AEROSPACE
MATERIAL SPECIFICATIONS
SOCIETY OF AUTOMOTIVE ENGINEERS, Inc. 485 Lexington Ave., New York 17, N.Y.

AMS 4395A

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MAGNESIUM WIRE, WELDING
9Al - 2Zn (AZ92A)

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

2. APPLICATION: Primarily for use as filler metal for inert gas arc welding of magnesium alloys of similar composition, particularly where consistently high quality joints are mandatory.

3. COMPOSITION:

Aluminum	8.3 - 9.7
Zinc	1.7 - 2.3
Manganese	0.15 min
Silicon	0.05 max
Copper	0.05 max
Nickel	0.005 max
Iron	0.005 max
Other Impurities, total	0.30 max
Magnesium	remainder

4. CONDITION:

4.1 Unless otherwise specified, wire for cut lengths shall be extruded; for spooled wire, shall be extruded and sized. Wire shall be furnished on disposable spools for machine welding and in cut lengths for manual welding operations, as ordered.

4.2 Extruding compounds, oxides, and dirt shall be removed.

5. TECHNICAL REQUIREMENTS:

5.1 Welding: Melted wire shall flow smoothly and evenly during welding and shall be capable of producing acceptable welds.

5.2 Spooled Wire: Shall conform to the following unless otherwise agreed upon by purchaser and vendor.

5.2.1 Layer Winding: Wire shall be closely wound in layers but adjacent turns within a layer need not necessarily be touching; shall be wound so as to avoid producing kinks, waves, and sharp bends; and shall be free to unwind without restriction caused by overlapping or wedging. The outside end of the spooled wire shall be so treated that it may be readily located.

5.2.2 Wire on each spool shall be in one continuous length.

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