



Signed by Mats Linde	Approved by Per-Åke Pettersson/Christos Skodras	Reg no EN005072	Cancelling EN002650	Reg date 2009-11-27	Page 1 (1)
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REASON FOR ISSUE

Shielding Gas standard up date.

GENERAL

OK Tigrod 5754 is a solid aluminium rod 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, I3 (EN ISO 14175)

Alloy Type: AlMg

CLASSIFICATIONS Wire Electrode

EN ISO 18273 S Al 5754 (AlMg3)

APPROVALS

VdTÜV 04759

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
Si		0.25
Mn		0.50
Cr		0.30
Cu		0.05
Al		
Ti		0.15
Zn		0.20
Fe		0.40
Be		0.0003
Mg	2.6	3.6
Mn+Cr	0.10	0.60
Other each		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	

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.