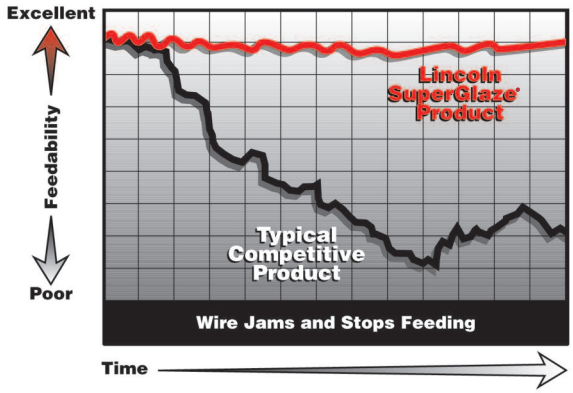
5356 Wire Surfaces
Magnified 60x



Typical Competitive Product

SuperGlaze® "Best in Class"

With our MIG welding process knowledge, we understand that welding performance is one of the most important criteria used when selecting a wire. Aluminum MIG wire tends to produce a welding arc that is less stable than other materials because aluminum conducts electricity better. Small changes in wire diameter, wire feed speed, and current produce dramatic changes in weld bead profile, arc length and can even cause equipment downtime due to wire burnback and fusing to tip. Our continuous evaluation of finished product ensures consistency in manufacturing. You can count on Lincoln aluminum MIG wire for superior arc stability, weld appearance, integrity and productivity.



ALUMINUM MIG WIRE SELECTION GUIDE

Electrode Name	AWS Number	Recommended Polarity	General Description	Page No.
SuperGlaze® 4043	ER4043	DC+	SuperGlaze® 4043 is a great choice for the welding of heat-treatable base alloys and more specifically the 6XXX series alloys. It has a lower melting point and more fluidity than the 5XXX series filler alloys and is preferred by welders because of its favorable operating characteristics. ER4043 type wires are also less sensitive to weld cracking with the 6XXX series base alloys. SuperGlaze® 4043 is suitable for sustained elevated temperature service, i.e. above 150°F (65°C).	6
SuperGlaze® 4047	ER4047	DC+	A lower melting point and higher fluidity are two advantages SuperGlaze® 4047 has over its cousin SuperGlaze® 4043. SuperGlaze® 4047 produces very clean weld deposits and possesses excellent operator appeal. It can be used as a substitute for an ER4043 type wire to increase silicon in the weld metal, minimize hot cracking, and produce higher fillet weld shear strength. SuperGlaze® 4047 is suitable for sustained elevated temperature service, i.e. above 150°F (65°C).	7
SuperGlaze® 5183	ER5183	DC+	SuperGlaze® 5183 is designed to weld high magnesium alloys to meet higher tensile strength requirements. Use on 5083 and 5654 base materials when required tensile strengths are 40,000 psi (276 MPa) or greater. Typical applications are in the marine and cryogenic industries, and high strength structural aluminum fabrication.	8
SuperGlaze® 5356	ER5356	DC+	SuperGlaze® 5356 is our most popular aluminum MIG wire. It is a great general purpose filler alloy designed for the welding of 5XXX series alloys when 40,000 psi (276 MPa) tensile strength is not required.	9
SuperGlaze® 5554	ER5554	DC+	SuperGlaze® 5554 is intended as a matching filler alloy when welding 5454 base alloys. This alloy is a lower magnesium content alloy and is often used for automotive wheels, over-the-road trailers, and rail tank cars where the weld filler metal chemistry must closely match the base material chemistry to maximize corrosion performance.	10
SuperGlaze® 5556	ER5556	DC+	SuperGlaze® 5556 weld deposits will provide matching tensile strengths for the 5XXX alloys, such as 5083 and 5654. Contains increased amounts of magnesium and manganese.	11

SuperGlaze® 4043

Aluminum MIG Wire
(AWS ER4043)

SuperGlaze® 4043 is a great choice for the welding of heat-treatable base alloys and more specifically the 6XXX series alloys. It has a lower melting point and more fluidity than the 5XXX series filler alloys and is preferred by welders because of its favorable operating characteristics. ER4043 type wires are also less sensitive to weld cracking with the 6XXX series base alloys. SuperGlaze® 4043 is suitable for sustained elevated temperature service, i.e. above 150°F (65°C).

