



Extruded alloys- tempers & mechanical properties:

Standard alloys in production include:

Alloy chemical composition as per EN 573-3											
Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other		Al
									Each	Total	
6060 AlMgSi _{0,5} DIN3.3206	0,30-0,60	0,10-0,30	0,10	0,10	0,35-0,60	0,05	0,15	0,10	0,05	0,15	Rest
6063 AlMg _{0,7} Si	0,20-0,60	0,35	0,10	0,10	0,45-0,90	0,10	0,10	0,10	0,05	0,15	Rest
6005A AlMgSi _{0,7} DIN3.3210	0,50-0,90	0,35	0,30	0,50	0,40-0,70	0,30	0,20	0,10	0,05	0,15	Rest
6082 AlSi ₁ MgMn DIN3.2315	0,70-1,30	0,50	0,10	0,40-1,00	0,60-1,20	0,25	0,20	0,10	0,05	0,15	Rest
6061* AlMg ₁ SiCu DIN3.3211	0,40-0,80	0,70	0,15-0,40	0,15	0,80-1,20	0,04-0,35	0,25	0,15	0,05	0,15	Rest

* Only available with a prior notice of 5 weeks and a minimum ordered quantity of 22 tons dispatched in one go.

Available combinations of Alloys & Tempers				
6060	6063	6005A	6082	6061
O	O	O	O	O
T4	T4	T4	T4	T4
T5	T5	-	T5	-
T64	-	-	-	-
T6	T6	T6	T6	T6
T66	T66	-	-	-

Temper designation EN 515:2017	
F	As fabricated (no specific mechanical property limits are specified)
O	Annealed wrought alloys
T4	Solution heat treated & naturally aged.
T5	Cooled from an elevated temperature forming operation & artificially aged (precipitation hardened)
T64	Solution heat treated & artificially aged in underaged conditions to improve formability (bending temper)
T6	Solution heat treated & artificially aged (precipitation hardened). Press quenching required.
T66	Cooled from an elevated temperature forming operation & artificially aged (precipitation hardened) to a higher level of mechanical properties through special control of manufacturing processes. Press quenching required.

Bendability classes to standardised tempers (EN 15088:2005)						
Alloy	T4	T5	T6	T6510	T64	T66
EN-AW 6060	-	B3	B3	B3	B2	B3
EN-AW 6063	-	B3	B3	B3	-	B3
EN-AW 6005A	-	-	-	B3	B3	-
EN-AW 6082	B2	B3	B3	-	-	-
EN-AW 6061	B2	-	B3	B3	-	-
B2	Material is in mid strained hardened/naturally aged/partially aged hardened. Bendability for simple symmetrical sections with medium radii is possible. Thin walled or complicated sections may require special devices or bending machines.					
B3	Material is in hard/fully age hardened. For simple symmetrical sections bendability is possible only with relatively large radii. Thin walled or complicated sections may require special devices or bending machines.					

