

ALUFIL Al Mg 5

Drôt pre zváranie TIG/MIG

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

Pręty/druty spawalnicze do spawania metodami TIG/MIG



Standards:

EN ISO 18273

AWS/ASME SFA-5.10

Comparable No. of Materials:

S Al 5356

ER 5356

3.3556

SK Vlastnosti a použitie:

Prídavný materiál pre zváranie zliatin AlMg a AlMgSi.

GB Application and properties:

Welding rod or wire electrode for TIG/MIG-welding of AL Mg-and Al Mg Si- alloys.

POL Zastosowania i własności:

Pręty/druty spawalnicze do spawania TIG/MIG stopów Al-Mg oraz Al-Mg-Si.

Materials for instance:

No. of Materials	DIN-Designation	No. of Materials	DIN-Designation
3.3535	Al Mg 3	3.3555	Al Mg 5

Approvals:

TÜV, DB, ÖBB, LRS

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

Mn	Cr	Al	Mg
0,10	0,10	Remainder	5,00

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	≥110	≥240	≥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:

