



MIG ALG3

Old reference: MIG AlMg3

Classification

ISO 18273 : S Al 5754 (Al Mg3) Material N° : 3.3536
 AWS A5.10 : ~ER5654

Description & Applications

Solid wire for GMAW used to weld Aluminium alloys with up to 3% Mg. Very often used in marine construction for their excellent resistance to salt water corrosion and other types of construction.

Base material:

Alloy	DIN	Material N°.
5005	Al Mg1	3.3315
3303	Al Mg2.5	3.3523
3004	Al Mg3	3.3535
3005	Al Mg Si 0.5	3.3206

Typical Chemical Composition (%)

Si	Fe	Cu	Mn	Mg	Zn	Cr	Ti	Al
0.1	0.2	0.002	0.45	3.2	0.04	0.06	0.07	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
120	250	20

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0	100-150	18-22	Ar/He 18-20 l/min
	1.2	130-200	18-25	
	1.6	170-250	20-27	

Ind.10



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