

Welding Aluminum with 3% Mg**GENERAL DESCRIPTION**

Welding rod for AlMg3 work pieces.
 Repair of AlMgSi0.5, AlMgSi1 and AlMgMn (AA6060 - AA6082).
 Seawater resistant.
 Can be used for TIG and oxy acetylene welding.

APPLICATIONS

Containers, architectural applications, chemical industry, food industry, repair of plates and profiles on trucks.
 Work pieces that must be anodised (no discoloration on Si free base metals).

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

Cr : 0.15	Mn : 0.25	Si : 0.25	Fe : 0.40	Ti : 0.175
Cu : 0.05	Al : Balance			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)

GENERAL INFORMATION

Welding positions	NA	
Shielding gas	Argon	
Packing	5 Kg in a cardboard box	
Polarity	AC	
Diameter (mm)	2.0	3.2
Length (mm)	1000	1000

Tips & Tricks

For oxyacetylene welding use a slightly carburizing flame + flux Modi Lastek 74A.
 Flux residues must be removed with hot water + brushing.
 For welding thick pieces: preheat to 150 °C (300 °F).