



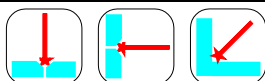
AlMg5

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(l1)

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A₅</i> (%)	<i>Hardness</i>
265	120	>25	70 HB

WELD METAL COMPOSITION(%)

Mg	Mn	Fe	Al	Si	Ti		
5	<0,2	<0.40	rest	<0,25	0,2		

PACKAGING & WELDING PARAMETERS

Mig(mm)	0,8	1,0	1,2	1,6
Kg/spool	0,5/2/7	0,5/2/7	0,5/2/7	7
Ampere(A)	60-120	90-175	120-240	150-300
Volt(V)	13-24	15-26	20-29	25-30
Tig(mm)	1,0x1000	1,6x1000	2,0x1000	2,4x1000
	3,2x1000	4,0x1000		
Kg/box	2,5	2,5	2,5	2,5
Ampere(A)	20-50	25-50	40-75	90-130
	160-240	290-340		