Advantage Lincoln

- All-position aluminum MIG wire.
- Superior wire surface finish for the best feedability and arc performance.
- Optimal manufacturing process to precisely control chemical composition.
- State-of-the-art testing equipment to ensure trouble-free performance of the weld wire.
- Manufactured under a quality system certified to ISO 9001 requirements.

Typical Applications

- For welding 6XXX alloys, and most casting alloys.
- Good all purpose filler alloy.
- Automotive components such as frame and drive shafts.
- Bicycle frames.

Welding Positions

All Position

Shielding Gas

100% Argon
Argon / Helium Mixtures
Flow Rate: 30 - 50 CFH

Conformance

AWS A5.10: ER4043
CWB

DIAMETERS/PACKAGING

Diameter in. (mm)	1 lb (0.4 kg) Spool 20 lb (9.1 kg) Carton	16 lb (7.3 kg) Spool	20 lb (9.1 kg) Fiber Spool	275 lb (125 kg) Accu-Pak® Box
0.030 (0.8)	ED030307			
0.035 (0.9)	ED030308	ED028395		
3/64 (1.2)	ED030310	ED028397	ED029234	ED030982[1]
1/16 (1.6)			ED030281	ED030983[2]

WIRE COMPOSITION

	%Al	%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Zn	%Ti	%Be
Requirements AWS ER4043	Remainder	4.50 - 6.00	0.80 max.	0.30 max.	0.05 max.	0.05 max.	—	0.10 max.	0.20 max.	0.0008 max.
Test Results[2]	Remainder	5.26	0.15	0.006	0.01	0.03	—	0.001	0.009	<0.0002

[1] Wire payoff kit K2858-1 sold separately. [2] Wire payoff kit K2859-1 sold separately. **NOTE:** Typical Operating Procedures found on pages 12-13.

SuperGlaze® 4047

Aluminum MIG Wire
(AWS ER4047)

A lower melting point and higher fluidity are two advantages SuperGlaze® 4047 has over its cousin SuperGlaze® 4043. SuperGlaze® 4047 produces very clean weld deposits and possesses excellent operator appeal. It can be used as a substitute for an ER4043 type wire to increase silicon in the weld metal, minimize hot cracking, and produce higher fillet weld shear strength. SuperGlaze® 4047 is suitable for sustained elevated temperature service, i.e. above 150°F (65°C).

Advantage Lincoln

- All-position aluminum MIG wire.
- Similar to SuperGlaze® 4043, with even higher crack resistance.
- Superior wire surface finish for the best feedability and arc performance.
- Optimal manufacturing process to precisely control chemical composition.
- State-of-the-art testing equipment to ensure trouble-free performance of the weld wire.
- Manufactured under a quality system certified to ISO 9001 requirements.

Typical Applications

- Automotive components, heat exchangers.
- Body panels.

Welding Positions

All Position

Shielding Gas

100% Argon
Argon / Helium Mixtures
Flow Rate: 30 - 50 CFH

Conformance

AWS A5.10: ER4047

DIAMETERS/PACKAGING

Diameter in. (mm)	16 lb (7.3 kg) Spool
3/64 (1.2) 1/16 (1.6)	EDS28417 EDS28418

WIRE COMPOSITION

	%Al	%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Zn	%Ti	%Be
Requirements AWS ER4047	Remainder	11.00 - 13.00	0.80 max.	0.30 max.	0.15 max.	0.10 max.	—	0.20 max.	—	0.0008 max.
Test Results[2]	As Reported per AWS Requirements									

NOTE: Typical Operating Procedures can be found on pages 12-13.

