

## MT-AIMg 3

## 3.3536

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

### Standard designation

DIN 1732	SG - AlMg 3
Material No.	3.3536
WAS/ASME SFA-5.10	similar to. ER 5754
B.S.2901, part 4	similar to. 5754
EN ISO 18273	AW 5754

### Main base metals

Aluminium-magnesium alloys  
e.g. AlMg 1,8 (3.3326), AlMg 3 (3.3535), sowie AlMn 1 (3.0515)

### Physical properties (typical values)

El.conductivity at 20°C [S · m/mm <sup>2</sup> ]	Thermal conductivity at 20°C [W/(m · K)]	Linear thermal expansion coefficient (20-100°C) [1/K]
20-23	130-170	23,7 · 10 <sup>-6</sup>

### 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 <sub>p0,2</sub>	[N/mm <sup>2</sup> ]	80	80
Tensile strength	R <sub>m</sub>	[N/mm <sup>2</sup> ]	200	200
Elongation	A <sub>5</sub>	[%]	20	20

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

Al	Mg	Mn	Cr	Ti
Basic	3	0,3	0,1	0,13

### Application notes

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

### Gas types applicable (TIG and MIG)

Welding argon

### 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 = +**