CEWELD® AlMg 5

CATEGORY	GMAW-GTAW Solid wires
TYPE	Mig filler metal for welding Aluminium Magnesium alloys.
APPLICATIONS	Filler metal for welding Aluminium alloys with maximum 5% Magnesium. This Magnesium alloyed Aluminium wire, thanks to its excellent corrosion resistance and its high mechanical properties is mainly used in ship yards, car and railway industry. Thicker sections should be preheated (150°C) prior to welding.
PROPERTIES	Excellent weldabillity and good mechanical strength combined with good corrosion resistance are typical for this alloy. The weld deposit is free from porosity due to the special shaving process and cleaning method during production. AlMg5 is one of the most popular types within the range of aluminum alloys and covers a weight range of alloys.
CLASSIFICATION	AWS A 5.10: ER5356 EN ISO 18273: S Al 5356 (AlMg5Cr(A)) F-nr 22
SUITABLE FOR	Aluminium alloys: AlMg3, AlMg4, AlMg5, AlMgSi1, AlMgSi0,5,AlMgMn, AlZnMg1, G-AlMg3Si, G-AlMg5Si, G-AlMg10, AlMg1SiCu, AlMgSi0,7, AlZn4,5Mg1, AlSi1MgMn, AlSiMg(A), 3.3545, 3.3206, 3.3210, 3.2315, 3.3211, 3.4335, EN AW 5086, EN AW 6060, EN AW 6005A, EN AW , EN AW 6061, EN AW 7020, EN AC 51400, EN AC 51300, EN AC 51100, EN AW 5454
APPROVALS	CE
WELDING POSITIONS:	

TYPICAL WELD DEPOSIT WEIGHT %

Si	Mn	Cr	Ti	Mg
0.2	0.1	0.1	0.1	5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)
As Welded /	130	300	30

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A) DC+	SPOOL TYPE	KG / SPOOL/ DRUM	KG / PALLET
0.8	14-23	60-160	D-200 / KD-300 / DRUM	2 / 7 / 80	400 / 504 / 320
1.0	15-26	90-210	D-200 / KD-300 / DRUM	2 / 7 / 80	400 / 504 / 320
1.2	20-29	140-260	D-200 / KD-300 / DRUM	2 / 7 / 80	400 / 504 / 320
1.6	25-30	190-350	KD-300 / DRUM	7 / 80	504 / 320

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1, I3