



MIG ALG4M

Old reference: MIG AlMg4.5Mn

Classification

ISO 18273 : S Al 5183 (AlMg4.5Mn0.7) Material N° : 3.3548
 AWS A5.10 : ER5183

Description & Applications

Solid wire for GMAW used to weld Aluminium-Magnesium alloys of similar composition. The deposit shows superior mechanical resistance compared to Al Mg5 due to the addition of Mn.

Base material:

| Alloy | DIN | Material N°. |
|-------|--------------|--------------|
| 5083 | Al Mg4Mn | 3.3547 |
| 5086 | Al Mg4.5Mn | 3.3545 |
| 5454 | Al ZnMgCu1.5 | 3.4365 |
| 5754 | | |
| 7020 | | |

Typical Chemical Composition (%)

| Si | Fe | Cu | Mn | Mg | Zn | Cr | Ti | Al |
|------|------|------|------|-----|------|-----|------|------|
| 0.05 | 0.15 | 0.01 | 0.65 | 4.8 | 0.02 | 0.1 | 0.12 | Rem. |

All Weld Metal Mechanical Properties

| R _{p0.2} (MPa) | R _m (MPa) | A ₅ (%) |
|---------------------------|------------------------|----------------------|
| 135 | 310 | 30 |

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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