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## REASON FOR ISSUE

Classification and mechanical data update.

## GENERAL

Bare welding rod suitable for welding of aluminium alloys with up to 5 % Mg and alloys where a higher tensile strength is required. The alloying element Zr gives improved properties against hot cracking during solidification.

**Shielding Gas:** I1, I2, I3 (EN ISO 14175)

**Alloy Type:** AlMgMn

## CLASSIFICATIONS Wire Electrode

SFA/AWS A5.10 R5087  
EN ISO 18273 S Al 5087 (AlMg4,5MnZr)

## APPROVALS

CE EN 13479  
DB 61.039.08  
VdTÜV 05796

## CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
Si		0.25
Mn	0.7	1.1
Cr	0.05	0.25
Cu		0.05
Al		
Ti		0.15
Zr	0.10	0.20
Zn		0.25
Fe		0.40
Be		0.0003
Mg	4.5	5.2
Other each		0.05
Others tot		0.15

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	Typ
Rp0.2 (MPa)		130
Rm (MPa)		280
A4-A5 (%)		30

## Comments:

THIS INFORMATION IS BASED ON DATA DEVELOPED UNDER LABORATORY CONDITIONS AND IS DESIGNED AS A GUIDELINE ONLY. INDIVIDUAL CONDITIONS, WELDING EQUIPMENT AND ENVIRONMENT CAN AFFECT RESULTS.

## OTHER DATA

Preheating: is not required for welds in sections up to 20 mm but risk of porosity can be reduced by preheating sections over 10 mm. Preheating temperature is usually 150-200 °C.

Clean material is essential for a good weld quality. Remove oxide, dirt, oil, humidity etc. before welding. If brushing use a stainless steel wire brush.