

OK Autrod 5183

OK Autrod 5183 was developed to provide the highest strengths possible in the as welded condition of alloy AA 5083 and other similar high magnesium alloys. The more common 5356 grade will typically fail to meet the as-welded tensile requirements of AA 5083. The alloy is typically utilised in marine and structural applications where high strengths, high fracture toughness for impact resistance and exposure to corrosive elements are important. The alloy is not recommended for elevated temperature applications due to its susceptibility to stress corrosion cracking. The alloy is non-heat treatable.

Specifiche	
Classificazioni	SFA/AWS A5.10 : ER5183 EN ISO 18273 : S Al 5183 (AlMg _{4,5} Mn _{0,7} (A))
Omologazioni	ABS : WC ABS : ER 5183 BV : WC CE : EN 13479 ClassNK : KAI5RCG(I) CWB : ER5183 DB : 61.039.03 DNV : 5183 LR : WC1/I-1 S RINA : WC (*) UKCA : EN 13479 VdTÜV : 04666

Le approvazioni si basano sulla posizione della fabbrica. Si prega di contattare ESAB per ulteriori informazioni.

Tipo di lega	AlMgMn
Gas di protezione	I1, I3 (EN ISO 14175)

Proprietà prova Charpy con intaglio a V		
Stato	Temperatura di prova	Valore tenacità
Come saldato	20 °C	90 J

Typical Wire Composition %								
Mn	Si	Cr	Al	Cu	Ti	Zn	Fe	Mg
0.65	0.04	0.08	94.200	0.01	0.100	0.01	0.13	4.9

Parametri di saldatura		
Amp	Diametro del filo	Volt
90-275 A	1.0 mm	15-26 V
140-300 A	1.2 mm	20-29 V
190-350 A	1.6 mm	25-30 V