

## VBC Alloy 0033 3103 NG3

Designation and Description	GTAW and GMAW Solid Welding Wire Aluminium Base	Issued: Mar/2014	MSRR: 9500/33	AMS: N/A
		Revision: 01		
Cross Reference/ Conformance Specification	MSRR 9500/33 OMat 361A WN° 3.0516 N3 (NG3)	BS 2901-4:1990 3103 BS EN ISO 18273:2004 AlMn1 3103 DIN Al Mn 1 ISO Al Mn 1 Afnor A-81		
Metallurgical Background Information	Alloy 3103 NG3 is a solid welding wire produced conventionally and the surface cleaned to remove standard metal working lubricants.  3103 is an Al-Mn single-phase alloy used for welding alloys of similar composition. Deep drawing alloy.			
Materials To Be Welded, Applications and Advice	3103, L61, L59, N53, L60, WN° 3.0515  3000 series materials and commercial grade aluminium.			
Wire Chemistry WT% (as per AMS)	Silicon – 0.5% max		Zinc – 0.20% max	
	Iron – 0.7% max		Beryllium – 0.0008%	
	Copper – 0.10% max		Zirconium + Titanium – 0.10%	
	Manganese – 0.9-1.5%		Chromium – 0.10% max	
	Magnesium – 0.3% max		Aluminium - Balance	
Weld Properties	Melting range (approx.) 645°C - 655°C Hardness annealed 30 HV    Hardness Fully Hard 56 HV Readily weldable Density 2.73gm/cc			
Sizes and Forms of Supply	<b>Straight Length:</b> 2.5 kg Packs 36" / 914mm lengths Flag tagged Range of diameters available		<b>Spool:</b> Precision layer wound with controlled cast and helix 300mm diameter standard Range of diameters available	

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