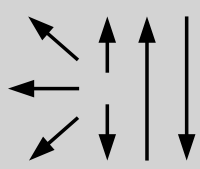


Classifications									
EN ISO 18273	AWS A5.10								
S Al 5754 (AlMg3)	ER5754								
Characteristics and typical fields of application									
Solid wire for AlMg alloys containing up to 3 % Mg. Seawater resistant weld metal. Good colour matching with base metal after anodizing. Thorough cleaning of the workpiece bevels is necessary. Thicker plate materials require preheating to 150 °C (302 °F).									
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							
GAIMg 3 Si	3.3241	-							
Typical analysis of solid wire (wt.-%)									
	Al	Mn	Cr	Mg	Ti	Fe	Si	Zn	Cu
wt.-%	bal.	< 0.5	< 0.3	2.6 – 3.6	< 0.15	< 0.4	< 0.4	< 0.2	< 0.1
Mechanical properties of all-weld metal									
Yield strength $R_{p0,2}$	Tensile strength $R_m$			Elongation A ( $L_0=5d_0$ )					
MPa	MPa			%					
80	190			20					
Operating data									
		<b>Polarity:</b> DC (+)		<b>Shielding gas:</b> EN ISO 14175: I1, I3  Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm				<b>ø (mm)</b> 1.0 1.2 1.6	
Approvals									
-									