Welding wire (Tig) for Magnesium (AZ92A)

The oxides on the surface is the main issue when welding Magnesium, to obtain good results the surface should be cleaned mechanically with an aluminum or stainless steel brush. For chemically cleaning a solution of 24 oz. Chromic acid, 5-1/3 oz. ferric nitrate and 1/16 oz. potassium fluoride in enough water to make one gallon. Bring the solution to 70-90° F then immerse the part for 3 minutes and rinse in hot water. Make sure that both the welding joint and the filler rod are properly cleaned. For the Tig process a Tungsten Zirconium electrode should be used preferably on AC current with pure Argon to offer proper melt pool protection. Argon / Helium mixture may be used when increased temperature and cleaning action is preferred.

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