



MAGNESIUM

DESCRIPTION

Specially-formulated bare rod for welding magnesium and magnesium alloys.

CHARACTERISTICS

- Can be used with a torch or TIG process
- Very high fluidity
- Low bonding temperature
- High mechanical resistance
- Easy to use
- Good color match on magnesium

TYPICAL APPLICATIONS

Rebuilding of used parts, casting repairs, chain saws, magnesium rims, magnesium tools, cement buckets, loading dock plates, etc.

PROCEDURE

Clean the brazing area and remove grease and dirt. Preheat at 250°C (482°F) to reduce risks of cracking. Dip the hot end of the rod into **Soudotec F0780** flux. Heat the joint uniformly using a low carburizing flame. When the flux becomes fluid, melt the alloy into the joint. Let cool down slowly. Remove flux residue.

MECHANICAL PROPERTIES

Tensile strength: 30 500 psi (210 MPa)

BRAZING PARAMETERS

Diameter: 3.2 mm (1/8")
Bonding temperature: 590°C (1100°F)
Type of flame: Carburizing

For TIG welding, use the same parameters as for welding aluminum.

Rév.: 7_01

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



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