

GENERAL DESCRIPTION

Elite 841 is a high-quality Italian manufactured under strict quality control, triple shaved and precision layer wound solid aluminium wire suitable for welding alloys containing up to 5% magnesium. Smooth wire feed, a low fume factor and clean welds the 841 has a good resistance to marine atmospheric corrosion and suitable for aluminium base metals 3xxx, 5xxx and 6xxx series.

APPLICATIONS:

- General aluminium fabrication
- Shipbuilding
- Construction
- Automotive
- Storage tanks

WELDING POSITIONS



CLASSIFICATION

SFA - 5.10/5.10M : 2012 AWS ER 5356
AS/NZS ISO 18273 - S Al 5356

RECOMMENDED SHIELDING GASES

100% Argon
Argon/Helium mixtures

CHEMICAL COMPOSITION

Wt% - wire	Si	Fe	Cu	Mn	Mg	Zn	Ti	Cr	Be	Al
	0.10	0.20	0.02	0.10	5.00	0.05	0.10	0.10	≤0,0003	REM

TYPICAL MECHANICAL PROPERTIES

Typical as welded	
Yield Strength	110 Mpa
Tensile strength	270 Mpa
Elongation	20%

DEPOSITION DATA - DCEP (DC+)

1.2mm Diameter	
Current (A)	80-220A – (suggested starting current 160-170A)
Voltage (V)	16-23V – (suggested starting voltage 20 – 21V)
Wire Speed	11mt
Gas volume	18-20lt/min

Welding parameters are a guide only as they are dependent on the machine used / setup parameters, material thickness and operator experience. Some adjustments between wire types would be needed as Euromarc 841 is melting from lower amperage vs some competitor brands.

No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

CONFORMANCE AND APPROVAL

CE, ABS, LR, DB, TUV, Rina

STORAGE

Store all wire spools in their original packaging in a controlled environment of less than 50% relative humidity.

WARNING

Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection.

Read and understand the Safety Data Sheet for this product.

PACKAGING INFORMATION

Size	Weight	Spool	Vacuumed Packed	Part Number / Order code
1.0	7kg	D300	YES	VW84101207
1.2	7kg	D300	YES	VW84101007
1.0	0.5Kg	Mini Spool	YES	VW84110005
1.2	0.5Kg	Mini Spool	YES	VW84112005

