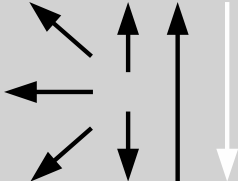


Classifications								
EN ISO 18273				AWS A5.10				
S Al 5754 (AlMg3)				ER5754				
Characteristics and typical fields of application								
Rod for GTAW of AlMg alloys containing up to 3 % Mg. Seawater resistant weld metal. Good colour matching with base metal after anodizing. Thorough cleaning of the workpiece bevels is necessary prior to welding.								
Base materials								
EN AW-5754 [AlMg3]	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-6060 [AlMgSi]	AlMgSi0.5	3.3206						
EN AC-51100	G-AlMg3	3.3541						
	G-AlMgSi	3.3241						
and similar.								
Typical analysis of TIG rod (wt.-%)								
Al	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
Bal.	< 0.40	< 0.40	< 0.10	< 0.50	2.6 – 3.6	< 0.30	< 0.20	< 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			%		
80			190			20		
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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