

**Standards**

TS EN ISO 18273	: S Al 5754 (AlMg3)
EN ISO 18273	: S Al 5754 (AlMg3)
AWS A5.10	: ER 5754

**Chemical Composition of Welding Wire % (Typical)**

Mg	Mn	Si	Fe	Al
3.0	<0.5	<0.40	<0.40	rest

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Working Temperature (°C)
100	200	20	610 - 642

**Typical Base Material Grades**

- AlMg 1, AlMg 2.5, AlMg 3, AlMg 2.7 Mn, AlMg Si 0.5, AlMg 2, AlMg2 Mn 0.8, AlMgSi 0.7, AlMgSi 0.8, G-AlMg 3, G-AlMg3 (Cu), G-AlMg 3 Si.

**Features and Applications**

- It is used for joining aluminum alloys includes up to 3 % Mg. Resistance to sea water. Parent metals AlMg 1, AlMg 2.5, and AlMg 2 Mn 0.8 etc
- Required use of Ar, He or Ar+He gas as shielding gas
- It is recommended that preheating to 150°C before welding of plates thicker than 10mm

**Welding Positions**

**Current Type**

MIG D.C. (+)

**Operating Data**

Product Code	Diameter (mm) / (inch)		Package Weight (Kg)
6011100271	1.20	0.047"	7
6011100272	1.60	0.062"	7