Union AlMg 6 Zr

Solid wire, Aluminium

Classifications	
EN ISO 18273	AWS A5.10
S Al Z (AlMg6Zr)	-

Characteristics and typical fields of application

Solid wire for GMAW 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.

Base materials

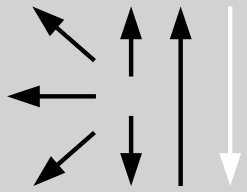
EN AW-5019 [AlMg5]	AlMg5	3.3555
EN AW-5754 [AlMg3]	AlMg3	3.3535
EN AW-5454 [AlMg3Mn]	AlMg2,7Mn	3.3537
EN AW-5086 [AlMg4]	AlMg4Mn	3.3545
EN AW-6060 [AlMgSi]	AlMgSi0,5	3.3206
EN AW-6005A [AlSiMg(A)]	AlMgSi0,7	3.3210
EN AW-6082 [AlSi1MgMn]	AlMgSi1	3.2315
EN AW-7020 [AlZn4,5Mg1]	AlZn4,5Mg	3.4335
EN AC-51300	G-AlMg5	3.3561

and similar.

Typical analysis of solid wire (wt.-%)

Al	Fe	Mn	Mg	Zn	Ti	Zr
Bal.	< 0.2	0.8 – 0.9	5.5 – 6.1	< 0.2	0.02 – 0.20	0.08 – 0.12

Operating data



Polarity:	Shielding gases:	ø mm
DC (+)	(EN ISO 14175)	1.2
	I1, I3	1.6

Approvals

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