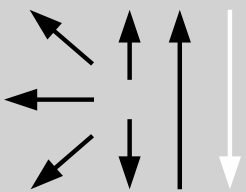


Classifications			
EN ISO 18273-A		AWS A5.10	
S Al Z (AlMg6Zr)		-	
Characteristics and typical fields of application			
<p>Rod for GTAW of AlMg alloys containing up to 5% Mg. Seawater resistant weld metal. Susceptible to stress corrosion cracking if exposed to service temperatures >65°C. Good colour matching with base metal after anodizing. Designed for optimum combination of strength, ductility and corrosion resistance. Thorough cleaning of the workpiece bevels is necessary prior to welding.</p>			
Base materials			
EN AW-5019 [AlMg5]	AlMg5	3.3555	
EN AW-5754 [AlMg3]	AlMg3	3.3535	
EN AW-5454 [AlMg3Mn]	AlMg2,7Mn	3.3537	
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-7020 [AlZn4,5Mg1]	AlZn4,5Mg	3.4335	
EN AC-51300	G-AlMg5	3.3561	
and similar.			
Mechanical properties of all-weld metal			
Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	
MPa	MPa	%	
150	300	23	
Operating data			
	Polarity: AC	Shielding gases: (EN ISO 14175) I1, I3	ø mm
			1.6
			2.0
			2.4
			3.2
4.0			
Approvals			
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