PRODUCT SPECIFICATION

Lastek 7002

Welding of aluminium profiles and plates

CLASSIFICATION

DIN 1732 (Si-AlMn)
A5.3 (E 3003)

GENERAL DESCRIPTION

Welding of aluminum and aluminum alloys.
No discoloration of the weld after anodizing.
Good bond on the base metal, very good releasing of the slag.
Low spatter. Pore-free.
(We recommend using Lastek 62 for welding aluminum-silicon castings.)

TYPICAL USE

Can be used for welding of pure aluminum, AlMgSi, AlMn, AlMg1 and AlMg3.
Chemical and food industry, fish processing industry, transportation (trucks, construction of containers, etc ...)

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Si	Fe	Mn	Al			
0.4	0.3	1.3	Balance			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 150 MPa	≥ 250 MPa	≥ 10%	

General information

Welding positions: PA, PB, PC

Shielding gas: NA

Dia (x length) (mm): 2.5 - 4.0 (x 350)

Packing: 2.5 kg in plastic box

Polarity: DC reverse polarity (electrode positive)

Tips & tricks: Hold the electrode perpendicular to the workpiece. Use a short arc.
High travel speed. Preheat thick pieces to 150 - 200 ° C.
Always use dry electrodes.
Remove the slag thoroughly to avoid corrosion.