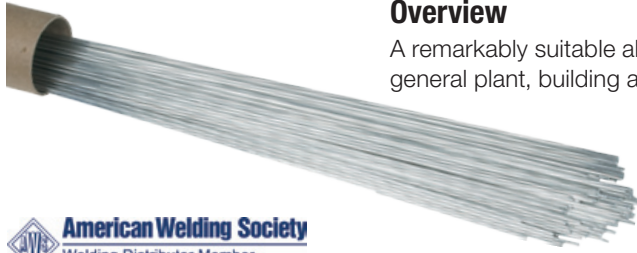


Technical Data Sheet

510T TIG Wire The High-Strength Aluminum Alloy



Cronatron™
A LAWSON BRAND



Overview

A remarkably suitable aluminum alloy for casting repair or wrought and sheet work in general plant, building and all types of maintenance applications.



Features/Benefits

- Lower temperature melting point than aluminum
- Provides a color-matched smooth deposit
- High corrosion resistance
- All-position welding ease
- Excellent for both cast and sheet aluminum

Applications

- All-aluminum castings and housings
- Cylinder heads and compressor cases
- Oil pans, vessels, vats and tanks
- Pipes, frames and ornamental aluminum
- Guard rails, appliances, tools, etc.

Method of Application

Torch or TIG

Identification

Aluminum gray, embossed or flagged

Directions for Gas Use

Bevel joints to be welded; use the flex wheels specially designed for aluminum to remove oxidation, dirt and scale. A gap of 1/16" to 1/8" (1.6mm to 3.2mm) should be maintained if possible. Torch flame should be kept at a 1" to 3" (2.5cm to 7.6cm) distance from base metal and in constant motion. When flux melts to a clear liquid, apply enough alloy to thoroughly wet and bond to base metal.

Technical Specifications

Tensile Strength: 35,000 PSI (241 MPa)
Temperature: 1,080°F (582°C)

Polarity: AC/High Frequency
Gas: Argon/Helium

Technical Tips

If additional flux is required, F55 or F56 Fluxes are recommended.

