

AX-AIMg 5

3.3556

Aluminium-magnesium alloyed filler wire for TIG and MIG welding of AlMg alloys

Standard designation

DIN 1732	SG AlMg 5
Material No.	3.3556
AWS/ASME SFA - 5.10	similar to ER 5356
B. S. 2901, part 4	ähnlich 5056 A

Chemical composition in % (limits)

Al	Mg	Mn	Cr	Ti
Basis	5	0.35	0.1	0.15

Special instructions

Large work pieces and sheets thicker than 15 mm should be preheated to 150°C.

Main applications

Aluminium-Magnesium alloys,
e.g. AlMg 1 (3.3315), AlMg 3 (3.3535) AlMg 5 (3.3555), AlMgSi 1 (3.2315)

Physical properties (standard values)

Electrical conductivity at 20° C [S · m/mm ²]	Heat conductivity at 20° C [W/(m · K)]	Coefficient of linear heat expansion (20-300°C) [1/K]
15 – 19	110 – 150	23,7 · 10 ⁻⁶

Mechanical properties, all-weld metal (standard values)

Welding process: Shielding gas: Heat treatment: Temperature controlled at:		[°C]	TIG Argon without +20°C	MIG Argon without +20°C
Yield strength Rp 0.2 %	[N/mm ²]		110	110
Tensile strength Rm	[N/mm ²]		250	250
Elongation A5	[%]		25	25

Shielding gas to be used

Argon

Approvals

(details available upon request)

TIG rods

Diameter (mm): 1.6 2.0 2.4 3.2 4.0 5.0
Straight lengths of 1000 mm

MIG wire

Diameter (mm) 0.8 1.0 1.2 1.6 2.4

