



Alumig Mg5

GMAW - MIG MAG
Aluminium alloys

Date: 2007-10-08
Revision: 9

Description:

Aluminium MIG 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:

DC+

Wire composition, wt.%

	Si	Mn	Cr	Cu	Al	Ti	Zn
Min		0,1	0,05			0,06	
Typical	0,05	0,15	0,1	0,01	bal.	0,12	0,01
Max	0,25	0,2	0,2	0,05	bal.	0,15	0,1

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

Shielding gas:

- I1, Argon 16-20 l/min.
I2, Helium 16-20 l/min.
I3, Argon/Helium 16-20 l/min.

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 S Al 5356 (AlMg5Cr)
AWS A5.10 ER 5356

Approvals:

TÜV
DNV
DB Kennblatt Nr 61.042.03
CE

Product data

Diam.mm	Product code	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	9504-2008			70-110	18-22
1,0	9504-2010			100-150	18-22
1,2	9504-2012			140-210	19-25
1,6	9504-2016			170-320	20-26
1,2	9504-2512				
0,8	9504-3008				
1,0	9504-3010				
1,2	9504-3012				
1,2	9504-8012				