

## AlMg 3

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Mig filler metal for welding Aluminium Magnesium alloys.

**APPLICATIONS** Suitable for base metals with maximum 3% Mg. These alloys are suitable for a big range of applications in the construction sector, in general, and in the structural industry. Widely used in ship and vessel building.

**PROPERTIES** This alloy offers excellent weldability when properly cleaned prior to welding. Heavy parts and thicker plates should be preheated (150°C), prior to welding. The alloy shows good corrosion-resistance and an excellent colour-uniformity after anodizing. AlMg3 offers also good resistance against seawater.

**CLASSIFICATION**

AWS	A 5.10: ER 5654
EN ISO	18273: S Al 5754-AlMg3
DIN: W.Nr.	3.3536
DIN	1732: SG-AlMg3

**SUITABLE FOR** Aluminium alloys: AlMg Mn, AlMg 3Mn, AlMg1, AlMg2, AlMg2,7Mn, AlMg3, AlMg3,5, AlMgSi0,5, AlMgSi0,8, G-AlMg3Si, 3.3315, 3.3535, 3.3206, 3.3541, EN AW 5005A, EN AW 5754, EN AW 6060, EN AC 51100, EN AW 5454, EN AW 5251,

**APPROVALS** CE approved

**WELDING POSITIONS:**



**ALL WELD DEPOSIT (WEIGHT %)**

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

**MECHANICAL PROPERTIES**

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	>80	>190	>20				

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / drum	kg / pallet
0.8	14-23	60-160	D-100 / D-200 / KD-300	0.5 / 2.0 / 7.0	
1.0	15-26	90-210	D-100 / D-200 / KD-300 / drum	0.5 / 2.0 / 7.0 / 80	
1.2	20-29	140-260	D-100 / D-200 / KD-300 / drum	0.5 / 2.0 / 7.0 / 80	
1.6	25-30	190-350	D-200 / KD-300 / drum	2.0 / 7.0 / 80	

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I1, I3