Union AlMg 5 Mn

Solid wire, Aluminium

Classifications

EN ISO 18273-A	AWS A5.10
Al 5556A (AlMg5Mn)	~ER5556

Characteristics and typical fields of application

Solid wire for GMAW of AlMg containing up to 5 % Mg. Seawater resistant weld metal.
Base material should be cleaned near the seam. Pre-heating 150 °C (302°F) for plates > 15 mm

Base materials

EN AW-5019 [AlMg 5]	AlMg5	3.3555
EN AW-5754 [AlMg 3]	AlMg3	3.3535
EN AW-5083 [AlMg 4,5]	AlMg4,5Mn	3.3547
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-5454 [AlMg3Mn]	AlMg2,7Mn	3.3537
EN AW-7020 [AlZn4,5Mg1]	AlZn4,5Mg1	3.4335
EN AC-51300	G-AlMg5	3.3561
EN AC-51400	G-AlMg5Si	3.3261
EN AC-51100	G-AlMg3	3.3541

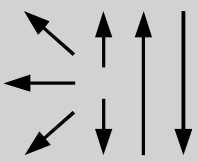
Typical analysis of solid wire (wt.-%)

	Al	Mg	Mn	Cr	Ti
wt.-%	Bal.	4.8 – 5.5	0.6 – 1.0	< 0.2	< 0.20

Mechanical properties of all-weld metal

Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Electrical conductivity
MPa	MPa	%	Sm/mm^2
125	275	17	14 – 19

Operating data



Polarity:	Shielding gases:	ø mm	Spool:	Drum kg
DC (+)	(EN ISO 14175)	0.8	BS300	-
	I1, I3	1.0	BS300	-
		1.2	BS300	80
		1.6	BS300	80

CE