



# MIG ALG4M

Old reference: MIG AlMg4.5Mn

## Classification

AWS A5.10 : ER5183

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

## Description & Applications

Solid wire for GMAW of Aluminium-Magnesium alloys of similar composition. The deposit shows superior mechanical resistance compared to AlMg5 standard grade due to the addition of Mn (0.7%).

**Main applications:** Ship building, wagons building, tanks and trailers manufacturing.

**Base materials:**

Alloys	DIN
5083	AlMg4.5Mn
5086	AlMg4Mn
5454	AlMg3Mn
5754	AlMg3
7020	AlZn4.5Mg1

## Typical Chemical Composition ( % )

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Be	O/E	O/T	Al
Min				0.50	4.3	0.05						
Max	0.40	0.40	0.10	1.0	5.2	0.25	0.25	0.15	0.0003	0.05	0.15	Rem.
Type	0.10	0.15	0.01	0.70	4.8	0.10	0.02	0.10	0.0001	<0.05	<0.15	Rem.

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
Min	-	-	-
Max			
Type	140	285	30

## 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	

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**Fumes:** Consult information on MSDS, available upon request.

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