

Lastofil 77

Welding of AlMg 5

CLASSIFICATION

EN ISO 18273 : S Al 5356 (AlMg5)

AWS A5.10 : ER 5356

GENERAL DESCRIPTION

Aluminium-Magnesium welding wire for MIG welding AlMg5, AlMgSi1 and hardenable alloys such as AlZnMg.

Excellent resistance against corrosion by seawater.

Usable in a temperature range from -196°C (-320°F) to +100°C (210°F).

Suitable for anodizing. (No darkening when the basemetal doesn't contain Si).

APPLICATIONS

Welding AlMg5, AlMg2Mn0.8, AlMg2.7Mn, AlMg3, AlMg4.5Mn, AlMgSi1, AlMgSi0.5, AlZnMg1.

Containers, yacht building, truck bodies, etc..

Hardness: 70 HB.

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

Si : < 0.25	Fe : < 0.40	Cu : < 0.05	Mn : 0.10 - 0.20	Mg : 4.50 - 5.50
Cr : 0.05 - 0.20	Ti : 0.06 - 0.15			

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)
≥ 125 MPa	≥ 275 MPa	≥ 17%	≥ 16 J (R.T.)

GENERAL INFORMATION

Welding positions All

Shielding gas Argon (or Helium or Argon/Helium mixed gas)

Packing 7 kg spool (in a cardboard box)

Polarity DC+

Diameter (mm) 0.8 1.0 1.2 1.6

Tips & tricks

Clean the workpieces very carefully.

Workpieces thicker than 15mm can be preheated up to 150°C (300°F).

Use appropriate driving wheels for Al wire in the wire feeder.

For smaller wire diameters it's preferable to use a push-pull torch.

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.