

CARBO S- AIMg 5

CARBO T- AIMg 5

	S = solid wire	T = bare rod
International standards	DIN 1732	SG AIMg 5
	Material N.	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/mm²	R_{p0,2} N/mm²	A₅ %	J	HB
(typical values)	250	110	25	70	140

Physical properties (typical values at 20°C)	Electric conductivity	Thermal conductivity	Linear thermal expansion
	S ≥m/mm²	W/(m≥K)	coefficient [1/K]
	15-19	110-150	23.7 ≥10 ⁻⁶

Weld metal analysis (typical, wt. %)	Al	Mg	Mn	Cr	Ti
		basic	5	0,35	0,1

Gas types EN 439	S = solid 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 7 kg. 10 kg./ carton

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Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.