



# Alutig Mg4.5 Mn

GTAW - TIG  
Aluminium alloys

Date: 2007-10-08  
Revision: 9

## Description:

Aluminium TIG wire containing a nominal 4.9% Magnesium and 0.8% Manganese to produce a higher strength weld metal than the standard 5% Mg alloy.

## Welding current:

AC

## Wire composition, wt.%

	Si	Mn	Cr	Cu	Al	Ti	Zn
Min		0,6	0,05				
Typical	0,08	0,7	0,15	0,03	bal.		0,1
Max	0,25	1,0	0,25	0,05	bal.	0,15	0,25

	Mg	Fe
Min	4,3	
Typical	4,9	0,20
Max	5,2	0,40

## Shielding gas:

I1, Argon 5-10 l/min.

I2, Helium 8-16 l/min.

I3, Argon/Helium 5-10 l/min.

## Stamping

Mg4.5Mn

## Chemical composition, wt.%

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥125 MPa	145 MPa
Tensile Strength, Rm:	≥275 MPa	275 MPa
Elongation, A5	≥17%	24%

## Classification:

EN ISO 18273

AWS A5.10

S Al 5183 (AlMg4.5Mn)

ER 5183

## Approvals:

DB

TÜV

GL

CE

Kennblatt Nr 61.042.02

## Product data

Diam.mm	Length mm	Product code
1,6	1000	9506-1016
2,0	1000	9506-1020
2,4	1000	9506-1024
3,2	1000	9506-1032
4,0	1000	9506-1040