Table 29 - Selection of Filler Rods and Wires for MIG and TIG Welding Wrought and Cast Aluminium Alloys

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		5083			5454			5154A		5251	5005	3105	3103	1200	1350	1050A	1080A	Parent Metal Combination
ZA	4043A	4043A	4043A	4043A NA	4043A	4043A	4043A NA	4043A	4043A	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	LM 27
NA	4043A	4043A	4043A	4043A NA	4043A	4043A	4043A NA	4043A	4043A	4043A 4043A 4043A NA	4043A 4043A 4043A NA				4043A 4043A NA	1		LM 25
N <sub>R</sub>	Z R	NR	Ž R	4043A NA		4043A	4043A NA	· ,	4043A	4043A 4043A NA	4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A NA		4043A 4043A NA			LM20
ZA	4043A	4043A	4043A	4043A NA		4043A	4043A NA		4043A	4043A 4043A NA	4043A 4043A NA		4043A 4043A NA		4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A NA	LM9
NR	Z R	Z <sub>R</sub>	Z <sub>R</sub>	4043A NA		4043A	4043A NA		4043A	4043A 4043A 4043A NA		4043A 4043A 4043A NA	4043A 4043A 4043A NA	A A A A	4043A 4043A 4043A NA			LM6
Z			[5056A] [5556A]	5056A NA		5056A	5056A		5056A	5056A 5056A NA			5056A 5056A 5056A NA	5056A 5056A NA	5056A 5056A NA			LM5
Z	4043A	4043A	4043A	4043A NA		4043A	4043A NA		4043A	4043A 4043A NA	4043A 4043A NA		4043A 4043A NA	4043A 4043A NA	4043A 4043A NA			LM4
Z R	Z R	Z	Z	4043A NA		4043A	4043A NA		4043A	4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A NA	4043A 4043A NA	4043A 4043A NA	4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	LM2
5056A	5556A	5556A	5556A	5056A 5056A		5056A 5556A	5056A 5056A		[5056A] [5556A]	5056A 5056A 5056A 5056A	5556A 5556A 5556A 5556A	5556A 5556A 5556A	5556A 5556A 5556A	5556A 5556A 5556A 5556A	5556A 5556A NA	5556A 5556A 5556A 5556A	5556A 5556A 5556A 5556A	7020
100	5056A	5556A	5556A	5056A 5056A	5056A	5056A	5056A 5056A		5056A	5056A 5056A 5056A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A NA	4043A 4043A 5056A	4043A 4043A 4043A 5056A	6082
·   • • •	5056A	5556A	5556A	5056A 5056A		5056A	5056A 5056A	5056A	5056A	5056A 5056A 5056A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A NA	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	6063
1	5056A		5556A	5056A 5056A	5056A	5056A	5056A 5056A	5056A	5056A	5056A 5056A 5056A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 4043A NA	4043A 4043A 5056A	4043A 4043A 4043A 5056A	6061
	5056A	5556A	5556A	5056A	5056A	5056A	5056A NA	5056A	5056A	5056A 5056A 5056A NA	4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A NA	4043A 4043A 4043A NA	6101A
5056A	5556A	5556A	5556A	056A 154A	154A 056A	5056A 5556A	056A 154A	154A 056A	5056A 5556A	5056A 5056A 5056A 5056A	5056A 5556A 5056A 5056A	5056A 5056A 5056A 5056A	5056A 5056A 5056A 5056A	5556A 5556A 5556A 5556A	5556A 5556A 5556A NA	5556A 5556A 5556A 5556A	5556A 5556A 5556A 5556A	5083
				5056A 5554	5554	5056A	5056A 5154A	5554	5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A NA	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5454
							5056A 5154A	5154A	5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5056A 5056A 5056A	5056A 5056A 5056A NA	5056A 5056A 5056A 5056A	5056A 5056A 5056A 5056A	5154A
										5056A 5554 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5056A 5154A 5056A NA	5056A 5154A 5056A 5056A	5056A 5154A 5056A 5056A	5251
A A											5154A 5154A 5056A 5154A	5056A 5056A 5056A 5056A	5056A 5056A 5056A 5056A	5056A 5056A 5056A 5056A	5056A 5056A 5056A NA	5056A 5056A 5056A 5056A	5056A 5056A 5056A 5056A	5005
												4043A 3103 4043A 3103	4043A 3103 4043A 3103	4043A 3103 4043A 1050A	4043A 3103 4043A NA	4043A 3103 4043A 1050A	4043A 3103 4043A 1050A	3105
													4043A 3103 4043A 3103	4043A 3103 4043A 1050A	4043A 3103 4043A NA		4043A 3103 4043A 1050A	3103
												***		4043A 1050A 4043A 1050A	4043A 1050A 4043A NA		4043A 1050A 4043A 1050A	1200
												Wester			4043A 1050A 4043A NA		4043A 1050A 4043A NA	1350
										***************************************			***************************************				4043A 1050A 4043A 1050A	1050A
												- Andrews						1080A

LM 27	LM 25	LM 20	LM9	LM6	LM 5	LM 4	LM2	7020	6082	6063	6061	6101A
4043A 4043A 4043A 4043A 4043A	4043A 4043A 4043A 4043A	4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	ZZZZ ZZZZ	4043A 4043A 4043A 4043A	4043A 4043A 4047A 4043A	ZZZZ	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA
:	4043A 4043A 4043A 4043A	4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	ママママ アアアア	4043A 4043A 4043A 4043A	4043A 4043A 4047A 4043A	ZZZZ	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A NA	4043A 4043A 4043A NA
		4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	ママママ アアアア	4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	ZZZZ	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A 4043A NA
			4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	ZZZZ ZZZZ	4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	ZZZZ RRRR	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A NA	4043A 4043A 4043A NA
				4043A 4043A 4047A 4043A	ママママ アアアア	4043A 4043A 4047A 4043A	4043A 4043A 4047A 4043A	ZZZZ	4043A 4043A 4043A NA	4043A 4043A 4043A NA	4043A 4043A NA	4043A 4043A 4043A NA
					5056A 5056A 5056A 5056A	ZZZZ	ZZZZ	5556A 5556A 5556A 5556A	5056A 5056A 5056A NA	5056A 5056A NA	5056A 5056A NA	5056A 5056A NA
,						4043A 4043A 4043A 4043A	4043A 4043A 4047A 4043A	ZZZZ	4043A 4043A NA	4043A 4043A NA	4043A 4043A NA	4043A 4043A NA
		:					4043A 4043A 4047A 4043A	ZZZZ	4043A 4043A 4043A NA	4043A 4043A NA	4043A 4043A NA	4043A 4043A NA
				-				5556A 5556A 5556A 5556A	ZZZZ	ZZZZ	ZZZZ	ZZZZ
									4043A 4043A 4043A 5056A	4043A 4043A 4043A 5056A	4043A 4043A 5056A	4043A 4043A NA
			-							4043A 4043A 4043A 5056A	4043A 4043A 5056A	4043A 4043A NA
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and is to be preferred for freedom from persistent weld cracking.	1. NA = Not applicable. 1. NA = Parent metal combinations not recommended. 2. NR = Parent metal combinations not recommended. 3. For casting alloys LM 2, LM 6, LM 9 and LM 20, 4047A may be consisted for AM2A for better compositional matching.	The filler material for optimum colour matching when welds are to be anodized is shown on the bottom line.	The filler material for maximum resistance to corrosion (see CP 118 and BS 1500 Part 3) is shown on the second line.  The filler material for freedom from persistent weld cracking is shown on the third line.	parent metals.  The filler material for maximum weld strength is shown on the top line.	Recommended filler materials for each combination of materials to be welded are shown in one box, which is located by traversing horizontally and vertically from the appropriate			mentary international many marked definant, addition,				
be preferred for freedom from persistent weld	licable. netal combin nys LM 2, LN	rial for optined is shown	rial for maxi 500 Part 3) i rial for freed third line.	ial for maxin	filler mate elded are shoontally and							***************************************
r freedom f	ations not r	num colour r on the botto	mum resista s shown on om from per	num weld str	rials for ea wn in one bo vertically fr							
from persis	ecommende	matching w )m line.	the second rsistent weld	ength is sho	ach combing, which is loom the ap							
tent weld	d. )47A may	hen welds	cracking	wn on the	nation of ocated by propriate				***************************************			

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