

ERAZ92A magnesium welding alloy is a good choice when welding magnesium base metals of similar chemical composition. It produces superior joints with the maximum tensile strengths offered by these alloys. Cleanliness of both the filler metal and base metal is extremely important when welding with magnesium. Flux is NOT required for TIG or MIG welding processes of ERAZ92A magnesium alloy. Although Oxy-acetylene welding of this alloy is uncommon it can be done and should be limited to single-pass welding on thin gauge magnesium materials.

AWS Specification

ANSI/AWS A5.19-92 (R2006)

AWS Classification ERAZ92A

Welding Current

GTAW - AC/DCEP

GMAW - DCEP

Typical Wire Chemistry

Al 8.3 - 9.7

Be 0.0002 - 0.0008

Mn 0.15 - 0.5

Zn 1.7 - 2.3

Cu 0.05

Fe 0.005

Ni 0.005

Si 0.05

Mg REM

OTHER 0.30

Typical Mechanical Properties

(As Welded)

Yield Strength, ksi 14

Tensile Strength, ksi 25

Elongation%, min 2

Brinell Hardness 65

Melting Point °F 1110

**Available diameters MIG and
suggested Operating Range in Amps**

.040" 25 - 50

1/16" 70 - 175

3/32" 115 - 210

**Available Diameters TIG and
suggested Operating Range in Amps**

3/32" 35 - 125

1/8" 160

5/32" 175