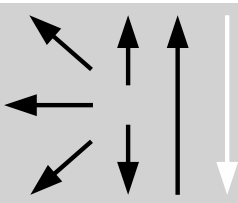


Classifications						
EN ISO 18273			AWS A5.10			
S Al Z (AlSi7Mg)			ER4010 (ER4008)			
Characteristics and typical fields of application						
Union AlSi 7 Mg is a modified 4010 alloy (alloy 4008) with low levels of impurities, specially designed for joining or repairing of 7% Si aluminium cast components 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.						
Base materials						
356.0, A356.0 and A357.0						
EN AC-42000 [AlSi7Mg]						
EN AC-42100 [AlSi7Mg0.3]						
EN AC-42200 [AlSi7Mg0.6]						
and similar.						
Typical analysis of solid wire (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: DC (+)		Shielding gases: (EN ISO 14175) I1, I3		ø mm 1.0 1.2 1.6
Approvals						
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