

FILLER METAL SELECTION TABLE FOR LIGHT METAL AND TITANIUM ALLOYS

PROPERTIES	PRODUCTS							
	70	75	76	Zma4	78	780	EasyMigAlu	T792
Tensile strength (x 1000 psi)	34	34	35	—	50	30.5	34	50
Bonding temperature (°C)	N/A	570	590	440-460	370	590	N/A	N/A
Electrical arc (SMAW)	✓							
Electrical arc TIG (GTAW)		✓				✓		✓
Oxy-acetylene torch	✓	✓	✓	✓	✓	✓		
Use with flux		✓			✓	✓		
Self-fluxing alloys			✓	✓				
Soldering				✓				
Aluminum-copper assemblies				✓				
Magnesium parts						✓		
White metal parts					✓			
Truck bodies	✓						✓	
Aluminum parts build-up	✓		✓				2	
Aluminum thin section parts		1	3	2	1		1	
Transmissions	✓		✓				1	
Tubular cast parts		1	2	3			1	
Aluminum boats		✓			✓		2	
Motor boat parts			✓					
Aluminum radiators	3	1	2	2	2			
Titanium parts								✓

1 = Most efficient product(s) ; ✓ = Recommended product(s)

Note :

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This table is not exhaustive; other products may be suitable for certain applications and/or characteristics. Consult the **FSH Welding Canada** Technical Department