



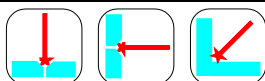
AlMg4.5Mn

AWS A 5.1: ER 5183 ISO 18273: S-AI 5183

DESCRIPTION

For welding aluminium base alloys that require high mechanical properties. Construction, offshore and automotive industry. Very good saltwater resistance.

WELDING POSITIONS



CURRENT

DC (+) Mig
AC Tig

GAS

Ar(11)

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>Hardness</i>
290	140	>26	

WELD METAL COMPOSITION(%)

Mg	Mn	Fe	Cr	Al	Zn	Si	Ti
<5,2	<1,0	0.40	<0,25	rest	0,25	0,4	0,15

PACKAGING & WELDING PARAMETERS

Mig(mm)	0,8	1,0	1,2	1,6
Kg/spool	7	2/7	2/7	7
Ampere(A)	60-120	90-175	120-240	150-300
Tig(mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000
	4,0x1000			
Kg/box	2,5	2,5	2,5	2,5