

**Welding of aluminum profiles and plates****GENERAL DESCRIPTION**

Welding of aluminium and aluminium alloys.  
 No discoloration of the weld after anodizing.  
 Good bond on the base metal and very good releasing of the slag.  
 Low spatter and pore-free.  
 We recommend using Lastek 62 for welding aluminium-silicon castings.

**APPLICATIONS**

Can be used for welding of pure aluminium, AlMgSi, AlMn, AlMg1 and AlMg3.  
 Chemical and food industry, fish processing industry, transportation (trucks, construction of containers, etc ...)

**CHEMICAL COMPOSITION (%) (Typical values, all weld metal)**

Si : 0.40	Fe : 0.30	Mn : 1.30	Al : Balance	
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**MECHANICAL PROPERTIES (Typical values, all weld metal)**

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 150 MPa	≥ 250 MPa	≥ 10 %	

**GENERAL INFORMATION**

<b>Welding positions</b>	PA, PB, PC		
<b>Shielding gas</b>	NA		
<b>Packing</b>	2.5 Kg in a plastic box		
<b>Polarity</b>	DC, reverse polarity (electrode positive)		
<b>Diameter (mm)</b>	2.5	3.2	4.0
<b>Length (mm)</b>	350	350	350

**Tips & Tricks**

- Hold the electrode perpendicular to the workpiece, use a short arc and a high travel speed.
- Preheat thick pieces to 150 - 200 ° C.
- Always use dry electrodes.
- Remove the slag thoroughly to avoid corrosion.

*The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.*