Inweld AZ61A

AWS A5.19 ERAZ61A

Chemical Composition of Inweld AZ61A

Fe	Mg	Be	Ni	Zn	Mn	Si	Al	N	Cu	Other
0.005	5.8-7.2	0.0002-0.0008	0.05	0.40-1.50	0.15-0.50	---	5.8-7.2	---	0.05	0.30

Single values are maximum unless otherwise specified.

Description and Applications

For manual AC welding, argon is generally preferred because the arc has good stability. On heavier sections, the addition of helium may be considered, and arc penetration will increase significantly; however, gas flow rates must be increased when helium is added. If oxyacetylene is used, employ a neutral or slightly reducing flame and flux. Remove flux residue with hot water.

Recommended Parameters

GMAW (DCEN – Electrode-)

Wire Diameter	Voltage	Amperage
0.020”		5-20
0.040”		15-80
1/16”		70-150
3/32”		150-250
1/8”		250-400