



CEWELD AlMg 4.5MnZr

| TYPE | Mig filler metal for welding Aluminium Magnesium alloys | | | | | | | | | | | | |
|--|--|----------------------|-------------------------|----------------------|-----------------------------------|----------|-----------|------|-----|------|------|-----|------|
| TOEPASSINGEN | Construction of ships, off-shore, storage tanks, railways and automotive industry. | | | | | | | | | | | | |
| EIGENSCHAPPEN | Special alloy for welding aluminium-magnesium basis alloys with maximum 5% Mg. Zirconium acts as grain-refiner to improve both the bending and the corrosion resistance. Applications in the construction of ships, off-shore, storage tanks, railways and automotive industry. | | | | | | | | | | | | |
| CLASSIFICATIE | <table border="0"> <tr> <td>AWS</td> <td>A 5.10: ER5087</td> </tr> <tr> <td>EN ISO</td> <td>18273: S Al 5087 (AlMg4,5MnZr(A))</td> </tr> <tr> <td>W.Nr.</td> <td>3.3546</td> </tr> <tr> <td>F-nr</td> <td>22</td> </tr> </table> | AWS | A 5.10: ER5087 | EN ISO | 18273: S Al 5087 (AlMg4,5MnZr(A)) | W.Nr. | 3.3546 | F-nr | 22 | | | | |
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| EN ISO | 18273: S Al 5087 (AlMg4,5MnZr(A)) | | | | | | | | | | | | |
| W.Nr. | 3.3546 | | | | | | | | | | | | |
| F-nr | 22 | | | | | | | | | | | | |
| GESCHIKT VOOR | <p>Aluminium alloys:</p> <p>AlMg4,5Mn, AlZnMgCu1,5, AlMg5, AlMg3, AlMg5, AlMg2Mn0.8, AlMg2,7Mn, AlZn4,5Mg1, AlZnMg4,5Mn, AlZn5,5Mg1, AlZn5,5Mg1,5, G-AlMg3Si, G-AlMg5Si, G-AlMg10, G-AlMgSi1, AlMgSiCu 3.3535, 3.3547, 3.3555, ~3.1325, ~3.2315, ~3.4335</p> <p>EN AW 5086, EN AW 6060, EN AW 6005A, EN AW , EN AW 6061, EN AW 7020, EN AW 7021, EN AC 51400, EN AC 51300, EN AC 51100, EN AW 5454</p> | | | | | | | | | | | | |
| GOEDKEURINGEN | CE | | | | | | | | | | | | |
| LASPOSITIES | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1"> <thead> <tr> <th>Mn</th> <th>Cr</th> <th>Ti</th> <th>Al</th> <th>Mg</th> <th>Zr</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>0.1</td> <td>0.15</td> <td>Rem.</td> <td>4.5</td> <td>0.15</td> </tr> </tbody> </table> | Mn | Cr | Ti | Al | Mg | Zr | 1 | 0.1 | 0.15 | Rem. | 4.5 | 0.15 |
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| 1 | 0.1 | 0.15 | Rem. | 4.5 | 0.15 | | | | | | | | |
| MECHANISCHE WAARDEN | <table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{P0.2} (MPa)</th> <th>R_m (MPa)</th> <th>A₅ (%)</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>140</td> <td>300</td> <td>20</td> <td>HRc</td> </tr> </tbody> </table> | Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness | As Welded | 140 | 300 | 20 | HRc | | |
| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness | | | | | | | | | |
| As Welded | 140 | 300 | 20 | HRc | | | | | | | | | |
| HERDROGEN | Not required | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | I1, I3 | | | | | | | | | | | | |