SuperGlaze® 5183

Aluminum MIG Wire
(AWS ER5183)

SuperGlaze® 5183 is designed to weld high magnesium alloys to meet higher tensile strength requirements. Use on 5083 and 5654 base materials when required tensile strengths are 40,000 psi (276 MPa) or greater. Typical applications are in the marine and cryogenic industries, and high strength structural aluminum fabrication.

Advantage Lincoln

- All-position aluminum MIG wire.
- Superior wire surface finish for the best feedability and arc performance.
- Optimal manufacturing process to precisely control chemical composition.
- State-of-the-art testing equipment to ensure trouble-free performance of the weld wire.
- Manufactured under a quality system certified to ISO 9001 requirements.

Typical Applications

- For welding high magnesium 5XXX alloys.
- Marine fabrication and repair.
- Cryogenic tanks.
- Shipbuilding and other high strength structural aluminum applications.
- Bicycle frames.

Welding Positions

All Position

Shielding Gas

100% Argon
Argon / Helium Mixtures
Flow Rate: 30 - 50 CFH

Conformance

AWS A5.10:	ER5183
ABS:	IACS Grade WC
Lloyd's Register:	WC
DNV:	5183
G.L.:	S-AlMg 4.5Mn
Bureau Veritas:	WC
TUV	

DIAMETERS/PACKAGING

Diameter in. (mm)	16 lb (7.3 kg) Spool	300 lb (136.1 kg) Accu-Pak® Box
3/64 (1.2) 1/16 (1.6)	EDS28437 EDS28438	ED031825

WIRE COMPOSITION

	%Al	%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Zn	%Ti	%Be
Requirements AWS ER5183	Remainder	0.40 max.	0.40 max.	0.10 max.	0.50 - 1.00	4.30 - 5.20	0.05 - 0.25	0.25 max.	0.15 max.	0.0008 max.
Test Results[2]	Remainder	0.03	0.13	0.001	0.65	4.99	0.10	0.02	0.07	0.0006

NOTE: Typical Operating Procedures can be found on pages 12-13.

SuperGlaze® 5356

Aluminum MIG Wire
(AWS ER5356)

SuperGlaze® 5356 is our most popular aluminum MIG wire. It is a great general purpose filler alloy designed for the welding of 5XXX series alloys when 276 MPa (40,000 ksi) tensile strength is not required.

Advantage Lincoln

- All-position aluminum MIG wire.
- Superior wire surface finish for the best feedability and arc performance.
- Optimal manufacturing process to precisely control chemical composition.
- State-of-the-art testing equipment to ensure trouble-free performance of the weld wire.
- Manufactured under a quality system certified to ISO 9001 requirements.

Typical Applications

- For welding most 5XXX alloys when 276 MPa (40,000 ksi) tensile strength is not required.
- Automotive bumpers and supports.
- Structural frames in the shipbuilding industry.
- Bicycle frames.
- Formed truck panels.

Welding Positions

All Position

Shielding Gas

100% Argon
Argon / Helium Mixtures
Flow Rate: 30 - 50 CFH

Conformance

AWS A5.10:	ER5356
ABS:	IACS WB
Lloyd's Register:	WB
DNV:	5356
G.L.:	S-AlMg 5
Bureau Veritas:	WB
CWB	
TUV	

DIAMETERS/PACKAGING

Diameter in. (mm)	1 lb (0.4 kg) Spool 20 lb (9.1 kg) Carton	16 lb (7.3 kg) Spool	20 lb (9.1 kg) Fiber Spool	300 lb (136.1 kg) Accu-Pak® Box
0.035 (0.9)	ED030312	ED028385		
3/64 (1.2)	ED030314	ED028387	ED030282	ED031826[1]
1/16 (1.6)			ED030283	ED030985[1]

WIRE COMPOSITION

	%Al	%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Zn	%Ti	%Be
Requirements AWS ER5356	Remainder	0.25 max.	0.40 max.	0.10 max.	0.05 - 0.20	4.50 - 5.50	0.05 - 0.20	0.10 max.	0.06 - 0.20	0.0008 max.
Test Results[2]	Remainder	0.05	0.09	0.03	0.12	4.56	0.08	0.003	0.15	0.0007

[1] Wire payoff kit K2860-1 sold separately. **NOTE:** Typical Operating Procedures can be found on pages 12-13.

