

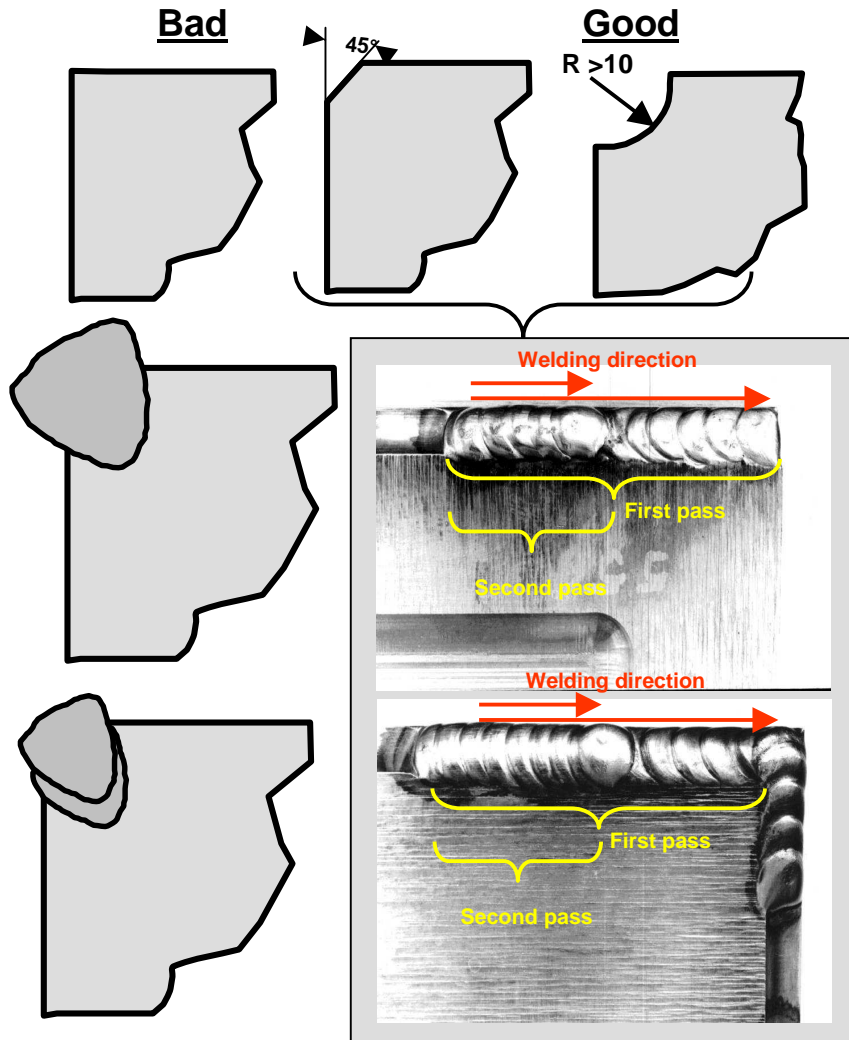


**WELDING OF:
HOKOTOL**

HOKOTOL - The High-Strength Alloy

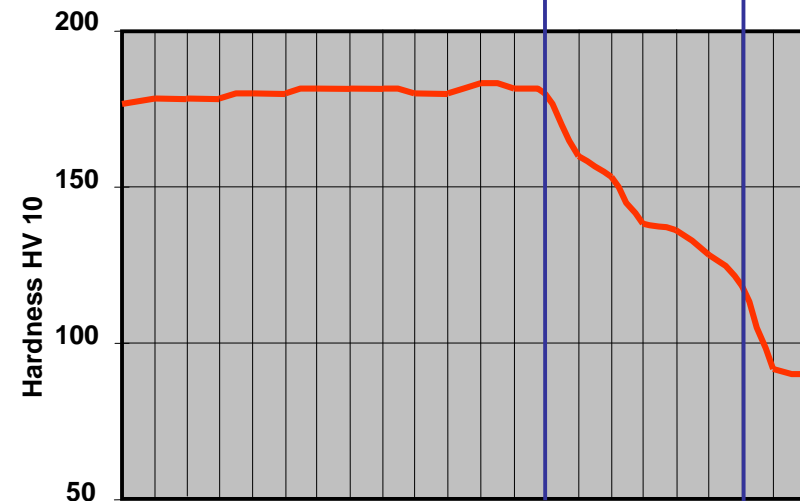
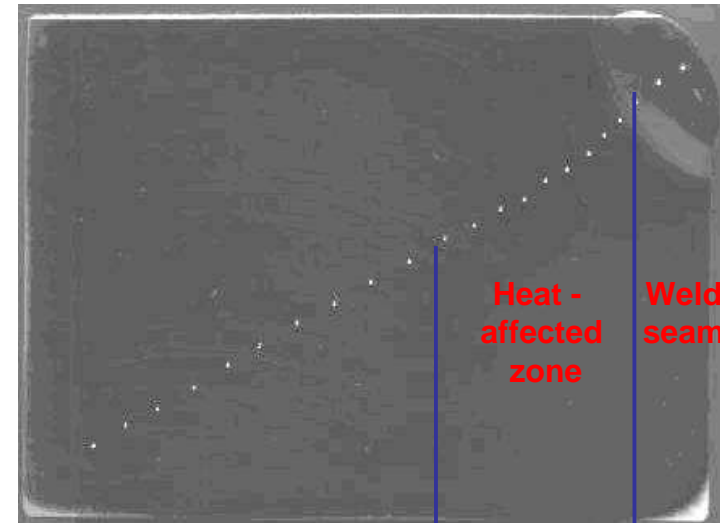
Repair Welding

