

AL 5356 Aluminium Mig Welding Wire

DESCRIPTION

A general-purpose type aluminum alloy which is typically chosen for its relatively high shear strength. In addition, it also offers excellent corrosion resistance when exposed to salt water. ER5356 should be considered for welding 5000 series aluminum base metals.

SHIELDING GAS: 100% Argon or Argon/Helium Mixtures

WELDING CURRENT: DCEP (Electrode Positive, Reverse Polarity)

CONFORMANCES: ER5356 **AWS:** AWS A5.10/A5.10M:1999(R2007) **EN ISO:** 18273:2004

TYPICAL APPLICATIONS

- Welding filler wire

Typical Wire Chemistry

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other	Al
0.25	0.40	0.10	0.05-0.20	4.5-5.5	0.05-0.20	0.10	0.06-0.20	0.15	REM

Mechanical Properties (As Welded)

Melting range	Conductivity	Density	Anodised colour	Tensile Strength,ksi
570 - 635°C	29% IACS (- O), 27% IACS (- H18)	2657.27 kg/m3	White	38

AVAILABLE DIAMETERS AND SUGGESTED OPERATING RANGE IN AMPS

These machine settings are a guide only. Actual voltage, welding current and ESO used will depend on machine characteristics, plate thickness, run size, shielding gas, operator technique, etc.

Wire Dia (mm)	Current Range (amps)
0.8mm	70-110
0.9mm	120-150
1.0mm	130-210
1.2mm	170-225

WELDING POSITIONS

All-positional