



PRODUCT DATA SHEET

SOLID MIG WIRES - ALUMINIUM

WCD 6415

AUSTMIG 5183



SUMMARY

- > Aluminium-Magnesium-Manganese, Metal Inert Gas (MIG) Welding Wire
- > Precision Layer Wound and Double Shaved for Superb Feedability
- > For Welding of Alloys of the same Composition

CLASSIFICATION

- > AS/NZS ISO 18273 - S Al 5183
- > AWS A5.10: E5183

DESCRIPTION AND APPLICATION

Austmig 5183 is a precision layer wound aluminium wire alloyed with Mg, Mn and Cr.

It is recommended for welding Al/Mg material of the 5083 type in the annealed condition, particularly for low temperature applications where good ductility and toughness are required, ie cryogenic plant. It may also be used for welding medium strength Al/Zn/Mg alloys of the 7020 type and joining 5083 alloy to 5456 alloy.

Welding grade Argon or Argon/Helium shielding gas combinations are recommended with flow rates of 10-20 litres/minute.

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	150 - 250	20 - 27
1.6	200 - 350	23 - 30

Welding Current DC +

*Voltage is determined by arc current and electrode arc length.

Welding currents and voltage shown are operational guides only.

SHIPPING APPROVAL

LR WC/1-1S **ABS** AWS A5. 10-92/ER5183 **DNV** 5183

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

Si	Fe	Cu	Mn	Mg
0.4	0.4	0.1	0.5 - 1.0	4.3 - 5.2
Cr	Zn	Ti	Al	
0.05 - 0.25	0.25	0.15	Bal	

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	Ar
Yield Strength	110 MPa
Tensile Strength	240 MPa
Elongation	17%

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.2	6kg spool	M518312S
1.6	6kg spool	M518316S

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