Preparing and welding of edges



Hardness profile of welded HOKOTOL

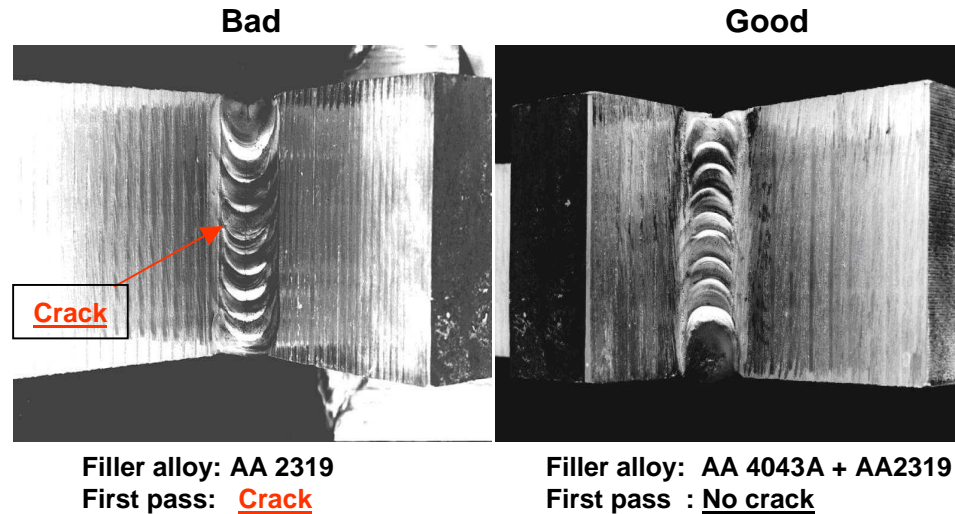
- Welding process: TIG; Filler alloy: AA 5556



