

## ER5356

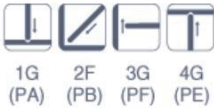
AWS A5.10 ER5356

EN ISO 18273 S Al 5356 (AlMg5Cr(A))

### Description:

An Al-Mg alloy welding wire is mainly used where higher weld strength and greater ductility is required, 5356 has greater resistance to corrosion (salt water) and better color match after anodizing. DC Reversed Polarity connection. Argon shielding gas is required. Welding for 5xxx series alloys.

### Welding Position:



### Diameters:

0.8mm, 0.9mm, 1.0mm, 1.2mm, 1.6mm.

### Typical Mechanical Properties:

Tensile strength(MPa):	265
Yield strength(MPa):	120
Elongation(%):	27
Impact values( $\geq 47$ )/+20°C):	--

### Typical Chemical Compositon:

Si	Fe	Cu	Mn	Mg
0.1	0.3	0.05	0.05-0.2	4.5-5.5
Cr	Zn	Be	Ti	Al
0.1-0.15	0.09	0.0008	0.06-0.2	Allowance

### Welding Current:(AC)

Dia:(mm)	0.8	0.9	1.0	1.2	1.6
Current/A	60-170	60-170	90-210	140-260	190-350
Voltage/V	13-24	13-24	15-26	20-29	25-30

### Note:

- 1.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
2. Shield Gas:100%Ar or 75%Ar+25%He or 50%Ar+50%He
3. In order to get good welding bead, weld on thick plate should be preheat 100-200°C before welding.
- 4. Tig rods ER5356 1.6mm, 2.0mm, 2.4mm, 3.2mm available**