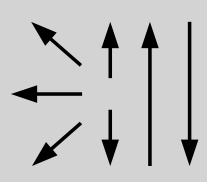


Classifications					
EN ISO 18273		AWS A5.10			
S Al 5754 (AlMg3)		ER5754			
Characteristics and typical fields of application					
Aluminium-alloyed welding rods for welding of aluminium alloys up to 3 % Mg. The weld metal is seawater-resistant. Welding joints on anodic oxidable base materials.					
Base materials					
AlMg 3	3.3535	EN AW-5754 [AlMg 3]			
AlMg 2 Mn 0.3	3.3525	EN AW-5251 [AlMg 2]			
AlMg	3.3315	EN AW-500SA [AlMg 1(C)]			
AlMgSi 0.5	3.3206	EN AW-6060 [AlMgSi]			
AlMg 2.7 Mn	3.3537	EN AW-5454 [AlMg 3 Mn]			
G-AlMg 3	3.3541	EN AC-51100			
GAlMg 3 Si	3.3241	-			
Typical analysis of solid wire (wt.-%)					
	Al	Mn	Cr	Mg	Ti
wt.-%	bal.	0.1 – 0.6	< 0.3	2.6 – 3.6	< 0.15
Mechanical properties of all-weld metal					
Condition		Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	
		MPa	MPa	%	
u		80	≥ 190	≥ 20	
u	untreated, as welded				
Operating data					
		Polarity: AC	Shielding gases: EN ISO 14175: I1		ø (mm)
					1.6
					2.0
			Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm		2.4
					3.2
					4.0
Approvals					
DB (61.014.02), CE					