



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod 5754

Prepared by Mats Linde	Qualified by Tero Tolonen	Approved by Michael Spieß	Reg no EN006182	Cancelling EN005073	Reg date 2013-08-29	Page 1 (2)
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REASON FOR ISSUE

Classification and mechanical update.

GENERAL

OK Autrod 5754 is a solid aluminium wire with a content of 3 % Mg. It is recommended for welding of Al-Mg alloys with less than 3 % magnesium. The alloy has a relatively high strength and corrosion resistance.

Shielding Gas: I1, I2, I3 (EN ISO 14175)

Alloy Type: AlMg

CLASSIFICATIONS Wire Electrode

SFA/AWS A5.10 ER5754
EN ISO 18273 S Al 5754 (AlMg3)

APPROVALS

VdTÜV 04758

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
Si		0.40
Mn		0.50
Cr		0.30
Cu		0.10
Al		
Ti		0.15
Zn		0.20
Fe		0.40
Be		0.0003
Mg		3.6
Mn+Cr	2.6	0.60
Other each	0.10	0.05
Others tot		0.15

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded	
	Typ	
Rp0.2 (MPa)	110	
Rm (MPa)	230	
A4-A5 (%)	23	

Comments:

THIS INFORMATION IS BASED ON DATA DEVELOPED UNDER LABORATORY CONDITIONS AND IS DESIGNED AS A GUIDELINE ONLY. INDIVIDUAL CONDITIONS, WELDING EQUIPMENT AND ENVIRONMENT CAN AFFECT RESULTS.



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W Nom	η Nom	H		Feed		U	
	Min	Max			Min	Max	Min	Max	Min	Max
0.8	60	170	15						13	24
0.9	60	170	15						13	24
1.0	90	210	16						15	26
1.2	140	260	19						20	29
1.6	190	350	25						25	30

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)

OTHER DATA

Preheating: is not required for welds in sections up to 20 mm but risk of porosity can be reduced by preheating sections over 10 mm. Preheating temperature is usually 150-200 °C.

Clean material is essential for a good weld quality. Remove oxide, dirt, oil, humidity etc. before welding. If brushing use a stainless steel wire brush.
