

## 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.

<b>Alloy Type</b>	Alloyed aluminium (Al + 6 % Mg + 0.8 % Mn + Ti + Zr)
<b>Shielding Gas</b>	I1, I2, I3 (EN ISO 14175)

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	160 MPa	330 MPa	25 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
As Welded	20 °C	26 J

Typical Wire Composition %						
Mn	Si	Al	Cu	Ti	Zr	Mg
0.8	0.06	92.93	0.03	0.03	0.1	5.8