

FILLER METAL SELECTION TABLE FOR LIGHT METAL AND TITANIUM ALLOYS

PROPERTIES	PRODUCTS							
	70	75	Zinal 4	TBM 12NCs	78	780	EasyMigAlu	T792
Tensile strength (x 1000 psi)	34	34	—	140	50	30.5	34	50
Bonding temperature (°C)	N/A	570	440-460	575-585	370	590	N/A	N/A
Electrical arc (SMAW)	✓							
Electrical arc TIG (GTAW)		✓				✓		✓
Oxy-acetylene torch	✓	✓	✓	✓	✓	✓		
Use with flux		✓			✓	✓		
Self-fluxing alloys			✓	✓				
Soldering			✓					
Aluminum-copper assemblies			✓					
Pièces en magnésium						✓		
White metal parts					✓			
Truck bodies	✓			✓			✓	
Aluminum parts build-up	✓						2	
Aluminum thin section parts		1	2	2	1		1	
Transmissions	✓			✓			1	
Tubular cast parts		1	3	1			1	
Aluminum boats		✓		✓	✓		2	
Motor boat parts								
Aluminum radiators	3	1	2	1	2			
Titanium parts								✓

1 = Most efficient product(s) ; ✓ = Recommended product(s)

Note :

This table is not exhaustive; other products may be suitable for certain applications and/or characteristics. Consult the **FSH Welding Canada** Technical Department