CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO S- AlMg 4,5 Mn
CARBO T- AlMg 4,5 Mn

International standards

S = solid wire	T = bare rod
DIN 1732	SG AlMg 4,5 Mn
Material No.	3.3548
AWS A 5.10	ER 5183

Approvals --- ---

Application notes Aluminium.Magnesium alloy welding wire for GMA (MIG) welding of similar alloys and also for age hardenable Al-alloys.

Selector Guide AlMg 3 (3.3535); AlMg4,5Mn (3.3547), AlMg5; (3.3555); AlCuMg1 (3.1325); AlMgSi1 (3.2315); AlZn4,5Mg1 (3.4335)

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R_m N/mm²	Yield strength $R_{p0,2}$ N/mm²	Elongation A_5 %
>275	>125	>17

Physical properties
(typical values at 20°C)

Electric conductivity S ≥m/mm²	Thermal conductivity W/(m≥K)	Linear thermal expansion coefficient [1/K]
16-19	110-120	23.7 $\geq 10^{-6}$

Weld metal analysis
(typical, wt. %)

Al	Mn	Mg	Cr	Ti
bas.	0,8	4,9	0,15	0,15

		S = solid wire				T = bare rod				
Gas types EN 439				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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