

# FONTARGEN A 411

## Magnesium welding rod



AWS A 5.10:	ER AZ 61 A
AMS:	4350 F
B.S.:	1354
Material-no.:	3.5612

### Composition, typical analysis (% w/w):

Al	Si	Mn	Zn	Mg
6,5	0,2	0,4	1,0	Remainder

### Characteristics / Applications:

A 411 is easy to handle. The bonding is achieved without melting the base material. The welding deposit is free from cracks and pores, colour match to Mg alloys. Corrosion-resistant.

Joint and building up of magnesium and magnesium alloys. Plates, profiles, castings.

### Mechanical properties of pure welding deposit

#### (Min. values at room temperature):

Melting range:	594 – 610°C
Tensile strength:	180 N/mm <sup>2</sup>
Yield strength (0,2%):	100 N/mm <sup>2</sup>
Elongation (l=5d):	5 %
Hardness:	50 – 55 HB

**Sources of heat:** Oxyacetylene torch and TIG procedure

**Shielding gas (DIN EN 439):** I 1 (argon)

**Current mode:** Alternating current

**Fluxes:** F 400 (powder, corrosive)  
F 400 M (powder, corrosive, low melting point)

**Availability:** Diameter (mm): 3,0  
Length (mm): 914

**Welding position:** according to DIN EN 287

PA	PB	PC	PD	PE	PF	PG
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