

ELBOWS

WELDING OF ALUMINIZED MATERIAL

Gas Welding

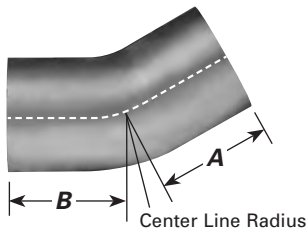
1. Adjust gases until there is a small soft blue flame extending beyond the inner cone $\frac{1}{8}$ " to $\frac{1}{4}$ ".
2. Use an AWS (American Welding Society) Number ER 70S-2 welding rod or the equivalent. This rod has extra elements added to cause the aluminized coating to float on top of the molten puddle away from the inner weld structure.

Tig Welding

Use the same type welding rod as gas welding with argon purge gas.

Mig Welding

For typical exhaust components, use a copper clad, .035 inch to .045 inch diameter wire. Specifically use a low carbon steel wire, AWS Number 70S-3 or the equivalent.



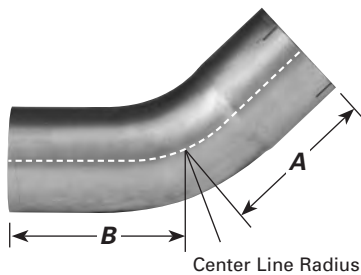
ALUMINIZED 15° ELBOWS

Both ends are O.D.

P/N	DIAMETER	LENGTH A-B	CENTERLINE RADIUS
10684	4"	2"-2"	4 ½"
10685	5"	4"-4"	8"

ALUMINIZED 30° ELBOWS

One end is I.D., the other end is O.D.



P/N	DIAMETER	STYLE	LENGTH A-B	CENTERLINE RADIUS
10631	3 ½"	ID-OD	4"-4"	5"
10632	4"	ID-OD	4"-4"	5"
10633	5"	ID-OD	4"-4"	6"

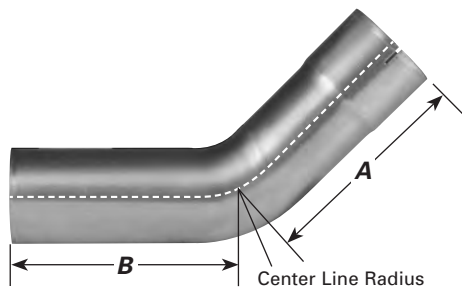
Both ends are O.D.

P/N	DIAMETER	STYLE	LENGTH A-B	CENTERLINE RADIUS
10636	4"	OD-OD	4"-4"	5"
10637	5"	OD-OD	4"-4"	6"

ELBOWS

ALUMINIZED & CHROME 45° ELBOWS

One end is I.D., the other end is O.D.



P/N ALUMINIZED	P/N CHROME	DIAMETER	STYLE	LENGTH A-B	CENTERLINE RADIUS
10311	—	2"	ID-OD	6"-6"	5"
10320	—	2 ¼"	ID-OD	6"-6"	4 ½"
10312	—	2 ½"	ID-OD	6"-6"	4"
10725	—	2 ½"	ID-OD	6"-6"	5"
10318	—	2 ¾"	ID-OD	6"-6"	5"
10313	—	3"	ID-OD	7"-7"	6"
10314	—	3 ½"	ID-OD	8"-8"	7"
10736	—	4"	ID-OD	5"-5"	4"
10726	—	4"	ID-OD	6"-6"	6"
10315	—	4"	ID-OD	9 ¼"-9 ¼"	8"
10727	—	4"	ID-OD	12"-12"	6"
10729	—	5"	ID-OD	7"-7"	8"
10730	809738	5"	ID-OD	8"-8"	10"
10317	809417	5"	ID-OD	12"-12"	8"
10731	—	5"	ID-OD	12"-12"	10"
10732	—	5"	ID-OD	15"-15"	8"

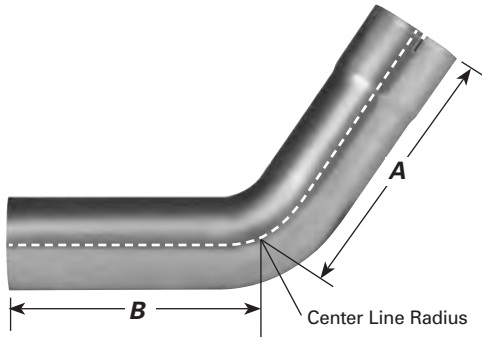
Both ends are O.D.

