

## Aluminium wire

### Classification

ISO 18273 :S Al 5754 (AlMg3)

### General Description

Solid wire for welding of aluminium alloys up to 3%Mg

### Shielding gas (acc. EN)

GTAW	I1	Inert gas Ar 100%
GMAW	I1	Inert gas Ar 100%
	I3	Inert gas Ar + > 0-95% He

### Chemical composition (w%), typical, all weld metal

Al	Mg	Zn	Cr	Ti	Mn	Si	Cu	Fe
rest	3.4	0.1	0.19	0.09	0.01	0.06	0.01	0.13

### Mechanical properties, all weld metal

	Process	Shielding gas	Condition	0.2% Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact (ISO), J		Hardness HB
							+20 °C	-196 °C	
Typical values	GTAW	I1	AW	100	220	33	35	20	
after welding	GMAW	I1	AW	100	210	30	35	30	

### Physical properties

Melting range 580-642°C

Density approximately 2660 kg/m<sup>3</sup>

### Materials to be welded

Material	Code	Type	W.Nr.	Int.Reg.Nr.	Int.Cast.Nr.
Aluminium wrought alloys	DIN 1725-1	Al Mg 1	3.3315	5005A	
		Al Mg 1.5	3.3316	5050B	
		Al Mg 1.8	3.3326	5051A	
		Al Mg 2.5	3.3523	5052	
		Al Mg 3	3.3535	5754	
		Al Mg 1	3.0515	3103	
		Al Mg Si 0.5	3.3206	6060	
		Al Mg Si 0.7	3.3210	6005A	
		Al Mg Si 0.8	3.2316	6181	
		Aluminium cast alloys	DIN 1725-2	G-AlMg 3	3.3541
G-AlMg 3 Si	3.3241				512.0

### Packaging, available sizes and identification

Process	Unit:	Sizes, mm							
		1.0	1.2	1.6	2.0	2.4	3.2	4.0	5.0
GTAW	5 kg tube				X	X	X	X	
GMAW	7 kg spool S300	X	X	X					

Other sizes and packaging on request

Identification

Imprint: Reval® AlMg3

Tip colour:

Reval® AlMg3 : rev.EN 20