

AUTOCRAFT AL5183XP


- ▲ For GMAW welding of wrought and cast aluminium alloys containing magnesium.
- ▲ Superior surface cleanliness for improved resistance to porosity.

Classifications:

AS/NZS ISO 18273: S Al 5183
 AWS/ASME-SFA A5.10: ER5183

Description and Applications:

Autocraft AL5183XP is a premium quality Aluminium welding wire that is typically used in the marine and structured industries, where higher strength and good fracture toughness is required. Autocraft AL5183XP is ideally suited to the welding of Alloy 5083. Autocraft AL5183XP is not suitable for heat treatment.

APPROVALS:

DNV Grade ER5183

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Single-vee butt weld with 5083 Aluminium
 Welding grade Argon:

0.2% Proof Stress	125 MPa
Tensile Strength	300 MPa
Elongation (in 2 inches)	17%

WIRE ANALYSIS LIMITS:

Single values are maximum unless otherwise stated.

Si: 0.1%	Fe: 0.2%	Cu: 0.05%
Mn: 0.5-0.8%	Mg: 4.3-5.2%	Cr: 0.05-0.2%
Zn: 0.05%	Be: 0.0003%	Ti: 0.15%
Total others: 0.15%	Other Ea: 0.05%	Al: Balance

RECOMMENDED* SHIELDING GAS:

AS 4882:	ISO 14175 / AWS A5.32:
SG-A	I1*- Cert supplied
SG-AHe-25	I3
SG-HeA-25	I3
Welding grade Ar or Ar+He (25%) or He+Ar(25%)	

Packaging and Operating Data:

These machine settings are a guide only. Actual voltage and welding current used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc. For 5XXX type welding wires use welding current settings on the higher side of the range specified below and arc voltages on the lower side of the range. For 1XXX, 2XXX and 4XXX type welding wires use welding current settings on the lower side of the specified range and arc voltages on the higher side.

Wire Diameter mm	Voltage Range (volts)	Wire Feed Speed (meters/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
1.2	20-25	5.5-12.0	150-250	Spool	7kg	722245

* Spool (ø300mm).