

Inweld AZ92A

AWS A5.19 ERAZ92A

Chemical Composition of Inweld Z92A

Mg	Fe	Be	Ni	Zn	Mn	Si	Al	N	Cu	Other
Balance	0.005	0.0002- 0.0008	0.005	1.7- 2.3	0.15- 0.50	0.05	8.3- 9.7	---	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 flam and flux. Remove flux residue with hot water.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Average As-Welded Brinell Hardness:	65
Tensile Strength:	25,000 psi
Yield Strength:	14,000 psi
Elongation:	2%

Recommended Parameters

GMAW (DCEN – Electrode-)

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

GMAW (DCEP – Reverse Polarity Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
1/16"		10-20
3/32"		15-30
1/8"		25-40
5/32"		40-55
3/16"		55-80

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