

OK Autrod 5087

Continuous solid wire suitable for welding of aluminium alloys with up to 5 % Mg and alloys where a higher tensile strength is required. The alloying element Zr gives improved properties against hot cracking during solidification.

Specifications	
Classifications	SFA/AWS A5.10 : ER5087 EN ISO 18273 : S Al 5087 (AlMg4,5MnZr)
Approvals	CE : EN 13479 DB : 61.039.07 VdTÜV : 05816 VdTÜV : 05816

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	AlMgMn
Shielding Gas	I1, I2, I3 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	130 MPa	280 MPa	30 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	20 °C	35 J

Typical Wire Composition %									
Mn	Si	Cr	Al	Cu	Ti	Zn	Zr	Fe	Mg
0.8	0.04	0.08	Rem	0.01	0.08	0.01	0.11	0.12	4.7

Recommended Welding Parameters		
Current	Wire Diameter	Voltage
90-275 A	1.0 mm	15-26 V
140-260 A	1.2 mm	20-29 V
140-300 A	1.2 mm	20-29 V
190-350 A	1.6 mm	25-30 V