HOKOTOL - The High-Strength Alloy

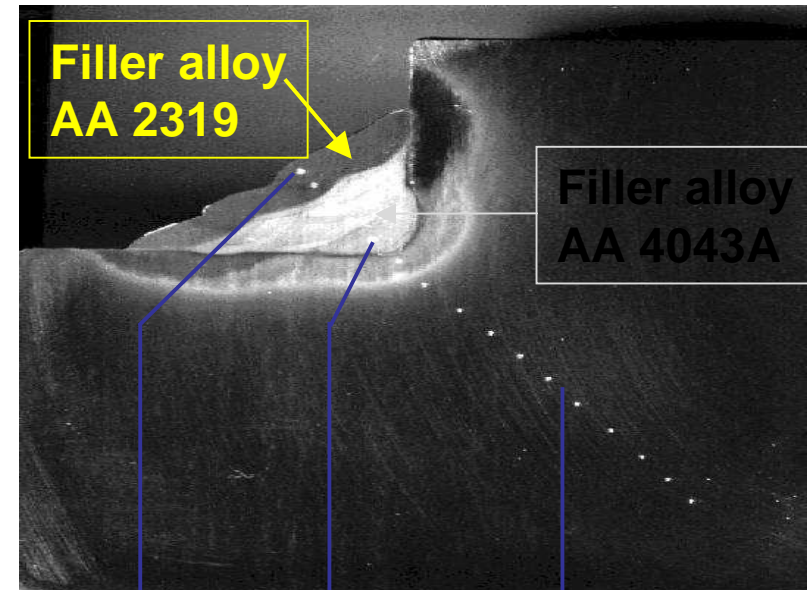
Repair Welding

Influence of filler alloy

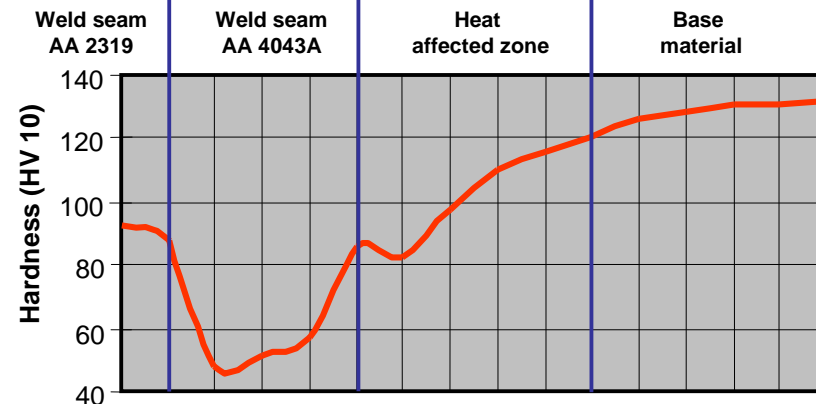
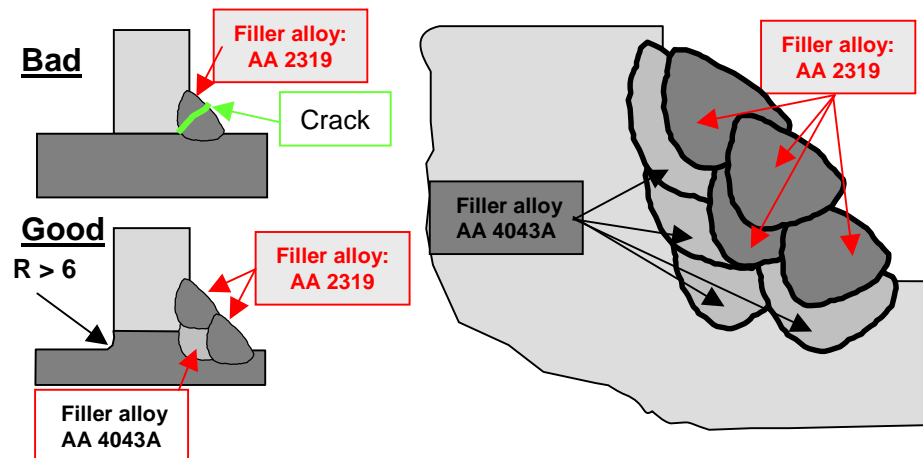


Hardness profile of welded HOKOTOL

- Welding process: TIG
- Filler alloy: AA 4043A and AA 2319

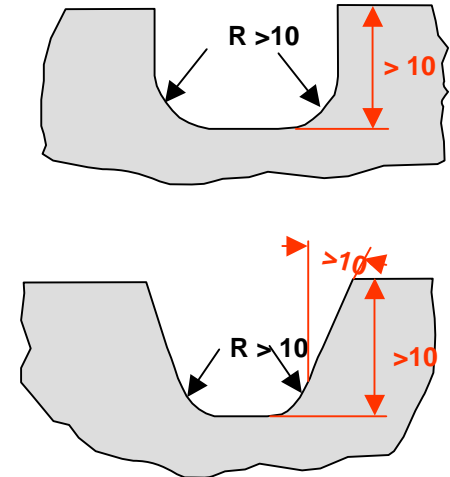
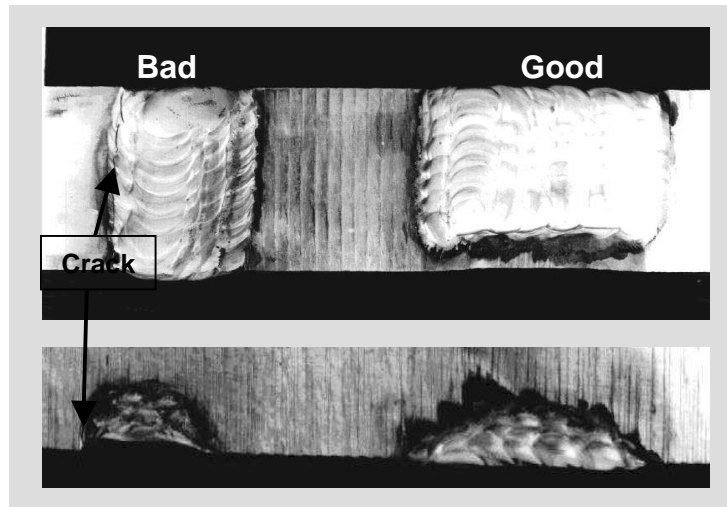
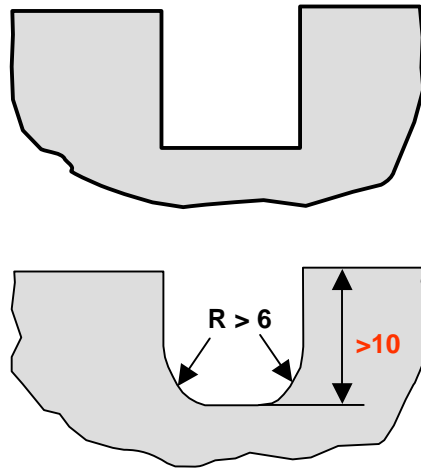


