

Lastek 74

Welding Aluminium with 3% Mg

CLASSIFICATION

EN ISO 18273 : S Al 5754 (AlMg3)

AWS A5.10 : ER 5754

GENERAL DESCRIPTION

Welding rod for AlMg3 work pieces.

Repair of AlMgSi0.5, AlMgSi1 and AlMgMn (AA6060 - AA6082).

Seawater resistant.

Can be used for TIG and oxy acetylene welding.

APPLICATIONS

Containers, architectural applications, chemical industry, food industry, repair of plates and profiles on trucks.

Work pieces that must be anodised (no discoloration on Si free base metals).

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

Cr :	0.15	Mn :	0.25	Si :	0.25	Fe :	0.40	Ti :	0.175
Cu :	0.05	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)

GENERAL INFORMATION

Welding positions NA

Shielding gas Argon

Packing 5 kg in a cardboard box

Polarity AC

Diameter (mm) 2.0 3.2

Lenght (mm) 1000 1000

Tips & tricks

For oxyacetylene welding use a slightly carburising flame + flux Lastek 74A.

Flux residues must be removed with hot water + brushing.

For welding thick pieces: preheat to 150 °C (300 °F).

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.