

Magnesium 92/8 Tig

CATEGORIE	GMAW-GTAW massieve draad
TYPE	Special Magnesium filler metal for welding most Magnesium alloys
APPLICATIONS	Magnesium casting repairs, broken or wornout parts of different Magnesium alloys.
PROPERTIES	Melting Point 1112°F, Magnesium 92/8 is Mg - 9 Al - 2 Zn welding alloy which finds wide use for fabricating and repair welding of many similar compositions. Casting repair and refurbishment is the most common application. Magnesium 92/8 is preferred for joining many casting alloys.

CLASSIFICATION	AWS	A 5.19: ER AZ92A MIL R6944 AMS 4395
	EN ISO	17672: 2010 Mg 001

SUITABLE FOR	Magnesium alloys, 2L124, 2L125, L122. AMS 4484, 4434, 4453, AZ31B, AZ10A, ZK21A, AM100A, AZ61A, AZ63A, AZ80A, AZ81A, AZ91A, AZ92A, AMS 4360, AZ casting alloys to: EK41A, EZ33A, HK31A, HM21A, HM31A, HZ32A, K1A (except AZ61A)
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WELDING POSITIONS:



PURE WELD METAL ANALYSIS (WEIGHT %)

Mg	Al	Zn	Mn	Be	Si	Cu	Fe	Ni	Other
Rem	8,3-9,7	1,7-2,3	0,15-0,5	0,0002-0,0008	<0,05	<0,05	<0,005	<0,005	<0,3

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} psi	R _m psi	A (%) ^{2"}	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	14,000	25,000	2				65

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing (kg)	
D (mm)	Length (mm)	Current (A) (AC/DC+)	single	master
2,4	1000	35-125	1	5
6.0	1000		1	5

REDRYING TEMPERATURE	Not required
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GAS ACC. EN ISO 14175:	I1, Argon+He(70/30)
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