Weld preparing and Welding

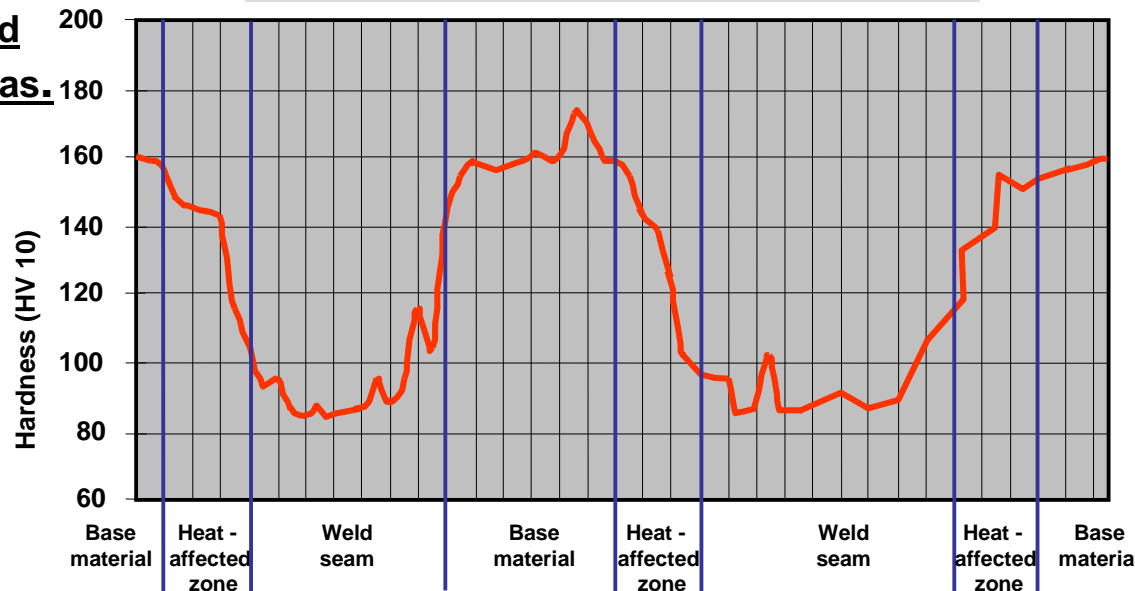
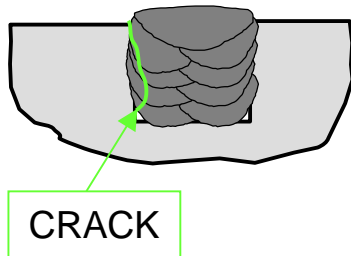


HOKOTOL - The High-Strength Alloy

Repair Welding



Preparing and welding of areas.
Bad



Good

Hardness profile of welded HOKOTOL

- Welding process: TIG
- Filler alloy: AA 2319

HOKOTOL - The High-Strength Alloy

Repair Welding: Filler alloys

Chemical composition of recommended filler alloys (weight %)

Alloy	Si	Fe	Cu	Mn	Mg	Ti	Zr
AA 4043 (AlSi5)	4,5 – 6,0	max. 0,6	max. 0,30	max. 0,15	max. 0,20	max. 0,15	-
AA 5183 (AlMg4,5Mn0,7)	max. 0,20	max. 0,40	max. 0,10	0,40 – 1,00	4,00 – 4,9	max. 0,5	-
AA 5556 (AlMg5Mn)	max. 0,25	max. 0,40	max. 0,10	0,5 – 1,00	4,7 – 5,5	0,05 – 0,25	-
AA 2319 (AlCu6,5Mn0,3)	max. 0,20	max. 0,30	5,6 – 6,6	0,20 – 0,40	max. 0,02	0,02 – 0,20	0,10 – 0,25

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