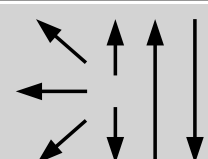


| Classifications | | | | | |
|--|-------------------------------------|------------------------------|---|-----------|---|
| EN ISO 18273 | | AWS A5.10 | | | |
| S Al 5183 (AlMg4.5Mn0.7(A)) | | ER5183 | | | |
| Characteristics and typical fields of application | | | | | |
| Sold wire for welding of AlMg alloys. The weld metal is resistant against sea water. Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm | | | | | |
| Base materials | | | | | |
| AlMg 4.5 Mn | 3.3547 | EN AW-5083 [AlMg 4.5 Mn 0.7] | | | |
| AlMg 4 Mn | 3.3545 | EN AW-5086 [AlMg 4] | | | |
| AlMg 5 | 3.3555 | EN AW-5019 [AlMg 5] | | | |
| AlMgSi 0.5 | 3.3206 | EN AW-6060 [AlMgSi] | | | |
| AlMgSi 0.7 | 3.3210 | EN AW-6005A [AlSiMg(A)] | | | |
| AlMgSi 1 | 3.2315 | EN AW-6082 [AlSi 1 MgMn] | | | |
| AlMg 1 SiCu | 3.3211 | EN AW-6061 [AlMg 1 SiCu] | | | |
| AlZn 4.5 Mg | 3.4335 | EN AW-7020 [AlZn 4.5 Mg 1] | | | |
| G-AlMg 5 | 3.3561 | EN AC-51300 | | | |
| G-AlMg 5 Si | 3.3261 | EN AC-51400 | | | |
| Typical analysis of solid wire (wt.-%) | | | | | |
| | Al | Mn | Cr | Mg | Ti |
| wt.-% | bal. | 0.5 – 1.0 | 0.05 – 0.25 | 4.3 – 5.2 | <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 | ≥ 130 | | ≥ 275 | | ≥ 18 |
| u | untreated, as welded | | | | |
| Operating data | | | | | |
|  | | Polarity: DC (+) | Shielding gases: (EN ISO 14175) I1, I3 | | ø (mm) 1.2 |
| Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm | | | | | |
| Approvals | | | | | |
| TÜV (02319.), DB (61.014.05), CE | | | | | |