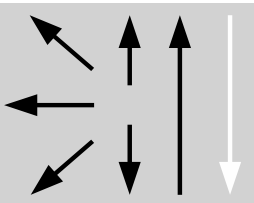


Classifications						
EN ISO 18273			AWS A5.10			
S Al Z (AISi7Mg)			ER4010 (ER4008)			
Characteristics and typical fields of application						
<p>Union AISi 7 Mg is a modified 4010 alloy (alloy 4008) with low levels of impurities, specially designed for joining or repairing of 7% Si aluminium cast components like 356.0, A356.0 and A357.0. The mechanical properties can be increased by heat treatment. Thorough cleaning of the workpiece bevels is necessary prior to welding.</p>						
Base materials						
356.0, A356.0 and A357.0						
EN AC-42000 [AISi7Mg]						
EN AC-42100 [AISi7Mg0.3]						
EN AC-42200 [AISi7Mg0.6]						
and similar.						
Typical analysis of TIG rod (wt.-%)						
Al	Si	Fe	Cu	Mn	Mg	Ti
Bal.	6.5 – 7.5	< 0.1	< 0.05	< 0.05	0.30 – 0.45	0.04 – 0.15
Mechanical properties of all-weld metal						
Yield strength $R_{p0.2}$		Tensile strength R_m		Elongation A ($L_0=5d_0$)		
MPa		MPa		%		
55		165		18		
Operating data						
		Polarity: AC		Shielding gases: (EN ISO 14175) I1, I3		ø mm 1.6 2.0 2.4 3.2 4.0
Approvals						
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