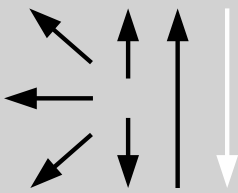


Classifications						
EN ISO 18273			AWS A5.10			
S Al 5554 (AlMg2,7Mn)			ER5554			
Characteristics and typical fields of application						
Solid wire for GMAW of AlMg alloys. The limited Mg-content of max. 2,8 % to obtains intergranular corrosion resistance. Sea water resistant. Recommended for high temperature applications (>65°C). For obtaining near matching coloured joints where anodizing is required.						
Base materials						
EN AW-5754 [AMg3]	AlMg3	3.3535				
EN AW-5454 [AlMg3Mn]	AlMg2,7Mn	3.3537				
EN AW-5251 [AlMg2]	AlMg2Mn0,3	3.3523				
EN AW-5005A [AlMg1(C)]	AlMg	3.3315				
EN AW-3004A [AlMn1Mg1]	AlMn1Mg	3.0526				
EN AC-51100	G-AlMg3	3.3541				
and similar.						
Typical analysis of solid wire (wt.-%)						
Al	Si	Fe	Mn	Mg	Cr	Ti
Bal.	< 0.25	< 0.40	0.5 – 0.8	2.4 – 2.8	0.05 – 0.20	0.05 – 0.15
Mechanical properties of all-weld metal						
Yield strength R _{p0.2}		Tensile strength R _m		Elongation A (L ₀ =5d ₀)		
MPa		MPa		%		
90		200		17		
Operating data						
		Polarity: DC (+)		Shielding gases: (EN ISO 14175) I1, I3		ø mm 1.0 1.2 1.6
Approvals						
-						