

| Classifications          |           |
|--------------------------|-----------|
| EN ISO 18273             | AWS A5.10 |
| S Al 5556A (AlMg5Mn1(A)) | ER5556A   |

**Characteristics and typical fields of application**

Rod for GTAW of AlMg alloys containing up to 5% Mg. Seawater resistant weld metal. Susceptible to stress corrosion cracking if exposed to service temperatures >65°C. Good colour matching with base metal after anodizing. Thorough cleaning of the workpiece bevels is necessary prior to welding.

**Base materials**

|                         |           |        |
|-------------------------|-----------|--------|
| EN AW-5019 [AlMg5]      | AlMg5     | 3.3555 |
| EN AW-5754 [AlMg3]      | AlMg3     | 3.3535 |
| EN AW-5086 [AlMg4]      | AlMg4Mn   | 3.3545 |
| EN AW-6060 [AlMgSi]     | AlMgSi0,5 | 3.3206 |
| EN AW-6005A [AlSiMg(A)] | AlMgSi0,7 | 3.3210 |
| EN AW-6082 [AlSi1MgMn]  | AlMgSi1   | 3.2315 |
| EN AW-6061 [AlMg1SiCu]  | AlMg1SiCu | 3.3211 |
| EN AW-7020 [AlZn4,5Mg1] | AlZn4,5Mg | 3.4335 |
| EN AC-51300             | G-AlMg5   | 3.3561 |

and similar.

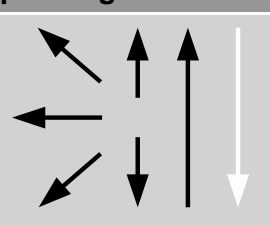
**Typical analysis of TIG rod (wt.-%)**

| Al   | Fe    | Mn        | Mg        | Cr          | Zn     | Ti          |
|------|-------|-----------|-----------|-------------|--------|-------------|
| Bal. | < 0.4 | 0.6 – 1.0 | 5.0 – 5.5 | 0.05 – 0.20 | < 0.20 | 0.05 – 0.20 |

**Mechanical properties of all-weld metal**

| Yield strength<br>R <sub>p0.2</sub> | Tensile strength<br>R <sub>m</sub> | Elongation A (L <sub>0</sub> =5d <sub>0</sub> ) |
|-------------------------------------|------------------------------------|---|
| MPa                                 | MPa                                | %   |
| 125                                 | 275                                | 17  |

**Operating data**

|   |                        |   |  |
|---|------------------------|---|--|
|  | <b>Polarity:</b><br>AC | <b>Shielding gases:</b><br>(EN ISO 14175)<br>I1, I3 | <b>ø mm</b><br>1.6<br>2.0<br>2.4<br>3.2<br>4.0 |
|---|------------------------|---|--|

**Approvals**

CE