

TECHNICAL DATA SHEET (TDS)

PRODUCT: 6082 ALUMINUM ALLOY COIL / SHEET

Aluminum alloy 6082 is a medium strength alloy with excellent corrosion resistance. It has the highest strength of the 6000 series alloys. It is known as a structural alloy. In plate form, Aluminum alloy 6082 is the alloy most commonly used for machining. As a relatively new alloy, the higher strength of Aluminum alloy 6082 has seen it replace 6061 in many applications. The addition of a large amount of manganese controls the grain structure which in turn results in a stronger alloy. It is difficult to produce thin walled, complicated extrusion shapes in alloy 6082. The extruded surface finish is not as smooth as other similar strength alloys in the 6000 series. In the T6 and T651 temper, 6082 machines well and produces tight coils of swarf when chip breakers are used.

PRODUCT BASIC INFORMATION:

Alloy:	6082		
Form:	Sheet, Coil		
Temper:	O, T4, T6		
Dimension:	Thickness:	0.5mm to 6.0mm	
	Width:	20.0mm to 2,000mm	
	Length:	1,000mm to 4,000mm, or Coil	
Surface Finish:	Mill Finish		
Standard Specification:	GB/T 3880, EN 485		
Application:	General Use		

CHEMICAL COMPOSITION:

Element		Percentage (%)
Aluminum	(Al)	Remainder
Silicon	(Si)	0.7~1.3
Iron	(Fe)	0.50 Max
Copper	(Cu)	0.1 Max
Manganese	(Mn)	0.6~1.2
Magnesium	(Mg)	0.8~1.2
Chromium	(Cr)	0.25 Max
Zinc	(Zn)	0.20 Max
Titanium	(Ti)	0.10 Max
Remainder Each		0.05 max
Remainder Total		0.15 max

MECHANICAL PROPERTIES:

		O	T4	T6
Ultimate Strength Rm/MPa		≤150	≥ 205	≥ 310
Yield Strength Rp0.2/MPa		≤85	≥ 110	≥ 260
Elongation Min. %	≥ 0.5~1.5mm	≥ 14%	≥ 12%	≥ 6%
	≥ 1.5~3.0mm	≥ 16%	≥ 14%	≥ 7%
	≥ 3.0~6.0mm	≥ 18%	≥ 15%	≥ 10%
Bend Radius (90°)	≥ 0.5~1.5mm	0.5t	1.5t	2.5t
	≥ 1.5~3.0mm	1.0t	2.0t	3.5t
	≥ 3.0~6.0mm	1.5t	3.0t	4.5t

PHYSICAL DATA :

Density (20°C):	2,700	kg/m ³
Melting Point:	575°C	
Thermal Expansion (20°C ~100°C):	23.1 x10 ⁻⁶	/K
Modulus of Elasticity:	71	GPa
Thermal conductivity (Temper O):	180	W·m-1·K-1
Electrical Resistivity (Temper O):	0.038 x10 ⁻⁶	Ω .m
Conductivity (Temper O):	42	%IACS
Magnetic performance:	No	
Color:	Silver	
Odour:	No	

TOLERANCE ON FORMS AND DIMENSIONS :

Thickness Tolerance:	Thickness	Width			
		≤1000mm	>1000~1250mm	>1250~1600mm	>1600~2000mm
	≥ 0.5~0.6mm	± 0.03mm	± 0.05mm	± 0.06mm	± 0.07mm
	> 0.6~0.8mm	± 0.03mm	± 0.06mm	± 0.07mm	± 0.08mm
	> 0.8~1.0mm	± 0.04mm	± 0.06mm	± 0.08mm	± 0.09mm
	> 1.0~1.2mm	± 0.04mm	± 0.07mm	± 0.09mm	± 0.10mm
	> 1.2~1.5mm	± 0.05mm	± 0.09mm	± 0.10mm	± 0.11mm
	> 1.5~1.8mm	± 0.06mm	± 0.10mm	± 0.11mm	± 0.12mm
	> 1.8~2.0mm	± 0.06mm	± 0.11mm	± 0.12mm	± 0.14mm
	> 2.0~2.5mm	± 0.07mm	± 0.12mm	± 0.13mm	± 0.15mm
	> 2.5~3.0mm	± 0.08mm	± 0.13mm	± 0.15mm	± 0.17mm
	> 3.0~3.5mm	± 0.10mm	± 0.15mm	± 0.17mm	± 0.18mm
	> 3.5~4.0mm	± 0.15mm	± 0.20mm	± 0.22mm	± 0.23mm
	> 4.0~5.0mm	± 0.18mm	± 0.22mm	± 0.24mm	± 0.25mm
	> 5.0~6.0mm	± 0.20mm	± 0.24mm	± 0.25mm	± 0.26mm

