

AX-Mg61A

Standard

DIN EN 1754
AMS 4350

Mg alloys
AZ61A

Area of application

Solid wire electrode/ filler rod for the maintenance and repair of components of magnesium and magnesium alloys.

Special hints

Composition of the filler rod/filler wire (typical data in %)

Mg	Al	Mn	Zn				
Basis	6.5	0.3	0.8				

Important base materials

Magnesium alloys

Material properties

Welding process	MIG	Mechanical properties of the weld metal according to EN ISO 15792-1
Heat treatment	untreated	
Test temperature	20°C	
Yield strength $R_{p0.2}$	[MPa]	150
Tensile strength R_m	[MPa]	280
Elongation A ($L_0 = 5d_0$) %	[%]	7
Modulus of elasticity	[GPa]	45
Liquidus - solidus temperature	[°C]	610– 525
Coefficient of thermal expansion	[1/K]	27.2×10^{-6}
Density	[at 20°C in kg/dm ³]	1.8

Applicable shielding gases (EN ISO 14175)

TIG/MIG: argon I1

Approval

(Request current scope if required)

Product forms (other dimensions available on request)

Spool	Ø mm	1.2	1.6				
Rod	Ø mm x 1000 mm	2.0	2.5	3.0			