

OK Tigrod 18.22

Bare welding rods 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 rods have small additions of Zr which increases the finegrained structure of weld deposit and makes it less sensitive to hot cracking during welding.

Typ legování	Alloyed aluminium (Al + 6 % Mg + 0.8 % Mn + Ti + Zr)
Ochranný plyn	I1, I2, I3 (EN ISO 14175)

Typické vlastnosti v tahu

Podmínky	Mez skluzu	Mez pevnosti v tahu	Prodloužení
Po svaení	160 MPa	330 MPa	25 %

Vrubová houževnatost

Podmínky	Testovací teplota	Vrubová houževnatost
Po svaení	20 °C	26 J

Typické složení drátu %

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