

ALUFIL Al Mg 4,5 Mn

Drôt pre zváranie TIG/MIG

Welding rod/wire electrode for TIG/MIG-welding process

Pręty/druty do spawania metodami TIG/MIG



Standards:

EN ISO 18273
AWS A5 10

S Al 5183
ER 5183

SK Vlastnosti a použitie:

Pridavný materiál pre zváranie zliatin Hliníka s vysokými nárokmi na pevnosť.

GB Application and properties:

Welding rod or wire electrode for TIG/MIG- welding of Al-alloys with high tensile strength requirements.

POL Zastosowania i własności:

Pręty/druty do spawania TIG/MIG stopów aluminium o wysokich własnościach wytrzymałościowych.

Materials for instance:

No. of Materials	DIN-Designation	No. of Materials	DIN-Designation
3.3555	Al Mg 5	3.3547	Al Mg 4,5 Mn

Approvals:

TÜV, DB, GL, LRS

Rod and wire analysis correspond to all-weld metal analysis (typical values in%):

Mn	Cr	Al	Mg
0,80	0,10	Remainder	4,50

Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	0,2 % Proof stress [N/mm ²]	Tensile strength [N/mm ²]	Elongation A ₅ [%]
AW	≥125	≥275	≥17

AW = as-welded

Analysis and mechanical properties apply to the use of shielding gas:

DIN EN 439 - I1 in TIG – welding
DIN EN 439 - I1 in MIG – welding

Shielding gas acc. to DIN EN 439:

Welding rod for TIG-welding:

I1 (ARCAL 1)

Wire electrode for MIG-welding:

I1(ARCAL 1), I2 (Helium R), I3 (ARCAL 31)

Consumption:

TIG = 10 l/min, MIG = 12 l/min

Form of delivery:

Welding rods					
Dia. [mm]	1,6	2,0	2,4	3,2	4,0
Length [mm]	1000				
Approx. weight of packet [kgs]	10				

Wire electrodes				
Dia. [mm]	0,8	1,0	1,2	1,6
Wire cage reel K300 [kgs]	7			

Further forms of delivery on request.

Type of current/Polarity/Welding positions:

