

# MIGWELD AlMg5

MIG/MAG Wires [GMAW]

Aluminium alloys

<b>CLASSIFICATION:</b> EN ISO 18273-A : S AL5356 DIN 1732 : SG AlMg5 AWS A-5.10 : ER 5356 W.Nr. : 3.3356	<b>APPROVALS:</b>	<b>APPLICATION:</b> Shipbuilding&Offshore Automobile
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- Solid aluminum welding wire for alloys containing up to 5% magnesium.
- Good resistance to atmospheric corrosion in marine environments.
- Above-average abrasion resistance of the weld metal.

### Application

Construction works in shipbuilding, railway and automotive industries; construction of tanks


### Base material

DIN 1725-1/2	W.Nr.	Int.Reg.Nr.	
AlMg3	3.3535	5754	
AlMg4,5	3.3345	5082	
AlMg5	3.3555	5056A	
AlMg2Mn0,8	3.3527	5049	
AlMg2,7Mn	3.3537	5454	
AlMg4Mn	3.3545	5086	
AlZn4,5Mg1	3.4335	7020	
G-AlMg3	3.3541		
G-AlMg3Si	3.3241	512.0	
G-AlMg5	3.3561	B535.0	
G-AlMg5Si	3.3261		
AlMgSi	3.3206	6060	
AlMg1SiCu	3.3211	6061	
AlMgSi07	3.3210	6005A	
AlSi1MgMn	3.2315	6082	

### Typical chemical composition %

<b>Mn</b>	<b>Cr</b>	<b>Fe</b>	<b>Al</b>	<b>Inne</b>
0,14	0,13	0,11	rest	Mg 4,87

### Typical mechanical properties

<b>Yield strength Re [N/mm2]</b>	110
<b>Tensile strength Rm [N/mm2]</b>	240
<b>Elongation A5 [%]</b>	17
<b>Hardness</b>	65[HBW] /
<b>Wire/rod type</b>	solid
<b>Heat treatment</b>	Thicker elements should be heated to 150 [°C]
<b>Welding current</b>	

**Welding positions****Shielding gases acc. to EN ISO 14175**

I1 - Ar / I3 - Ar + &gt;0-95% He /

**Welding parameters and packing**

∅	Welding current [A]	Weight of packet [kg]
0,8	40-150	2,0/7,0
1,0	70-180	2,0/7,0
1,2	80-220	2,0/7,0

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