

Classifications

EN ISO 18273-A	AWS A5.10
S Al 5183 (AlMg4,5Mn0,7(A))	ER5183

Characteristics and typical fields of application

TIG-rod for welding of AlMg alloys. The weld metal is resistant against sea water.
Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm

Base materials

EN AW-5083 [AlMg4,5Mn0,7]	AlMg4,5Mn	3.3547
EN AW-5086 [AlMg4]	AlMg4Mn	3.3545
EN AW-5019 [AlMg5]	AlMg5	3.3555
EN AW-6060 [AlMgSi]	AlMgSi0,5	3.3206
EN AW-6005A [AlSiMg(A)]	AlMgSi0,7	3.3210
EN AW-6082 [AlSi1MgMn]	AlMgSi1	3.2315
EN AW-6061 [AlMg1SiCu]	AlMg1SiCu	3.3211
EN AW-7020 [AlZn4,5Mg1]	AlZn4,5Mg	3.4335
EN AC-51300	G-AlMg5	3.3561
EN AC-51400	G-AlMg5Si	3.3261

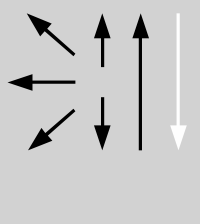
Typical analysis of TIG-rod (wt.-%)

	Al	Mg	Mn	Cr	Ti
wt.-%	bal.	4.3 – 5.2	0.6 – 1.0	0.05 – 0.25	< 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	%
125	275	17

Operating data

	Polarity: AC	Shielding gases: (EN ISO 14175) I1	Marks: ✦3.3548 / AlMg4,5Mn	ø mm 1.6 2.0 2.4 3.2 4.0
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Approvals

TÜV (02196), DB (61.132.03), CE