

MF 500

HIGH STRENGTH ALLOY WITH 5% SILICON FOR ALUMINIUM



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SPECIAL FEATURES

- **MF 500** Gives perfect welds on practically all types of Aluminum -both sheet and cast
- **MF 500** High-Strength Alloy for Aluminum
- **MF 500** Is so easy to use that it makes every welder easy with arc welding on Emergency Repair
- **MF 500** Gives welds that are stronger than pure Aluminum



MF-500

OUTSTANDING PROPERTIES:

- Requires no special skills or equipment
- Minimum spatter
- Features ultra high-pressure extruded coating enabling short arc and spray transfer application
- Requires no preheating -except in heaviest sections
- Provides non-porous welds that resist corrosion if clean weld surface
- Provides a good color match to aluminum

APPLICATIONS

MF 500 (for DC reverse polarity only) is ideal for use on

Structural Members	Aluminum Housings	Caravan & Truck Bodies
Aluminum Frames	Aluminum Pumps	Irrigation Piping
Casting Repairs	Foundry Patterns,	Metal Plates

RECOMMENDED FOR:

Arc welding Aluminums alloyed with copper, silicon, and magnesium. Also excellent for joining dissimilar grades of Aluminum.

MECHANICAL PROPERTIES:

Undiluted Weld Metal

Tensile Strength	Maximum Value Up to: 34,000 psi (250 N/mm ²)
Yield Strength	20,000 psi (150 N/mm ²)
Elongation	18%

RECOMMENDED CURRENT: DC Reverse (+)

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	20	50	70	110
Maximum Amperage	60	80	120	150

WELDING POSITIONS : Flat, Horizontal

WELDING TECHNIQUES:

Start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

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