

TIGWELD AlMg5

TIG Rods [GTAW]

Aluminium alloys

| | | |
|--|-------------------|--|
| CLASSIFICATION: EN ISO 18273-A : S AL5356 DIN 1732 : SG AlMg5 AWS A-5.10 : ER 5356 W.Nr. : 3.3356 | APPROVALS: | APPLICATION: Shipbuilding&Offshore Automobile |
|--|-------------------|--|

- TIG rod made of aluminum alloy 5% Mg.
- Suitable for welding alloys containing up to 5% magnesium.
- Good resistance to atmospheric corrosion in marine environments.

Application

Construction works in the shipbuilding, railway and automotive industries. Construction of tanks.


Base material

| DIN 1725-1/2 | W.Nr. | Int.Reg./Cast. 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 %

| | | | | |
|-----------|-----------|-----------|-----------|-------------|
| Mn | Cr | Fe | Al | Inne |
| 0,14 | 0,13 | 0,10 | rest | Mg 4,87 |

Typical mechanical properties

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

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

I1 - Ar / I3 - Ar + >0-95% He /

Welding parameters and packing

| ∅ | Length [mm] | Weight of packet [kg] |
|-----|-------------|-----------------------|
| 1,6 | 1000 / | 2,5 |
| 2,0 | 1000 / | 2,5 |
| 2,4 | 1000 / | 2,5 |
| 3,2 | 1000 / | 2,5 |

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