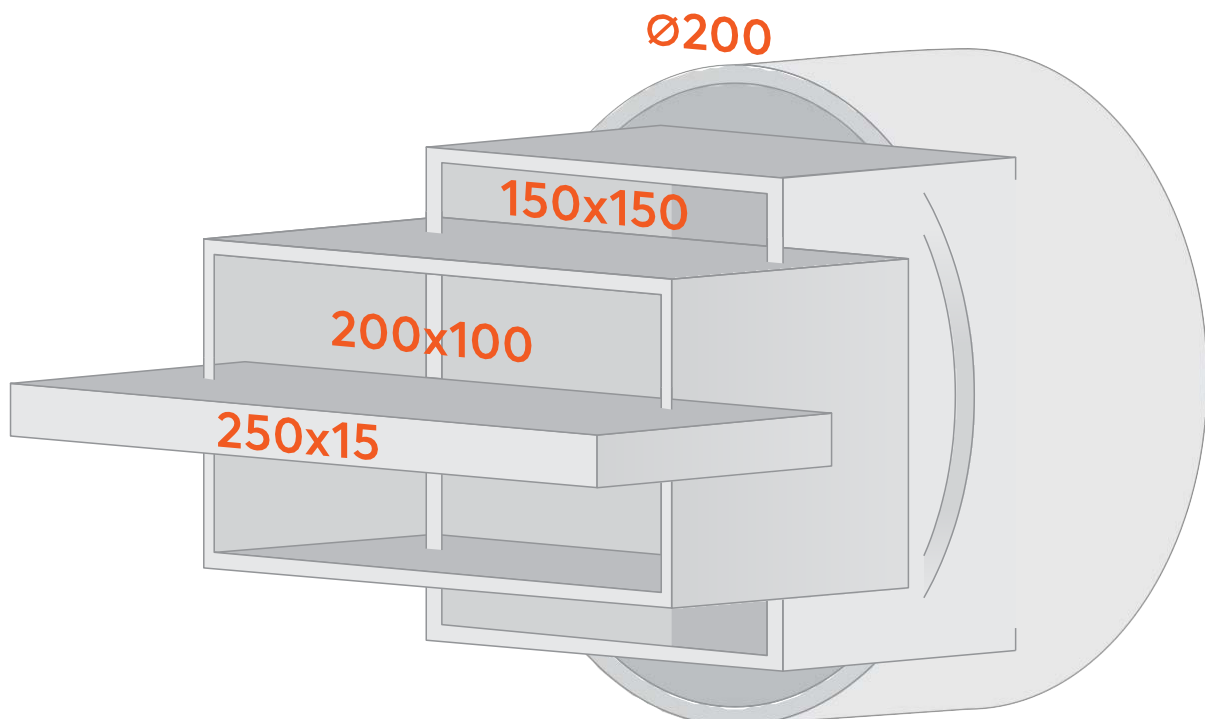
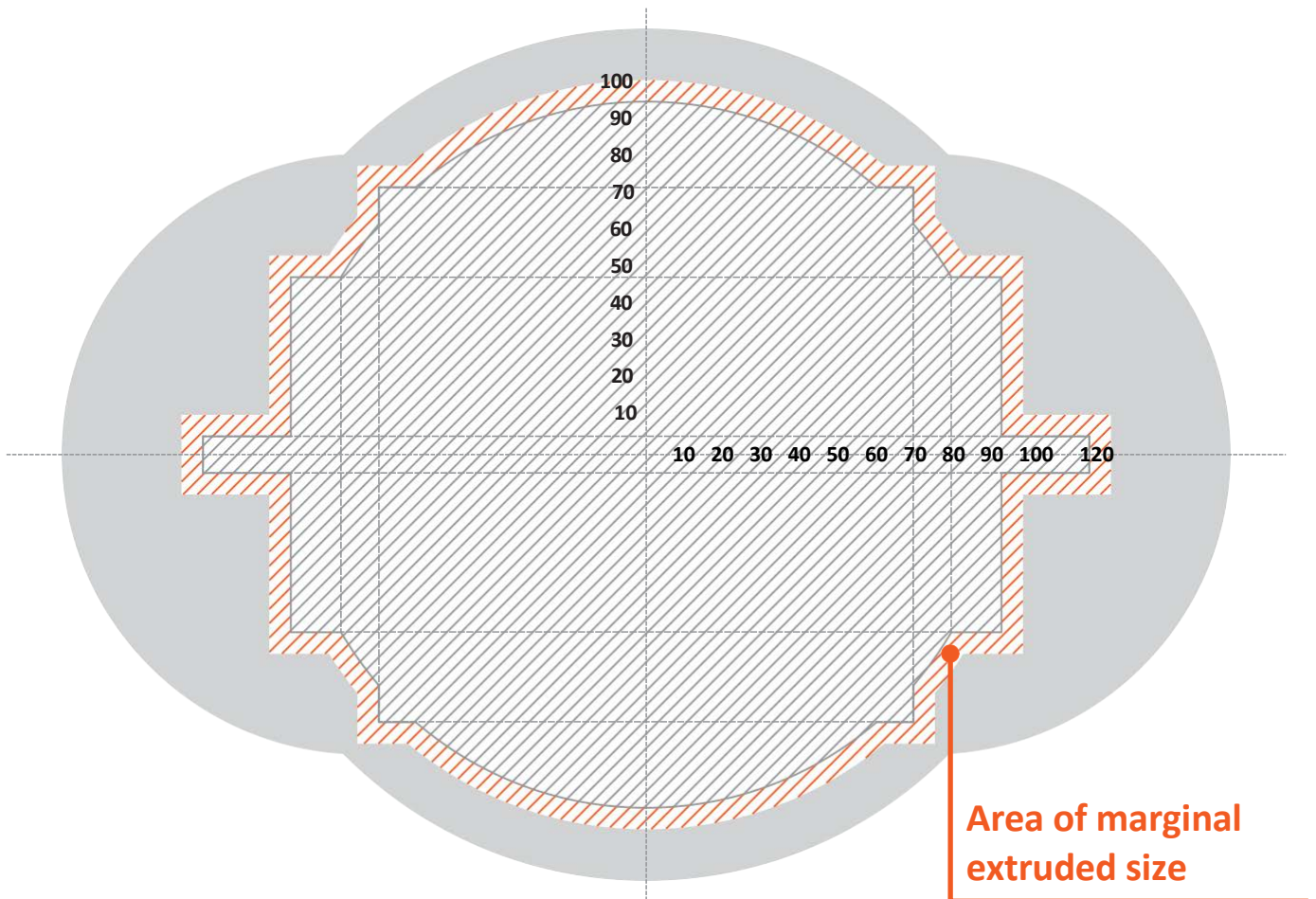
Physical properties	Alloys EN-AW				
Alloys EN-AW	6060	6063	6005A	6082	6061
Melting range °C	585-650		585-650	585-650	580-640
Density g/cm ³	2,70	2,70	2,70	2,70	2,70
Electrical Conductivity MS/m	34-38		26-32	24-32	22-30
Thermal Conductivity W/(m K)	200-220		180-220	170-220	170-200
Specific Heat J/(Kg K)	898			896	
Thermal Expansion Values					
-50 to 20 °C (10 ⁻⁶ /K)	21,8	23,4	23,4	23,4	23,0
20 to 100 °C (10 ⁻⁶ /K)	23,4				
20 to 200 °C (10 ⁻⁶ /K)	24,5				
20 to 300 °C (10 ⁻⁶ /K)	25,6				
Young's Modulus MPa	69500	69500	69500	70000	70000
Shear Modulus MPa	26100	26100	26200	26400	26300

