

## Description

Continuous solid wire suitable for welding aluminium alloys with up to 5% Mg and alloys where a higher tensile strength is required. The alloying element Zr produces improved resistance to hot cracking during solidification.

## Welding current

DC(+)

## Classifications

EN ISO 18273 S Al 5087 (AlMg4.5MnZr)

## Wire composition

Si	Mn	Cr	Cu	Ti	Zr	Zn	Fe	Mg
<0.25	0.9	0.15	<0.05	<0.15	0.15	<0.25	<0.40	4.9

## Typical mech. properties all weld metal

Yield stress, MPa	130
Tensile strength, MPa	280
Elongation, %	30

## Approvals

DB	61.039.07
Ü	61.039
VdTÜV	

## Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
1.0	7-14	90-210	15-26	0.9-1.8
1.2	6-13	140-260	20-29	1.1-2.4
1.6	4.5-7.5	190-350	25-30	1.5-2.5