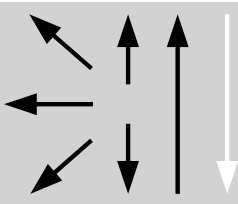


Classifications						
EN ISO 18273			AWS A5.10			
S Al 5183 (AlMg4,5Mn0,7(A))			ER5183			
Characteristics and typical fields of application						
Solid wire for GMAW of AlMg alloys. Seawater resistant weld metal. Good colour matching with base metal after anodizing. Thorough cleaning of the workpiece bevels is necessary prior to welding.						
Base materials						
EN AW-5083 [AlMg4,5Mn0,7]	AlMg4,5Mn	3.3547				
EN AW-5086 [AlMg4]	AlMg4Mn	3.3545				
EN AW-5019 [AlMg5]	AlMg5	3.3555				
EN AW-6060 [AlMgSi]	AlMgSi0,5	3.3206				
EN AW-6005A [AlSiMg(A)]	AlMgSi0,7	3.3210				
EN AW-6082 [AlSi1MgMn]	AlMgSi1	3.2315				
EN AW-6061 [AlMg1SiCu]	AlMg1SiCu	3.3211				
EN AW-7020 [AlZn4,5Mg1]	AlZn4,5Mg	3.4335				
EN AC-51300	G-AlMg5	3.3561				
and similar.						
Typical analysis of solid wire (wt.-%)						
Al	Fe	Mn	Mg	Cr	Zn	Ti
Bal.	< 0.40	0.6 – 1.0	4.3 – 5.2	0.05 – 0.25	< 0.25	< 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		%		
125		275		17		
Operating data						
		Polarity: DC (+)		Shielding gases: (EN ISO 14175) I1, I3		ø mm 1.0 1.2 1.6
Approvals						
TÜV (02195.04), DB (61.132.03), ABS, DNV GL, BV, LR, CE						