Width Tolerance:	Thickness	Width				
		≤300mm	>300~500mm	>500~1250mm	>1250~1650mm	>1650mm
	≥ 0.2~0.6mm	+ 0.4mm	+ 0.6mm	+ 1.5mm	+ 2.5mm	+ 3.0mm
	> 0.6~1.0mm	+ 0.5mm	+ 1.0mm	+ 1.5mm	+ 2.5mm	+ 3.0mm
	> 1.0~2.0mm	+ 0.7mm	+ 1.2mm	+ 2.0mm	+ 2.5mm	+ 3.0mm
	> 2.0~3.0mm	+ 1.0mm	+ 1.5mm	+ 2.0mm	+ 2.5mm	+ 4.0mm
	> 3.0~6.0mm	+ 1.5mm	+ 2.0mm	+ 3.0mm	+ 3.0mm	+ 5.0mm

Length Tolerance:	Thickness	Length			
		≤1000mm	>1000~2000mm	>2000~3000mm	>3000mm
	≥ 0.2~3.0mm	+ 3mm	+ 4mm	+ 6mm	+ 8mm
	> 3.0~6.0mm	+ 4mm	+ 6mm	+ 8mm	+ 10mm

Flatness Tolerance:	Thickness	Total Deviation		
		On Length	On Width	Partial Deviation
	≥ 0.2~0.5mm	By agreement	By agreement	By agreement
	> 0.5~3.0mm	≤ 0.4%	≤ 0.5%	≤ 0.5%
	> 3.0~6.0mm	≤ 0.3%	≤ 0.4%	≤ 0.4%

Lateral Curvature Tolerance:	Width	Lateral Curvature for Specified Length			
		≤1000mm	>1000~2000mm	>2000~3500mm	>3500mm
	≤300mm	≤ 2.0mm	≤ 4.0mm	≤ 8.0mm	-
	>300~600mm	≤ 1.5mm	≤ 3.0mm	≤ 5.0mm	-
	>600~1000mm	≤ 1.0mm	≤ 2.0mm	≤ 4.0mm	≤ 5.0mm
	>1000~2000mm	-	≤ 2.0mm	≤ 4.0mm	≤ 5.0mm
	>2000mm	-	-	≤ 4.0mm	≤ 5.0mm

Squareness Tolerance:	Length	Squareness Tolerance for Specified Width			
		≤1000mm	>1000~1500mm	>1500~2000mm	>2000mm
	≤1000mm	≤ 4.0mm	-	-	-
	>1000~2000mm	≤ 4.0mm	≤ 5.0mm	≤ 6.0mm	-
	>2000~3000mm	≤ 5.0mm	≤ 5.0mm	≤ 7.0mm	≤ 8.0mm
	>3000~5000mm	≤ 6.0mm	≤ 8.0mm	≤ 8.0mm	≤ 10.0mm

OTHER PROPERTIES:

Principal Design Features

This alloy has the highest strength of the 6000 series alloys. It is known as a high strength structural alloy with good weldability, workability and machinability. Due to the fine grained structure this alloy exhibits a good resistance to dynamic loading conditions.

Machinability

Machinability in the harder T4 and T6 tempers is good. It is notably less easy to machine in the annealed temper.

Forming	Easily cold worked and formed in the annealed condition. Stamping, bending, spinning, deep drawing are all readily accomplished using standard methods.
Weldability	Aluminum alloy 6082 has very good weldability but strength is lowered in the weld zone. When welded to itself, alloy 4043 wire is recommended. If welding Aluminum alloy 6082 to 7005, then the wire used should be alloy 5356.
Heat Treatment	Solution heat treat at 530°C for adequate time to allow for thorough heating and then water quench. Precipitation hardening is done at 175°C for 10 to 18 hours and air cool.
Hot Working	Hot working may be done in the temperature range of 260°C to 370°C.
Cold Working	Cold working in the O temper condition is readily performed. The alloy is notably less easy to cold form in the T4 and T6 tempers.
Annealing	Annealing should be done at 415°C for few hours followed by controlled cooling, then air cool.
Aging	The aging precipitation heat treatment is done at 175°C for 8 hours followed by air cooling. This produces the T6 temper.
Hardening	See "Aging".

APPLICATIONS

Typical Applications	Aluminum alloy 6082 is typically is used for milk churns, trusses, cranes, ore skips, beer barrels, bridges, scaffolding elements, rail coach parts, offshore constructions, containers, machine building and mobile cranes, highly stressed applications and transport applications. EN AW-6082 is certified for use in marine applications
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PACKAGING, HANDING & STORAGE:

Package:	Packed in waterproof Kraft, fastened by steel straps on wood pallets, suitable for handling, loading and unloading from the trunks or containers, suitable for export ocean forwarding.
Handling:	Prevent the goods hurting the people who are moving, loading, unloading, especially pay attention to the rolling and dropping for the coils.
Storage:	Stored in indoor area on plain floor, free away from moisture, water, snow, animal oils and dye wastes, avoid storing with acid or basic chemical goods.

The above mentioned aluminum product is produced according to national standard specifications, and has no poison, no pollution, and no cauterization. It is common industry metal material.

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