PRODUCT SPECIFICATION

Modi Lastek 77

Welding AlMg5 – highest strength

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)

Mn : 0.05 – 0.20	Si : < 0.25	Fe : < 0.40	Ti : 0.06 – 0.20	Cu : < 0.10
Mg : 4.50 – 5.50	Cr : 0.05 – 0.20	Zn : < 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)
≥ 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
Length (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 aluminum components should be supported by tack welds and jigs.