

## OK Autrod 18.22

Continuous solid wire suitable for welding of aluminium alloys with more than 3 % Mg, e.g. AlMg4.5Mn, AlMg5Mn and AlMg5Cr, where high tensile strength is required. Can also be used for materials of type AlMgSiCu and AlSi1MgMn and weldable AlZnMg-alloys, like AlZn4.5Mg1. The welding wire has small additions of Zr which increases the finegrained structure of weld deposit and makes it less sensitive to hot cracking during welding.

<b>Alloy Type</b>	AlMgMn
<b>Shielding Gas</b>	I1, I2, I3 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	160 MPa ( 23 ksi )	330 MPa ( 48 ksi )	25 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C ( 68 °F )	26 J ( 19 ft-lb )

### Typical Wire Composition %

Mn	Si	Al	Cu	Ti	Zr	Mg
0.8	0.06	92.93	0.03	0.03	0.1	5.8

### Recommended Welding Parameters

Current	Wire Diameter	Voltage
140-260 A	1.2 mm ( 0.047 in. )	20-29 V
140-300 A	1.2 mm ( 0.047 in. )	20-29 V