


**DESCRIPTION**

Solid GMAW (MIG) wire made up of a **high-strength** and **highly-liquefied** aluminum alloy for welding difficult-to-weld thin sheet, forged and cast aluminum alloys.

**CHARACTERISTICS**

- **Specially designed for dirty or difficult-to-weld aluminum alloys**
- Very high fluidity
- Low melting point alloy
- Excellent weld pool control
- High mechanical resistance
- Excellent electrical conductivity
- Good colour match on aluminum
- Excellent hot cracking resistance

**TYPICAL APPLICATIONS**

Truck bodies, refrigeration, body work, aluminum furniture and boats, frames, tanks, pulleys, etc.

**PROCEDURE**

Clean the weld area and prepare the joints. Remove the oxide layer prior to welding. Preheating of thick sections is recommended to facilitate welding and reduce risks of hot cracking.

**MECHANICAL PROPERTIES**

Tensile strength: 34 000 psi (235 MPa)

**WELDING PARAMETERS**

Gas:	Pure Argon or Ar / He mixture	
Diameter:	.045" (1.2 mm)	.035" (0.9 mm)
Amperage:	150 - 210 A	110 - 180 A
Voltage:	24 - 28 V	22 - 26 V
Gas flow rate (p.c.h):	20 - 40	20 - 40
Packaging:	0.5 kg or 6 kg spool	

Also available in bare rods: **Soudotec 75**

Rév.: 21\_08

*Specialized welding alloys and technology. For technical assistance or for ordering :*