



## Aluminium Alloy 5183

### ● TYPICAL CHARPY V-NOTCH PROPERTIES

Conditional Statement : As Welded

Testing Temperature : 68 °F

Impact Value : 66 ft-lb

Testing Temperature : 20 °C

Impact Value : 90 J

### ● RECOMMENDED WELDING PARAMETERS

Current	Voltage	Wire Diameter
140-260 A	20-29 V	1.2 mm (0.047 in.)
180-210 A	22-26 V	1.2 mm (0.047 in.)
125-150 A	20-24 V	1.2 mm (0.047 in.)
170-240 A	24-28 V	1.2 mm (0.047 in.)
190-350 A	25-30 V	1.6 mm (1/16 in.)
240-300 A	22-27 V	1.6 mm (1/16 in.)
190-260 A	21-26 V	1.6 mm (1/16 in.)
290-340 A	26-30 V	1.6 mm (1/16 in.)
260-310 A	22-27 V	1.6 mm (1/16 in.)
280-320 A	24-28 V	1.6 mm (1/16 in.)
90-210 A	15-26 V	1.0 mm (0.040 in.)

### ● DEPOSITION DATA

Current	Wire Diameter	Voltage
60-170 A	0.8 mm (.030 in.)	13-24 V
90-210 A	1.0 mm (.040 in.)	15-26 V
190-350 A	1.6 mm (1/16 in.)	25-30 V
280-400 A	2.4 mm (3/32 in.)	26-31 V
140-260 A	1.2 mm (.045 in.)	20-29 V

### ● CLASSIFICATIONS

Wire Electrode

SFA/AWS A5.10 : ER5183

EN ISO 18273 : S Al 5183 ( Al Mg 4.5 Mn 0.7 (A))

JIS Z 3232 : A5183

### ● CONSUMABLE CHARACTERISTICS

Alloy Type : AlMgMn

### ● TYPICAL WELD METAL ANALYSIS %

Typical Wire Composition %

Al	Cr	Cu	Fe	Mg	Mn	Si	Ti	Zn
94.2	0.08	0.01	0.13	4.9	0.65	0.04	0.100	0.01

# ALUMINIUM KOOHRANG ZAGROS CO.



## CONTACT US

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