

ALUFIL AlMg4.5MnZr is a 5087 type aluminum solid MIG welding wire, supplied precision layer wound, depositing Al-4.5Mg0.8Mn0.1Zr weld metal. Suitable for use with Ar, or Ar+He mixed shielding gases.

ALUFIL AlMg4.5MnZr is suitable for welding of 3-5% Mg-content aluminum.

Due to the Zirconium alloying the weld metal has a very good hot cracking resistance. Zr promotes grain refinement and increases the mechanical properties and corrosion characteristics.

For special request ALUFIL AlMg4.5MnZr is available with GL (Germanischer Lloyd) and LRS (Lloyd's Register) approvals.

Classification	Approvals	Grade
EN ISO 18273: S Al 5087 (AlMg4.5MnZr)	DB	●
	TÜV	●

Chemical analysis (Typical values in %)

Al	Si	Mn	Mg	Cr	Zr	Ti	Cu	Fe
Rem	0.2	0.9	4.5	0.1	0.15	0.1	0.02	0.1

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
As Welded	≥125	≥275	≥17


Gas test: 70% Ar+30% He

Shielding Gas - EN ISO 14175 : I1, I3

Materials

AlMg3, AlMg5, AlMgMn, AlZn4.5Mg1, AlZnMg4.5Mn, AlMgSiCu

G-AlMg 3 Si, G-AlMg 5 Si, G-AlMg 10

Storage	Current condition and welding position
Keep dry and avoid condensation.	DC+
	

Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	7
1.0	W000283210
1.2	W000283211
1.6	W000283212