Mechanical properties as per EN 755-2:2016 (EXTRUDED PROFILES)							
Alloy	Temper	Wall Thickness	Tensile strength	Yield strength	Elongation		Brinell Hardness
					A % min	A _{50mm} % min	
		e mm*	R _m MPa min	R _{p0,2} MPa min			HB**
EN-AW 6060	T4	e ≤ 25	120	60	16	14	50
	T5	e ≤ 5	160	120	8	6	60
		5 < e ≤ 25	140	100	8	6	60
	T6	e ≤ 5	190	150	8	6	60
		5 < e ≤ 25	170	140	8	6	60
	T64	e ≤ 15	180	120	12	10	60
	T66	e ≤ 5	215	160	8	6	75
		5 < e ≤ 25	195	150	8	6	75
EN-AW 6063	T4	e ≤ 25	130	65	14	12	50
	T5	e ≤ 10	175	130	8	6	65
		10 < e ≤ 25	160	110	7	5	65
	T6	e ≤ 10	215	170	8	6	75
		10 < e ≤ 25	195	160	8	6	75
	T66	e ≤ 10	245	200	8	6	80
		10 < e ≤ 25	225	180	8	6	80
EN-AW 6005A	T4 open	e ≤ 25	180	90	15	13	50
	T4 hollow	e ≤ 10	180	90	15	13	50
	T6 open	e ≤ 5	270	225	8	6	90
		5 < e ≤ 10	260	215	8	6	85
		10 < e ≤ 25	250	200	8	6	85
	T6 hollow	e ≤ 5	255	215	8	6	85
		5 < e ≤ 15	250	200	8	6	85
EN-AW 6082	T4	e ≤ 25	205	110	14	12	35
	T5 open	e ≤ 5	270	230	8	6	90
		hollow	e ≤ 5	270	230	8	6
	T6 open	e ≤ 5	290	250	8	6	95
		5 < e ≤ 25	310	260	10	8	95
	T6 hollow	e ≤ 5	290	250	8	6	95
		5 < e ≤ 15	310	260	10	8	95
EN-AW 6061	T4	e ≤ 25	180	110	15	13	65
	T6	e ≤ 5	260	240	9	7	95
		5 < e ≤ 25	260	240	10	8	95

* For a profile having different wall thicknesses, the lowest specified values of properties shall be considered as valid for the whole profile cross section. ** The values for the HB hardness are indicative only.

