



# TIG ALS7

Old reference: TIG AlSi7

## Classification

AWS A5.10 : R-357.0

AMS : 4246

## Description & Applications

Solid rod for GTAW of Aluminium-Silicium alloys with a Silicium content up to 7%.

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

**Base materials:**

DIN	Alloy
AlSi7Mg	6060
	6061
	6063
	6070
	6071
	6351

## Typical Chemical Composition ( % )

	Si	Fe	Cu	Mn	Mg	Zn	Ti	Be	O/E	O/T	Al
Min	6.5				0.45						
Max	7.5	0.15	0.05	0.03	0.6	0.05	0.20	-	0.05	0.15	Rem.
Type	7.0	0.10	0.002	0.01	0.50	0.01	0.10	0.0001	<0.05	<0.15	Rem.

## All Weld Metal Mechanical Properties

	R <sub>0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
Min	-	-	-
Max			
Type	85	130	19

## Welding Current & Instructions

Welding mode	Shielding Gas
GTAW AC (~)	ISO 14175: I1 (100% Ar) / I3 (Ar+ 5-30%He) 5-10 L/min

FT En-TL11-170206

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**Fumes:** Consult information on MSDS, available upon request.

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