



# Alutig Mg5

GTAW - TIG  
Aluminium alloys

Date: 2007-10-08  
Revision: 10

## Description:

Aluminium TIG wire containing 5% Magnesium for welding similar composition Al / Mg and Al / Mg / Si materials. The high strength weld metal has very good corrosion resistance in marine environments. Excellent colour match with material to be anodised. The most versatile and universally used aluminium filler material. Melting range 560-630°C.

## Welding current:

AC

## Wire composition, wt.%

	Si	Mn	Cr	Cu	Al	Ti	Zn
Min		0,10	0,05			0,06	
Typical	0,05	0,15	0,10	0,007	bal.	0,12	0,01
Max	0,25	0,20	0,20	0,05	bal.	0,15	0,10

	Mg	Fe
Min	4,5	
Typical	5,0	0,15
Max	5,5	0,40

## Shielding gas:

I1, Argon 5-10 l/min.

I2, Helium 8-16 l/min.

I3, Argon/Helium 5-10 l/min.

## Stamping

Mg5

## Chemical composition, wt.%

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	> 110 MPa	125 MPa
Tensile Strength, Rm:	> 235 MPa	255 MPa
Elongation, A5	> 17%	24%

## Classification:

EN ISO 18273

AWS A5.10

S Al 5356 (AlMg5Cr)

ER 5356

## Approvals:

DB

TÜV

CE

Kennblatt Nr 61.042.04

## Product data

Diam.mm	Length mm	Product code
1,6	1000	9504-1016
2,0	1000	9504-1020
2,4	1000	9504-1024
3,2	1000	9504-1032
4,0	1000	9504-1040
5,0	1000	9504-1050