



# Meltolit

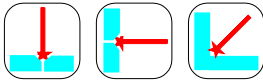
## AlMg4.5MnZr

AWS A 5.1: ER 5087  
ISO 18273: S-Al 5087(AlMg4,5MnZr)

### DESCRIPTION

For welding aluminium base alloys that require high mechanical properties. Construction, offshore and automotive industry. Very good saltwater resistance. Zr improves bending and corrosion resistance.

#### WELDING POSITIONS



#### CURRENT

DC (+) Mig  
AC Tig

#### GAS

Ar(l1)

### MECHANICAL PROPERTIES

<i>R<sub>m</sub></i> (Mpa)	<i>R<sub>p 0,2</sub></i> (Mpa)	<i>A<sub>5</sub></i> (%)	<i>Hardness</i>
>275	>125	>17	

### WELD METAL COMPOSITION(%)

Mg	Mn	Cr	Al	Zr	Ti		
<5,2	<1,0	<0,25	rest	0,10-0,20	0,15		

### PACKAGING & WELDING PARAMETERS

Mig(mm)	1,0	1,2	1,6	
Kg/spool	7	7	7	
Ampere(A)	90-175	120-240	150-300	
Tig(mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000
Ampere(A)	25-50	40-75	90-130	160-240
Kg/box	2,5	2,5	2,5	2,5