

CARBO S- AIMg 5

CARBO T- AIMg 5

| | S = massive wire | T = bare rod |
|--------------------------------|--------------------|-------------------|
| International standards | DIN 1732 | SG AIMg 5 |
| | Material Nr. | 3.3556 |
| | AWS/ASME SFA –5.10 | similarly ER 5356 |
| | B.S.2901, part 4 | similarly 5056 A |

Approvals --- ---

Application notes Massive rod or wire for welding AIMg alloys
Preheat the welding area of massive work-pieces to 150° C.

Selector Guide AIMg 1 (3.3315) AIMg 5 (3.3555)
AIMg 3 (3.3535) AIMgSi 1 (3.2315)

| Mechanical properties of all-weld-metal | Tensile strength | Yielding strength | Elongation | Impact Energy | Hardness |
|--|----------------------------------|-------------------------------------|------------------|---------------|----------|
| | R _m N/mm ² | R _{p0,2} N/mm ² | A ₅ % | J | HB |
| (typical values) | 250 | 110 | 25 | 70 | 140 |

| Weld metal analysis | Al | Fe | Mn | Ni | Cu |
|----------------------------|----|----|-----|-----|-----|
| (typical, wt. %) | 8 | 2 | 2,2 | 2,2 | bal |

| Gas types EN 439 | S = massive wire | | | | | T = bare rod | | | | |
|-------------------------|------------------|-----|-----|-----|--|----------------|-----|-----|-----|-----|
| | I1 | | | | | I1 | | | | |
| Current | = + | | | | | = - | | | | |
| Diameter mm | 0,8 | 1,0 | 1,2 | 1,6 | | 1,6 | 2,0 | 2,4 | 3,2 | 4,0 |
| Welding amps (A) min. | | | | | | | | | | |
| (A) max. | | | | | | | | | | |
| coils, weight | K300 15 kg. | | | | | 10 kg./ carton | | | | |

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