SuperGlaze® 5554

Aluminum MIG Wire
(AWS ER5554)

SuperGlaze® 5554 is intended as a matching filler alloy when welding 5454 base alloys. This alloy is a lower magnesium content alloy and is often used for automotive wheels, over-the-road trailers, and rail tank cars where the weld filler metal chemistry must closely match the base material chemistry to maximize corrosion performance.

Advantage Lincoln

- All-position aluminum MIG wire.
- Superior wire surface finish for the best feedability and arc performance.
- Optimal manufacturing process to precisely control chemical composition.
- State-of-the-art testing equipment to ensure trouble-free performance of the weld wire.
- Manufactured under a quality system certified to ISO 9001 requirements.

Typical Applications

- Matching filler alloy for 5454 base alloys.
- Automotive wheels.
- Transportation industry applications such over-the-road trailers and rail tank cars.
- Chemical storage tanks.

Welding Positions

All Position

Shielding Gas

100% Argon
Argon / Helium Mixtures
Flow Rate: 30 - 50 CFH

Conformance

AWS A5.10: ER5554
CWB

DIAMETERS/PACKAGING

Diameter in. (mm)	16 lb (7.3 kg) Spool
3/64 (1.2) 1/16 (1.6)	ED029573 ED029574

WIRE COMPOSITION

	%Al	%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Zn	%Ti	%Be
Requirements AWS ER5554	Remainder	0.25 max.	0.40 max.	0.10 max.	0.50 - 1.00	2.40 - 3.00	0.05 - 0.20	0.25 max.	0.06 - 0.20	0.008 max.
Test Results[2]	Remainder	0.06	0.13	0.03	0.51	2.41	0.06	0.005	0.09	0.0006

NOTE: Typical Operating Procedures can be found on pages 12-13.

SuperGlaze® 5556

Aluminum MIG Wire
(AWS ER5556)

SuperGlaze® 5556 weld deposits will provide matching tensile strengths for the 5XXX alloys, such as 5083 and 5654. Contains increased amounts of magnesium and manganese.

Advantage Lincoln

- All-position aluminum MIG wire.
- Superior wire surface finish for the best feedability and arc performance.
- Optimal manufacturing process to precisely control chemical composition.
- State-of-the-art testing equipment to ensure trouble-free performance of the weld wire.
- Manufactured under a quality system certified to ISO 9001 requirements.

Typical Applications

- For welding the higher strength 5XXX alloys, such as 5083 and 5654.
- Pressure vessels.
- Storage tanks.

Welding Positions

All Position

Shielding Gas

100% Argon
Argon / Helium Mixtures
Flow Rate: 30 - 50 CFH

Conformance

AWS A5.10: ER5556

DIAMETERS/PACKAGING

Diameter in. (mm)	16 lb (7.3 kg) Spool
3/64 (1.2)	EDS29581
1/16 (1.6)	EDS29582

WIRE COMPOSITION

	%Al	%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Zn	%Ti	%Be
Requirements AWS ER5556	Remainder	0.25 max.	0.40 max.	0.10 max.	0.50 - 1.00	4.70 - 5.50	0.05 - 0.20	0.25 max.	0.05 - 0.20	0.0008 max.
Test Results[2]	Remainder	0.03	0.13	0.001	0.65	5.00	0.10	0.02	0.07	0.0006

NOTE: Typical Operating Procedures can be found on pages 12-13.

