

Classifications									
EN ISO 18273					AWS A5.10				
S Al 5754 (AlMg3)					ER5754				
Characteristics and typical fields of application									
Solid wire for AlMg alloys containing up to 3 % Mg. Seawater resistant weld metal. Good colour matching with base metal after anodizing. Thorough cleaning of the workpiece bevels is necessary. Thicker plate materials require preheating to 150 °C (302 °F).									
Base materials									
AlMg 3	3.3535	EN AW-5754 [AlMg 3]							
AlMg 2 Mn 0.3	3.3525	EN AW-5251 [AlMg 2]							
AlMg	3.3315	EN AW-500SA [AlMg 1(C)]							
AlMgSi 0.5	3.3206	EN AW-6060 [AlMgSi]							
AlMg 2.7 Mn	3.3537	EN AW-5454 [AlMg 3 Mn]							
G-AlMg 3	3.3541	EN AC-51100							
GAlMg 3 Si	3.3241	-							
Typical analysis of solid wire (wt.-%)									
Al	Mn	Cr	Mg	Ti	Fe	Si	Zn	Cu	
bal.	< 0.5	< 0.3	2.6 - 3.6	< 0.15	< 0.4	< 0.4	< 0.2	< 0.1	
Mechanical properties of all-weld metal									
Yield strength R <sub>p0.2</sub>			Tensile strength R <sub>m</sub>			Elongation A (L <sub>0</sub> =5d <sub>0</sub> )			
MPa			MPa			%			
80			190			20			
Operating data									
	Ø (mm)		Shielding gas:				Polarity:		
	1.0		EN ISO 14175: I1, I3				DC ( + )		
	1.2		Base material should be cleaned near the seam.						
1.6		Pre-heating 150 °C for plates > 15 mm							
Approvals									
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