

Lastifil 780

Solid welding wire for hardenable aluminium plates and profiles

CLASSIFICATION

EN 18273 : S-AI 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/mm ²	Tensile Strength N/mm ²	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.

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.