OK Autrod 5087

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

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

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

Alloy Type:	AlMgMn

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	Fe	Mg	Ti	Zn	Zr
0.8	0.04	0.08	Rem	0.01	0.12	4.7	0.08	0.01	0.11

Deposition Data

Diameter	Current	Voltage
1.0 mm	90-210 A	15-26 V
1.2 mm	140-260 A	20-29 V
1.6 mm	190-350 A	25-30 V