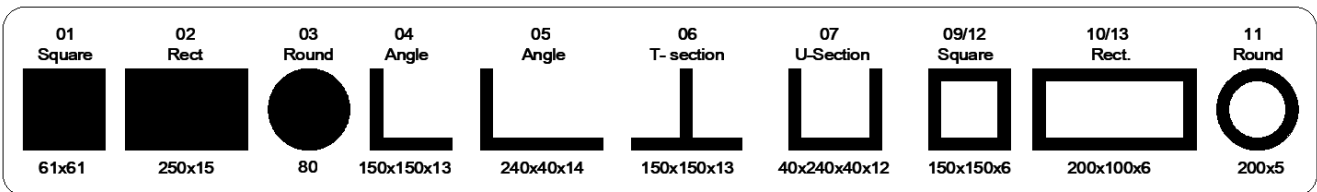


Profile size production range



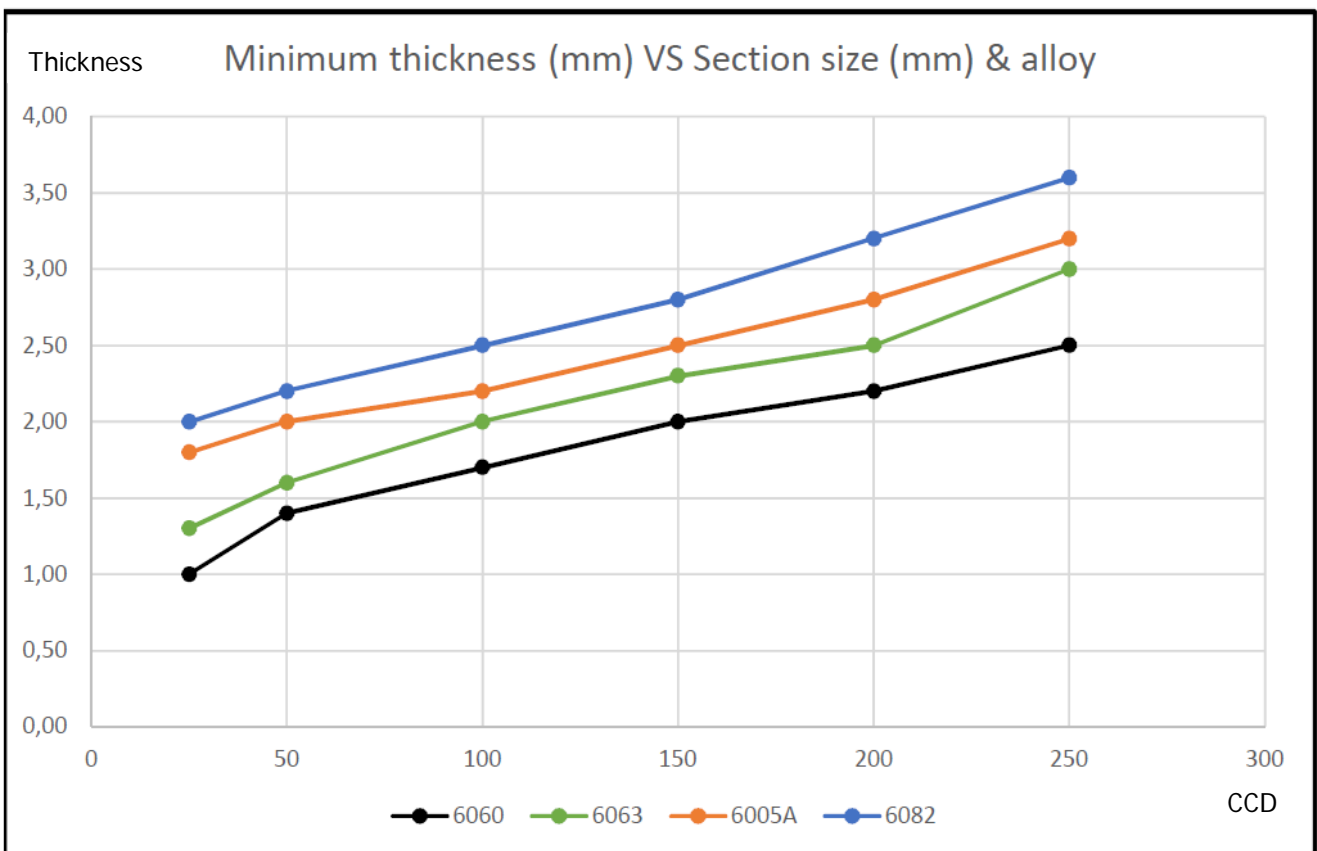
In tubes	∅200 x 5 mm	Weight range	
In square hollow sections	150 x 150 x 6 mm		
In rectangular hollow sections	200 x 100 x 6 mm	Minimum	Maximum
In equal leg angles and T sections	150 x 150 x 13 mm		
In unequal leg angles and channels	240 x 40 x 12 mm		
In rectangular (flat) bars	250 x 15 mm		
In square bars	70 x 70 mm		
In round bars	∅80 mm		

