

Standards

Chemical Composition of Weld Metal % (Typical)

EN ISO 18273	: S Al 5183 / AlMg4,5Mn0,7(A)
TS EN ISO 18273	: S Al 5183 / AlMg4,5Mn0,7(A)
AWS A.510	: ER 5183

Fe	Mn	Si	Cr	Mg	Al
0,40	0,80	0,40	0,20	5.00	Rest

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation Lo=5d0- (%)
170	250	20

Typical Base Material Grades

- AlMg 2.7 Mn, AlMg 3, AlMg 4.5 Mn, AlMg 4 Mn, AlMg 5,
- AlMgSi 0.5, AlMgSi, 0.7, AlMgSi 0.8, AlMgSi 1, AlMgSi 1 Cu, AlZn 4.5 Mg 1, AlZnMgCu 1.5,
- G-AlMg 5 Si, G-AlMg 3, G-AlMg 5

Features and Applications

- It is used for joining of Aluminum alloys including more than 3% Mg
- The weld deposit has a good resistance to atmospheric influences and sea water
- Used in storage tanks, columns, and marine applications.
- It is recommended that preheating to 150°C before welding of plates thicker than 10mm.
- In MIG welding, Ar, He, and Ar+He gas mixtures are used as shielding gases.
- In TIG welding, Ar gas is used as the shielding gas.

Welding Positions



Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				
		0.8	0.030"		
		1.0	0.040"		
		1.2	0.047"		
		1.6	0.062"		
		1,60 x 1000	1/16 x 39"		
		2,00 x 1000	5/64 x 39"		
		2,40 x 1000	3/32 x 39"		
		3,20 x 1000	1/8 x 39"		