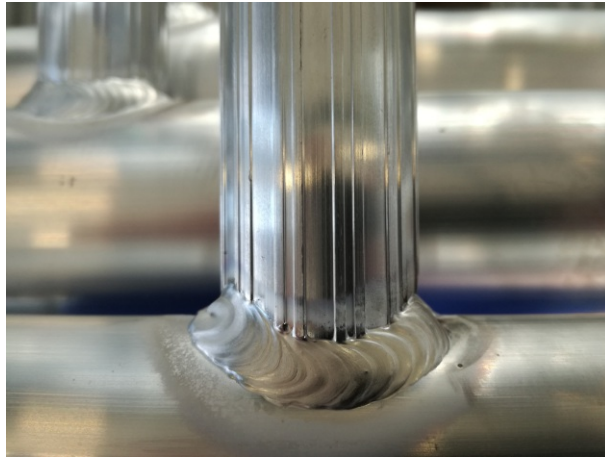


MF 501

HIGH STRENGTH ALLOY WITH 12% SILICON FOR ALUMINIUM



- One stop solution for all types of aluminum
- Gives welds that are stronger than parent metal

SPECIAL BENEFITS

- **MF 501** provides high-strength welds that are stronger than pure aluminum.
- **MF 501** suitable for most types of aluminum -both sheet and cast.
- **MF 501** high-Strength Alloy for Aluminum
- **MF 501** gives welds produced are stronger than the parent aluminium



MF-501

OUTSTANDING PROPERTIES:

- Features ultra high-pressure extruded coating enabling short arc and spray transfer application
- Requires no preheating -except in heavy sections
- Provides a good color match to aluminum

APPLICATIONS

MF 501 (for DC reverse polarity only) is ideal for use on

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

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
Yield Strength
Elongation

Maximum Value Up to:

34,000 psi (250 N/mm²)
20,000 psi (150 N/mm²)
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:

Pre heat the work piece, start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

MF - 501 HIGH STRENGTH ALLOY WITH 12% SILICON
FOR ALUMINUM

