

CLASSIFICATIONS

EN ISO 18273 : S AI 5754 (AlMg3)

AWS A5.10 : ER 5754

DESCRIPTION

- It is used for joining aluminum alloys includes up to 3 % Mg. Resistance to sea water. Parent metals AlMg 1, AlMg 2.5, and AlMg 2 Mn 0.8 etc
- Required use of Ar, He or Ar+He gas as shielding gas
- It is recommended that preheating to 150°C before welding of plates thicker than 10mm

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

Mg: 3.0 | Mn: <0.5 | Si: <0.40 | Fe: <0.40 | Al: rest

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation ($L_0=5d_0$) (%)	Working Temperature (°C)
100	200	20	610 - 642

BASE MATERIALS

- AlMg 1, AlMg 2.5, AlMg 3, AlMg 2.7 Mn, AlMg Si 0.5, AlMg 2, AlMg2 Mn 0.8, AlMgSi 0.7, AlMgSi 0.8, G-AlMg 3, G-AlMg3 (Cu), G-AlMg 3 Si.

WELDING POSITIONS



CURRENT CONDITION

MIG D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Package Weight (kg)
1011100089	1.20	0.047"	7
1011100090	1.60	0.062"	7