

greenTECH NMA 5754

ISO OERLIKON AG Schweisstechnik

CH-5737 Menziken AG – Tel. +41 (0)62 771 83 05

E-Mail info@iso-oerlikon.ch – www.iso-oerlikon.ch

Comparable specifications

ASME SFA- 5.10: ER5754

EN ISO 18273: S Al 5754 (AlMg3)

Werkstoff Nr.: 3. 3536

Description and applications*

* Illustrative, not-exhaustive list

Aluminum alloy filler metal with maximum 3% Mg, characterized by corrosion-resistance and outstanding colour-uniformity after anodizing. Unlike other alloys with Mg > 3.5%, this alloy is resistant to intergranular corrosion and stress corrosion cracking after exposure to elevated temperatures (over 65°C).

The weld metal is seawater-resistant.

Most common applications of this alloy includes welding of aluminium alloys up to 3% Mg in:

- the general construction sector and in the structural industry;
- automotive components;
- storage tanks;
- ship building;
- etc.

Weldable base materials*

* Illustrative, not-exhaustive list

AlMg1, AlMg2, AlMg3, AlMg3.5, AlMgMn, AlMg2Mn0.3, AlMgSi0.5, AlMgSi0.8, AlMg2.7Mn, etc.

All-weld metal mech. properties*

* For reference only values

Tensile strength (Rm): $\geq 190 \text{ N/mm}^2$ **Yield Strength (Rp_{0.2}):** $\geq 80 \text{ N/mm}^2$
Elongation: $\geq 20\%$

Chemical composition*

* For reference only values

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Be
max	max	max	max	2.60	max	max	max	max
0.40	0.40	0.10	0.50	3.60	0.30	0.20	0.15	0.0003

Standard packaging data*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	7 (33)	n.a.
GTAW **	filler rod	1.60 - 4.00 (1/16 - 5/32)	cardboard boxes / tubes	5 (11)	1000 (39.4)

* Other sizes and packing types are available upon request

** GMAW: gas metal arc welding; GTAW: gas tungsten arc welding

Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

 marking type-testing performed and available.

Customized labels are available upon request.

Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.