## PRODUCT SPECIFICATION

# Lastek 77



# Welding AIMg5 - highest strength

#### **CLASSIFICATION**

EN ISO 18273 : AI 5356 - AIMg5

AWS A5.10: ER 5356

#### **GENERAL DESCRIPTION**

TIG welding rod for welding AlMg-alloys with up to 5% Mg, AlMgMn and AlZnMg alloys.

High tensile strength and excellent corrosion resistance.

Applicable for temperatures from -196°C (-320°F) up to +150°C (300°F).

Can be anodized without risk of discoloration (on base metals without Si).

#### **APPLICATIONS**

Maintenance and repair welding of truck bodies, window frames, metallic furniture, advertising signs and boards etc...

All kinds of highly-stressed Al constructions e.g. container-repair.

Applications in marine environment.

Surfacing of Al-dies and moulds (plastic bottle dies).

Also in the chemical- and food industry.

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

<b>Mn:</b> 0.05 - 0.20	<b>Si</b> : < 0.25	<b>Fe:</b> < 0.40	<b>Ti</b> : 0.06 - 0.20	<b>Cu:</b> < 0.10
<b>Mg:</b> 4.50 - 5.50	<b>Cr</b> : 0.05 - 0.20	<b>Zn</b> : < 0.10	AI: Balance	

### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength	Tensile Strength	Elongation	Impact Strength
N/mm²	N/mm²	5d (%)	Charpy V notch (ISO-V)
≥ 125 MPa	≥ 275 MPa	≥ 17%	≥ 16 J (R.T.)

#### **GENERAL INFORMATION**

Welding positions	NA								
Shielding gas	Argon (or Helium)								
Packing	5 kg in a cardboard box								
Polarity	AC								
Diameter (mm)	1.0	1.2	1.6	2.0	2.4	3.2			
Lenght (mm)	1000	1000	1000	1000	1000	1000			
Approx. current (A)	0	0							

**Tips & tricks**Highest speed and minimum base metal dilution is recommended for heat treated alloys.
Complex or large aluminium components should be supported by tack welds and jigs.

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.

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