TYPICAL OPERATING PROCEDURES FOR GROOVE WELDING

Metal Thickness (in.)	Weld Position[1]	Edge Preparation[2]	Joint Spacing (in.)	Weld Passes	Electrode Diameter (in.)	DC+ Current[3] (Amps)	Arc Votlage[3] (Volts)	Argon Gas Flow (cfh)	Arc Travel Speed (ipm/pass)	Approx. Electrode Consump. (lb/100 ft.)
1/16	F	A	None	1	0.030	70 - 110	15 - 20	25	25 - 45	1.5
	F	G	3/32	1	0.030	70 - 110	15 - 20	25	25 - 45	2
1/8	F, V, H	A	0 - 3/32	1	0.030 - 3/64	120 - 150	20 - 24	30	24 - 30	2
	F, V, H, O	G	3/16	1	0.030 - 3/64	110 - 135	19 - 23	30	18 - 28	3
3/16	F, V, H	B	0 - 1/16	1F, 1R	0.030 - 3/64	130 - 175	22 - 26	35	24 - 30	4
	F, V, H	F	0 - 1/16	1	3/64	140 - 180	23- 2 7	35	24 - 30	5
	O	F	0 - 1/16	2F	3/64	140 - 175	23 - 27	60	24 - 30	5
	F, V	H	3/32 - 3/16	2	3/64 - 1/16	140 - 185	23 - 27	35	24 - 30	8
	H, O	H	3/16	3	3/64	130 - 175	23 - 27	60	25 - 35	10
1/4	F	C-90°	0 - 3/32	1F, 1R	3/64 - 1/16	175 - 200	24 - 28	40	24 - 30	6
	F	F	0 - 3/32	2	3/64 - 1/16	185 - 225	24 - 29	40	24 - 30	8
	V, H	F	0 - 3/32	3F, 1R	3/64	165 - 190	25 - 29	45	25 - 35	10
	O	F	0 - 3/32	3F, 1R	3/64 - 1/16	180 - 200	25 - 29	60	25 - 35	10
	F, V	H	1/8 - 1/4	2 - 3	3/64 - 1/16	175 - 225	25 - 29	40	24 - 30	12
	O, H	H	1/4	4 - 6	3/64 - 1/16	170 - 200	25 - 29	60	25 - 40	12
3/8	F	C-90°	0 - 3/32	1F, 1R	1/16	225 - 290	26 - 29	50	20 - 30	16
	F	F	0 - 3/32	2F, 1R	1/16	210 - 275	26 - 29	50	24 - 35	18
	V, H	F	0 - 3/32	3F, 1R	1/16	190 - 220	26 - 29	55	24 - 30	20
	O	F	0 - 3/32	5F, 1R	1/16	200 - 250	26 - 29	80	25 - 40	20
	F, V	H	1/4 - 3/8	4	1/16	210 - 290	26 - 29	50	24 - 30	35
	O, H	H	3/8	8 - 10	1/16	190 - 260	26 - 29	80	25 - 40	50
3/4	F	C-60°	0 - 3/32	3F, 1R	3/32	340 - 400	26 - 31	60	14 - 20	50
	F	F	0 - 1/8	4F, 1R	3/32	325 - 375	26 - 31	60	16 - 20	70
	V, H, O	F	0 - 1/16	8F, 1R	1/16	240 - 300	26 - 30	80	24 - 30	75
	F	E	0 - 1/16	3F, 3R	1/16	270 - 330	26 - 30	60	16 - 24	70
	V, H, O	E	0 - 1/16	6F, 6R	1/16	230 - 280	26 - 30	80	16 - 24	75

TYPICAL OPERATING PROCEDURES FOR GROOVE WELDING

Metal Thickness[4] (in.)	Weld Position[1]	Weld Passes[5]	Electrode Diameter (in.)	DC+ Current[3] (Amps)	Arc Votlage[3] (Volts)	Argon Gas Flow (cfh)	Arc Travel Speed (ipm/pass)	Approx. Electrode Consump.[5] (lb/100 ft.)
1/8	F	1	0.030 - 3/64	125 - 150	20 - 24	30	24 - 30	2
	V, H	1	0.030	110 - 130	19 - 23	30	24 - 30	2
	O	1	0.030 - 3/64	115 - 140	20 - 24	40	24 - 30	2
3/16	F	1	3/64	180 - 210	22 - 26	30	24 - 30	4.5
	V, H	1	0.030 - 3/64	130 - 175	21 - 25	35	24 - 30	4.5
	O	1	0.030 - 3/64	130 - 190	22 - 26	45	24 - 30	4.5
1/4	F	1	3/64 - 1/16	170 - 240	24 - 28	40	24 - 30	7
	V, H	1	3/64	170 - 210	23 - 27	45	24 - 30	7
	O	1	3/64 - 1/16	190 - 220	24 - 28	60	24 - 30	7
3/8	F	1	1/16	240 - 300	26 - 29	50	18 - 25	17
	V, H	3	1/16	190 - 240	24 - 27	60	24 - 30	17
	O	3	1/16	200 - 240	25 - 28	85	24 - 30	17
3/4	F	4	3/32	360 - 380	26 - 30	60	18 - 25	66
	V, H	4 - 6	1/16	260 - 310	25 - 20	70	24 - 30	66
	O	10	1/16	275 - 310	25 - 29	85	24 - 30	66

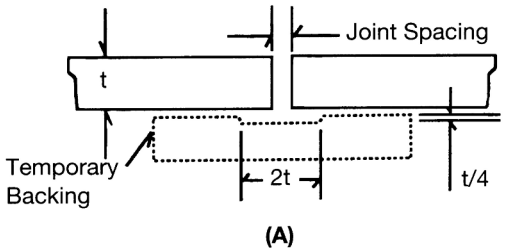
[1] F - Flat, V = Vertical, H = Horizontal, O = Overhead.

[2] See joint designs on page 13.

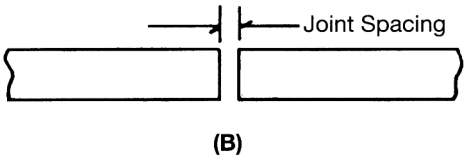
[3] For 5XXX series wires, use a welding current on the high side of the range and an arc voltage in the lower portion of the range. For 1XXX, and 4XXX series wires, use the lower currents and higher arc voltages.

[4] Metal thickness of 3/4" or greater for fillet welds sometimes employs a double vee bevel of 50° or greater included vee with 3/32" to 1/8" land thickness on the abutting member.

[5] Number of weld passes and electrode consumption given for weld on one side only.



(A)



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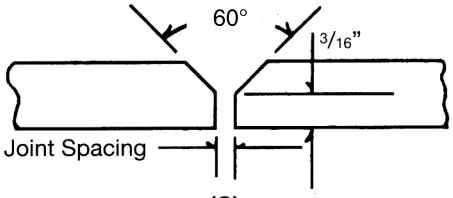

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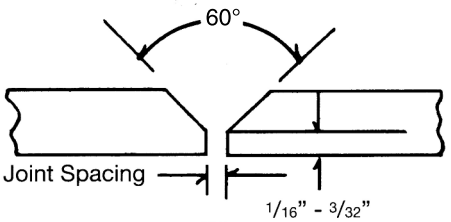

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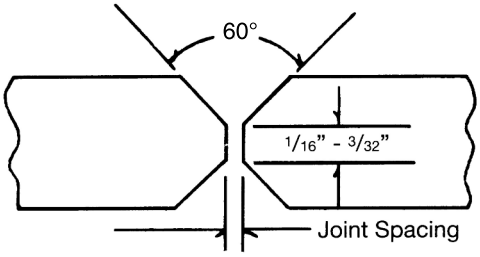
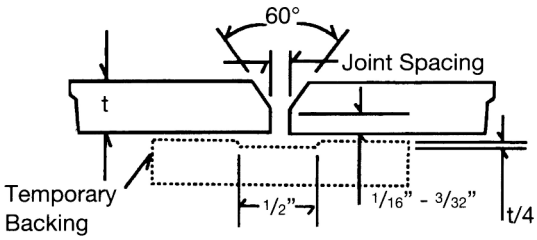


(E)



