

## Alumi-Arc™ M Versatile Aluminum Alloy Wire

- Wire has controlled columnar strength to reduce wire mis-feeds
- Joins almost all weldable grades of aluminum\*
- Excellent for structural and architectural applications
- Closely controlled cast and helix dimensions for improved wire feed characteristics
- Almost perfect color matching

\*This alloy should not be used to weld the high-magnesium alloys, such as 5083, 5086 or 5456.



### SPECIFICATIONS

Tensile strength..... up to 34,000 psi/234 MPa  
 Hardness ..... up to 55 HBN  
 Elongation ..... up to 25%  
 Color match ..... Excellent, will darken if anodized  
 Current..... DCEP  
 Gas ..... 100% Argon



### PROCEDURES

The shielding gas recommended for Alumi-Arc M is pure argon. Precautions should be taken to ensure that the gas shield is extremely efficient. Air contamination will cause porosity in the weld and may leave black scale. Always purge the system before welding and use gas afterflow. The angle of the welding gun is also important to the shielding gas coverage of the molten weld pool. A 5°-15° drag angle of the gun to the workpiece is recommended.



### APPLICATIONS

- Truck bodies
- Tanks
- Trailers
- Buses
- Handrails
- Pipes
- Machine parts
- Motor and transmission housings

<https://dod.emall.dla.mil>  
 SP47W1-17-D-0009  
 Available in select sizes only

Code #	Spool	Diameter	Amperage	Volts	Electrode Stick-out
641-1-0035	1#	.035"	100-135	19-23	3/8"
641-5-0030	15#	.030"	70-110	18-22	3/8"
641-5-0035	15#	.035"	100-135	19-23	3/8"
641-5-0045	15#	.045"	150-245	21-26	3/8"

Also available in:

