

## Classifications

EN ISO 18273	AWS A5.10
S Al 5754 (AlMg3)	ER5754

## Characteristics and typical fields of application

Solid wire for GMAW of 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 prior to welding.

## Base materials

EN AW-5754 [AlMg3]	AlMg3	3.3535
EN AW-5454 [AlMg3Mn]	AlMg2,7Mn	3.3537
EN AW-5251 [AlMg2]	AlMg2Mn0,3	3.3523
EN AW-5005A [AlMg1(C)]	AlMg	3.3315
EN AW-6060 [AlMgSi]	AlMgSi0.5	3.3206
EN AC-51100	G-AlMg3	3.3541
	G-AlMg3Si	3.3241

and similar.

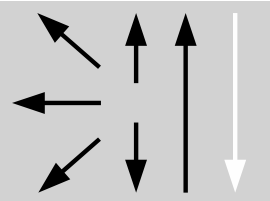
## Typical analysis of solid wire (wt.-%)

Al	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
Bal.	< 0.40	< 0.40	< 0.10	< 0.50	2.6 – 3.6	< 0.30	< 0.20	< 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	%
80	190	20

## Operating data

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

## Approvals

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