



Alumig Mg4.5 Mn

GMAW - MIG MAG

Aluminium alloys

Date:	2007-10-08
Revision:	10

Description:

Aluminium MIG 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:

DC+

Wire composition, wt.%

	Si	Mn	Cr	Cu	Al	Ti	Zn
Min		0,6	0,05				
Typical	0,08	0,7	0,15	0,02	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	0,2
Max	5,2	0,4

Shielding gas:

I1, Argon 16-20 l/min.

I2, Helium 16-20 l/min.

I3, Argon/Helium 16-20 l/min.

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

Kennblatt Nr 61.042.01

GL

TÜV

DNV

CE

Product data

Diam.mm	Product code	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	9506-2008			70-110	18-22
1,0	9506-2010			100-150	18-22
1,2	9506-2012			140-210	19-25
1,6	9506-2016			170-320	20-26
0,8	9506-3008				
1,0	9506-3010				
1,2	9506-3012				