



MIG ALG3

Old reference: MIG AlMg3

Classification

AWS 5.10 : ER5754

ISO 18273 : S Al 5754 (AlMg3)

Description & Applications

Solid wire for GMAW of aluminium-magnesium alloys with up to 3% Mg or heterogeneous assemblies. Excellent resistance to salt water corrosion and other types of construction.

Main applications: Ship building, shipyard installations.

Base materials:

Alloy	DIN	Material N°
3004	Al Mg1	3.3315
3005	Al Mg2.5	3.3523
3303	Al Mg3	3.3535
5005	Al Mg Si0.5	3.3206

Typical Chemical Composition (%)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Be	O/E	O/T	Al
Min					2.6							
Max	0.40	0.40	0.10	0.50	3.6	0.30	0.20	0.15	0.0003	0.05	0.15	Rem.
Type	0.05	0.13	0.15	0.20	3.1	0.10	0.01	0.08	0.0001	<0.05	<0.15	Rem.

$0.10 < Mn + Cr < 0.6$

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
Min	-	-	-
Max	-	-	-
Type	120	250	22

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = + / Pulsed	1.0	100-150	18-22	ISO 14175: I1 (100% Ar) I3 (Ar+ 5-30%He) 15-20L/min
	1.2	130-200	18-25	
	1.6	170-260	20-27	

FT En-ML04-200210

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Fumes: Consult information on MSDS, available upon request.

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