P/N ALUMINIZED	P/N CHROME	DIAMETER	STYLE	LENGTH A-B	CENTERLINE RADIUS
10562	—	2 ½"	OD-OD	6"-6"	5"
10742	—	3"	OD-OD	4"-4"	3"
10564	—	3"	OD-OD	7"-7"	6"
10565	—	3 ½"	OD-OD	8"-8"	7"
10743	—	4"	OD-OD	6"-6"	6"
10566	—	4"	OD-OD	8"-8"	4 ½"
10745	—	4"	OD-OD	12"-12"	6"
10567	—	5"	OD-OD	8"-8"	5 ½"
10746	809752	5"	OD-OD	8"-8"	8"
10747	809753	5"	OD-OD	15"-15"	8"
10748	—	6"	OD-OD	7"-7"	10"

ELBOWS

ALUMINIZED 60° ELBOWS

One end is I.D., the other end is O.D.



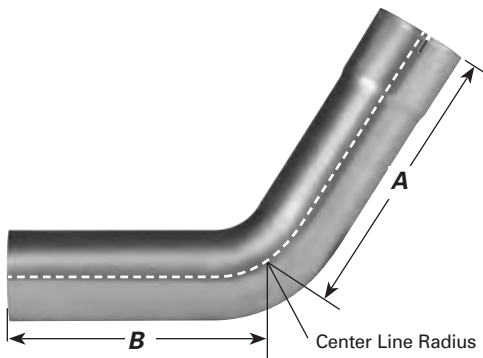
P/N	DIAMETER	STYLE	LENGTH A-B	CENTERLINE RADIUS
10639	3½"	ID-OD	8"-8"	5"
10640	4"	ID-OD	8"-8"	5"
10641	5"	ID-OD	8"-8"	6"

Both ends are O.D.

P/N	DIAMETER	STYLE	LENGTH A-B	CENTERLINE RADIUS
10644	4"	OD-OD	8"-8"	5"
10645	5"	OD-OD	8"-8"	6"

ALUMINIZED & CHROME 67° ELBOWS

Both ends are O.D.

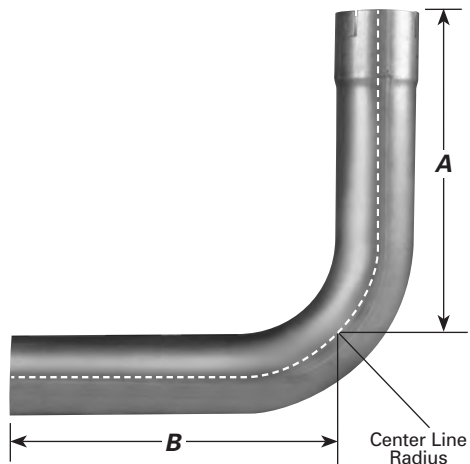


P/N ALUMINIZED	P/N CHROME	DIAMETER	STYLE	LENGTH A-B	CENTERLINE RADIUS
10560	809530	5"	OD-OD	7½"-11"	8"

ELBOWS

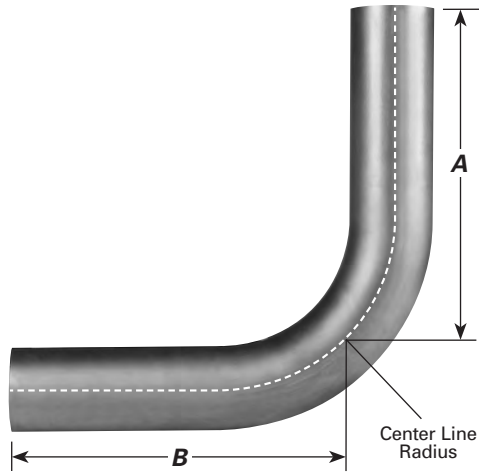
ALUMINIZED & CHROME 90° ELBOWS

One end is I.D., the other end is O.D.



P/N ALUMINIZED	P/N CHROME	DIAMETER	LENGTH A-B	CENTERLINE RADIUS
10922	—	1½"	6½"-6½"	4"
10670	—	1¾"	6¼"-6¼"	4"
10301	—	2"	11"-11"	5"
10671	—	2"	6⅜"-6⅜"	4"
10673	—	2¼"	6⅜"-6⅜"	4½"
10302	—	2¼"	10⅞"-10⅞"	5"
10672	—	2½"	6⅜"-6⅜"	4½"
10303	—	2½"	12"-12"	5"
10674	—	2¾"	6⅜"-6⅜"	5"
10675	—	3"	8"-8¼"	6"
10756	—	3"	8½"-8½"	5"
10757	—	3"	10"-12"	5"
10758	—	3"	12"-12"	5"
10304	—	3"	14"-14"	6"
10795	—	3½"	6¼"-6¼"	3½"
10759	—	3½"	9½"-9¾"	5"
10676	—	3½"	9"-9"	4½"
10305	—	3½"	16"-16"	7"
10681	—	4"	8"-8"	4½"
—	809621	4"	10"-10"	5"
10678	—	4"	10"-10"	4½"
10761	809770	4"	12"-12"	6"
10762	—	4"	16"-16"	8"
10306	809406	4"	18"-18"	8"
10764	—	5"	8½"-8½"	6"
10557	809771	5"	11"-11"	6"
10680	809547	5"	11"-11"	7½"
10765	—	5"	15"-15"	8"
10554	809546	5"	15"-15"	10"
10766	—	5"	16½"-16½"	10"
10308	809408	5"	18"-18"	10"
10556	—	6"	15"-15"	10"

ELBOWS



ALUMINIZED & CHROME 90° ELBOWS

Both ends are O.D.

P/N ALUMINIZED	P/N CHROME	DIAMETER	LENGTH A-B	CENTERLINE RADIUS
10773	—	2"	9"-9"	5"
10774	—	2½"	12"-12"	5"
10337	—	3"	3"-3"	3½"
10776	—	3"	6"-6"	3"
10777	—	3"	7"-7"	3"
10534	—	3"	10"-10"	6"
10778	—	3"	14"-14"	8"
10794	—	3½"	6"-6"	3½"
10338	—	3½"	4"-4"	4"
10329	—	3½"	8"-8"	4"
10535	—	3½"	12"-12"	7"
10536	—	3½"	16"-16"	7"
10339	—	4"	4½"-4½"	4½"
10780	—	4"	7"-7"	5"
10781	—	4"	8"-8"	4"
10538	—	4"	9"-15"	4½"
10783	—	4"	10"-10"	6"
10539	—	4"	12"-12"	5½"
10797	—	4"	16"-16"	8"
10537	—	4"	18"-18"	8"
10340	—	5"	5½"-5½"	5½"
10784	—	5"	7½"-7½"	6"
10785	809795	5"	8½"-8½"	6"
10786	—	5"	9"-11½"	5½"
10787	—	5"	8½"-12½"	6"
10788	—	5"	8¾"-14¼"	5½"
10789	—	5"	9½"-9½"	6"
10541	—	5"	11"-16"	5½"
10791	—	5"	12"-12"	6"
—	809796	5"	12"-12"	8"
10796	—	5"	15"-15"	5½"
10540	—	5"	15"-15"	8"
10309	—	5"	20"-20"	8"