

## Classifications

EN ISO 18273-A	AWS A5.10
S Al 5183 (AlMg4,5Mn0,7(A))	ER5183

## Characteristics and typical fields of application

Solid wire for GMAW and GTAW of AlMg alloys. The weld metal is resistant against sea water. Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm

## 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
EN AC-51400	G-AlMg5Si	3.3261

## Typical analysis of solid wire (wt.-%)

	Al	Mg	Mn	Cr	Ti
wt.-%	bal.	4.3 – 5.2	0.6 – 1.0	0.05 – 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	16

## Operating data

	<b>Polarity:</b> DC ( + )	<b>Shielding gases:</b> (EN ISO 14175) I1, I3	<b>∅ mm</b>
			0.8
			1.0
			1.2
			1.6

## Approvals

DB (61.132.03), DNV GL, CE