

Classification

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|-----------|--------------------------|-----|----------|
| AWS A5.10 | : ER307.0 | AMS | : 4246 |
| ISO 18273 | : Al 4011 (AlSi7Mg0.5Ti) | UNS | : A03570 |

Description & Applications

Solid wire for GMAW used to weld Aluminium-Silicon alloys with Si content up to 7%. Applicable for a wide variety of Aluminium alloys. Used in foundry reparations.

Base material:

| Alloy | DIN | Material N°. |
|------------------------------|-----------|--------------|
| 3004-3005 | AlMgSi0.5 | 3.3206 |
| 3003 | AlMn1Cu | |
| 3303 | AlMgSi1 | 3.3210 |
| 5005 | AlSi7Mg | 3.2371 |
| 6060-6061-6063-6070-6071 | AlSi5Mg | 3.2341 |
| 356.0, A356.0, 357.0, A357.0 | | |

Typical Chemical Composition (%)

| Si | Fe | Cu | Mn | Mg | Zn | Ti | Al |
|-----|-----|-------|------|-----|-------|-----|------|
| 7.0 | 0.1 | 0.001 | 0.01 | 0.5 | 0.002 | 0.1 | Rem. |

All Weld Metal Mechanical Properties

| R _{p0.2} (MPa) | R _m (MPa) | A ₅ (%) |
|-------------------------|----------------------|--------------------|
| 85 | 130 | 19 |

Welding Current & Instructions

| Welding mode | Wire Ø (mm) | Welding parameters | | Shielding Gas |
|--------------|-------------|--------------------|-------|-------------------|
| | | Pulsed arc (A) | (V) | |
| MIG =+ | 1.0 | 100-150 | 18-22 | Ar/He 18-20 l/min |
| | 1.2 | 130-200 | 18-25 | |
| | 1.6 | 170-260 | 20-27 | |

Ind.10



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