

ROWAC AIMg 3

Solid wire, Aluminium



Classifications

EN ISO 18273	AWS A5.10
S Al 5754 (AlMg3)	ER5754

Characteristics and typical fields of application

Solid wire for AlMg alloys containing up to 3 % Mg. Seawater resistant weld metal. Good colour matching with base metal after anodizing. Thorough cleaning of the workpiece bevels is necessary. Thicker plate materials require preheating to 150 °C (302 °F).

Base materials

AlMg 3	3.3535	EN AW-5754 [AlMg 3]
AlMg 2 Mn 0.3	3.3525	EN AW-5251 [AlMg 2]
AlMg	3.3315	EN AW-500SA [AlMg 1(C)]
AlMgSi 0.5	3.3206	EN AW-6060 [AlMgSi]
AlMg 2.7 Mn	3.3537	EN AW-5454 [AlMg 3 Mn]
G-AlMg 3	3.3541	EN AC-51100
GAlMg 3 Si	3.3241	-

Typical analysis of solid wire (wt.-%)

Al	Mn	Cr	Mg	Ti	Fe	Si	Zn	Cu
bal.	< 0.5	< 0.3	2.6 - 3.6	< 0.15	< 0.4	< 0.4	< 0.2	< 0.1

Mechanical properties of all-weld metal

Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)
MPa	MPa	%
80	190	20

Operating data

	Ø (mm) 1.0 1.2 1.6	Shielding gas: EN ISO 14175: I1, I3 Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm	Polarity: DC (+)
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Approvals

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