

MT-AIMg 5

3.3556

Aluminium-magnesium alloyed MIG/TIG wire for welding AlMg alloys.

Standard designation

DIN 1732	SG AlMg 5
Material No.	3.3556
WAS/ASME SFA-5.10	similar to. ER 5356
B.S.2901, part 4	similar to. 5056 A
EN ISO 18273	S Al 5356 AlMg5Cr(A)

Main base metals

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

Physical properties (typical values)

El.conductivity at 20°C [S · m/mm ²]	Thermal conductivity at 20°C [W/(m · K)]	Linear thermal expansions coefficient (20-100°C) [1/K]
15-19	110-150	23,7 · 10 ⁻⁶

Mechanical properties of all – weld – metal (typical values)

Welding process Gas shield Thermal treatment Test temperature		[°C]	TIG welding argon untreated +20°C	MIG welding argon untreated +20°C
0,2%-yield strength	R _{p0,2}	[N/mm ²]	110	110
Tensile strength	R _m	[N/mm ²]	250	250
Elongation	A ₅	[%]	25	25

Average chemical composition of all-weld-metal (%)

Al	Mg	Mn	Cr	Ti
Basis	5	0,35	0,1	0,15

Application notes

For larger work pieces and thicker sections than 15 mm preheat to 150 °C.

Gas types applicable (TIG and MIG)

Welding argon

Approvals

TÜV, DB, UDT

TIG rod diameters, unit weights

Diameter [mm]	Length [mm]	Kg per box
1,6	1000	10
2,0	1000	10
2,4	1000	10
3,2	1000	10
4,0	1000	10
5,0	1000	10

MIG welding wire

Diameter 0,8mm 1,0mm 1,2mm 1,6mm 2,4 mm

TIG ~

MIG = +