

ER5183

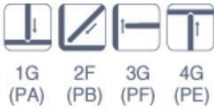
AWS A5.10 ER5183

EN ISO 18273 S Al 5183 (AlMg4.5Mn0.7(A))

Description:

A high magnesium aluminium welding wire is mainly used where higher tensile strength is required. If the tensile strength requirement is 40ksi (276MPa) or higher, used on 5083 or 5654 base metal. Used in marine and low temperature industries, or high strength aluminium structures.

Welding Position:



Diameters:

0.8mm, 0.9mm, 1.0mm, 1.2mm, 1.6mm.

Typical Mechanical Properties:

Tensile strength(MPa):	290
Yield strength(MPa):	140
Elongation(%):	26
Impact values(≥ 47)/+20°C):	--

Typical Chemical Compositon:

Si	Fe	Cu	Mn	Mg
0.1	0.3	0.05	0.6-1.0	4.7-5.2
Cr	Zn	Be	Ti	Al
0.06-0.14	0.10	0.0008	0.02-0.08	Allowance

Welding Current:(AC)

Dia:(mm)	0.8	0.9	1.0	1.2	1.6
Current/A	60-170	60-170	90-210	140-260	190-350
Voltage/V	13-24	13-24	15-26	20-29	25-30

Note:

- 1.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
2. Shield Gas:100%Ar or 75%Ar+25%He or 50%Ar+50%He
3. In order to get good welding bead, weld on thick plate should be preheat 100-200°C before welding.
4. **Tig rods ER5183 1.6mm, 2.0mm, 2.4mm, 3.2mm available**