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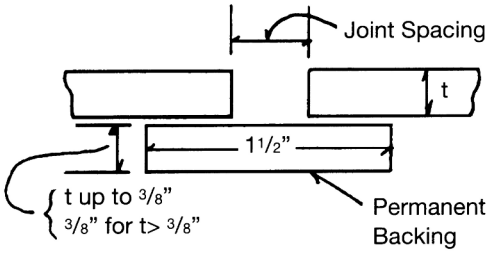

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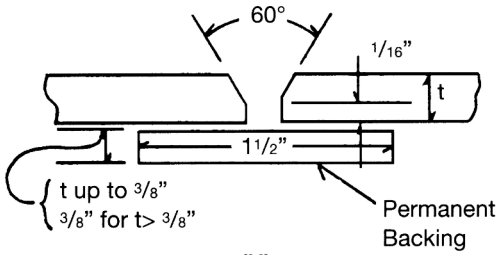

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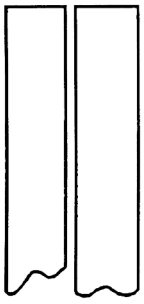

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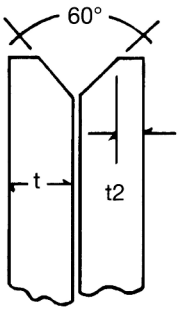
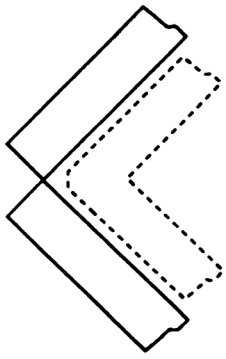


(J)



(K)

Packaging

No matter what your need, Lincoln Electric has a packaging option that offers a great fit. Small packaging includes spools, in quantities of 1 lb, 16 lb or 20 lb (0.4 kg, 7.3 kg or 9.1 kg).

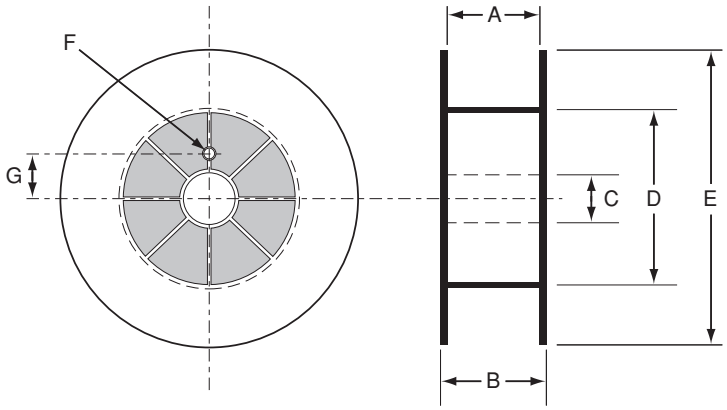
Accu-Pak® Box with Payoff Hood

PACKAGING PALLET WEIGHTS

Packaging Type	Package / Carton Weight lb (kg)	Pallet Weight lb (kg)
1 lb Spool	20 (9.1)	2000 (907)
16 lb Spool	16 (7.3)	1296 (588)
20 lb Spool	20 (9.1)	1620 (735)
275 - 300 AP	275 (125)	1100 (500)
	300 (135)	1200 (545)

SPOOL / REEL SPECIFICATIONS

Packaging Type		1 lb Spool in. (mm)	16 lb Spool in. (mm)	20 lb Spool in. (mm)
A	Inside Width	1 - 1/2 (38)	3 - 5/8 (92)	3 - 5/8 (92)
B	Outside Width	1 - 3/4 (44)	4 (102)	4 (102)
C	I.D. Arbor Hole	5/18 (7)	2 (51)	2 (51)
D	O.D. Core	1 - 1/2 (38)	6 - 3/4 (171)	5 - 29/32 (150)
E	O.D. Flange	4 (102)	11 - 7/8 (302)	11 - 7/8 (302)
F	I.D. Drive Hole	3/16 (5)	15/32 (12)	15/32 (12)
G	Drive Hole Offset	1 (25)	1 - 3/4 (44)	1 - 3/4 (44)



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