



ALUMIG Mg5

GMAW - MIG MAG
Aluminium alloys

Date: 2021-06-08
Revision: 10

Description:

Aluminium MIG wire containing 5% Magnesium for welding similar composition Al-Mg and Al-Mg-Si materials. The high strength weld metal has very good corrosion resistance in marine environments. Excellent colour match with material to be anodised. The most versatile and universally used aluminium filler material. Melting range 560-630°C.

Welding current:

DC+

Wire composition, wt. %

	Si	Mn	Cr	Cu	Al	Ti	Zn
Min		0,1	0,05			0,06	
Typical	0,05	0,15	0,1	0,01	bal.	0,12	0,01
Max	0,25	0,20	0,20	0,05	bal.	0,15	0,10

	Mg	Fe
Min	4,5	
Typical	5,0	0,15
Max	5,5	0,40

Shielding gas:

I1, Argon 16-20 l/min.

I2, Helium 16-20 l/min.

I3, Argon/Helium 16-20 l/min.

Chemical composition, wt. %

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 110 MPa	125 MPa
Tensile Strength, Rm:	≥ 235 MPa	255 MPa
Elongation, A5	≥ 17%	24%

Product data

Diam.mm	Spray Current A	Spray Voltage V
1,0	100-150	18-22
1,2	140-210	19-25
1,6	170-320	20-26

Classification:

EN ISO 18273

AWS A5.10

S Al 5356 (AlMg5Cr)

ER 5356

Approvals:

TÜV

DNV

DB

BV

CE

Kennblatt Nr 61.042.03

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and ITW Welding AB expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the corresponding EN ISO specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by ITW Welding AB.

ITW Welding reserves the right to change specifications or approvals without prior notice.