Schematic extrusion maximums per shape



Thickness vs Alloy

Depending on the size of the section (Circumscribed Circle Diameter, horizontal axis) and the alloy to extrude, the minimum thickness should follow the trend indicated by the chart below (vertical axis):





Product forms & Applications

Alloys	Forms	Characteristic properties	Applications
EN-AW 6060	Extruded bars Extruded tubes Extruded profiles	V.good corrosion resistance, weldability, Medium strength, Complex sections, Anodising quality.	Architectural sections, windows, doors, curtain walls, lightings, railing, ladders, furniture, fences, truck flooring, heat sinks, irrigation, cooling pipes, electronic modules.
EN-AW 6063		V.good corrosion resistance, weldability, Medium strength, Complex sections, Anodising quality.	Architectural sections, windows, doors, curtain walls, lightings, railing, ladders, furniture, fences, truck flooring, heat sinks, irrigation, cooling pipes, electronic modules, electric motor housings, office equipment, special machine elements.
EN-AW 6005A		V.good corrosion resistance, V.good weldability, ,Medium-high strength, Complex sections, Anodising quality.	Bus and railway profile structures, structural engineering, pylons, platforms, pipeline,...
EN-AW 6082		V.good corrosion resistance, V.good weldability, Medium-high strength, good machinability, formability in T4,Medium-high strength, Simple sections	Heavy duty structures in rail coaches, truck frames, ship building, offshore, bridges, boiler making, mast and beams for ship building, scaffolding, motorboats.
EN-AW 6061		V.good corrosion resistance, V.good weldability, Medium-high strength, good machinability, formability in T4,Medium-high strength, Simple sections	Heavy duty structures in rail coaches, truck frames, ship building, offshore, bridges, boiler making, mast and beams for ship building, scaffolding, motorboats

Quality control

We follow the European norms for:

EN Standard	Description
Aluminium & aluminium alloys- Extruded rod/bar, tubes and profiles	
EN 755-1	Technical conditions for inspection & delivery
EN 755-2	Mechanical properties
EN 515	Temper designation
EN 573-3	Chemical composition and form of products
EN 755-3	Round bars, tolerances on dimension & form
EN 755-4	Square bars, tolerances on dimension & form
EN 755-5	Rectangular bars, tolerances on dimension & form
EN 755-6	Hexagonal bars, tolerances on dimension & form
EN 755-8	Porthole square, rect, hex, Oct, & round tubes, tolerances on dimension & form
EN 755-9	Profiles, tolerances on dimension & form
EN- 12020-1	Technical conditions for inspection & delivery (for precision profiles only)
EN- 12020-2	Tolerances on dimension & form (for precision profiles only)
Metallic products- materials	
EN ISO 6892-1	Tensile testing- part 1: Method of test at room temperature
EN- 10204	Inspection certificates 2.3, 3.1, 3.2
On special request	
ASTM B 221M-07 (Metric)	Standard specification for Aluminium and Aluminium alloy Extruded Bars, Rods, Wire, Profiles and Tubes
ASTM B 429M- 06	Standard specification for Aluminium alloy Extruded Structural Pipe or Tube.
BS EN ISO 8493:2004	Tube- Drift- expanding test



Certifications

Cosmos Certificates
ISO 9001
ISO 14001
ISO 50001
ISO 45001
Certificate of Conformity of Factory Production Control- 0094/CPR/MAD/1007756/A A1 ENG (*) - LRQA
LR Approved – No LR23156785WA
REACH - RoHS
EPD
UK Certificate of Conformity of Factory Production Control – 0038/CPR/PRJ11100383196-1 - LRQA

