



MIG ALS7

Old reference: MIG AlSi7

Classification

AWS A5.10 : R-357.0
AMS : 4246

ISO 18273 : S Al 4018 (AlSi7Mg)

Description & Applications

Solid wire for GMAW of Aluminium-Silicium alloys with a Silicium content up to 7%. Used in foundries reparations of AS7 alloy (EN AW-4353 / EN AW AlSi7,5).

Main applications: Space industries, nuclear plant and armament and repair of defects in foundries.

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	Be	O/E	O/T	Al
Min	6.5				0.50						
Max	7.5	0.15	0.05	0.03	0.6	0.05	0.20	0.0003	0.05	0.15	Rem.
Type	7.0	0.10	0.002	0.01	0.52	0.01	0.10	0.0001	<0.05	<0.15	Rem.

All Weld Metal Mechanical Properties

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

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = + / Pulsed	1.0	100-150	18-22	ISO 14175: I1 (100% Ar) I3 (Ar+ 5-30%He) 15-20L/min
	1.2	130-200	18-25	
	1.6	170-260	20-27	

FT En-ML11-200210

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Fumes: Consult information on MSDS, available upon request.

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