PRODUCT SPECIFICATION

Lastifil 780

Solid welding wire for hardenable aluminium plates and profiles

CLASSIFICATION

EN 18273 : S-Al 4043
AWS A5.10 : ER 4043

GENERAL DESCRIPTION

Welding wire for MIG welding of aluminium alloys.
Very appropriate for welding of heat treated aluminium (AA 6000-range).
The deposit is hardly susceptible to cracking when joining hardenable aluminium alloys.
For welding AlMg-alloys with a high Mg-content, using Lastifil 77 is recommended because of hardness and strength reasons.
The weld beads become darker when anodized.

APPLICATIONS

Welding of AA6060; AA6082; AlMgSi0.5; AlMgSi0.7; AlMgSi1; AlMg1SiCu; G-AlSi7Mg; G-AlSi5Mg; G-AlSi6Cu4 and dissimilar aluminium alloys.

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

Mn : < 0.10	**Si :** 4.50 - 5.50	**Fe :** < 0.40	**Cu :** < 0.10	**Mg :** < 0.10
Al : Balance				

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 120 MPa	≥ 8%	

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

Tips & tricks	Use Teflon wire conductors and appropriate driving wheels on the wire feeder. Preferably use a push-pull torch.