

Aluminium wire

Classification

AWS A5.10-99	: ER5356
ISO 18273-01	: Al 5356

General description

Solid wire for welding aluminium alloys containing more than 3% Mg

Excellent feedability and very consistent welding performance.

Tight and stable arc.

Also available in 90 kg AccuPak®, that increases productivity by reducing time to change spools.

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	I1	Inert gas Ar (100%)
	I3	Inert gas Ar+ >0-95% He

Approvals

	ABS	BV	DB	DNV	GL	LR	TÜV
GTAW			+				+
GMAW	WB	WB	+	5356	S ALMg5	+	+

Chemical composition (w%), typical, wire / rod

Al	Mn	Si	Ti	Mg	Cr	Cu	Fe	Zn
bal.	0.11	0.08	0.06	4.9	0.07	0.01	0.2	0.03

Mechanical properties, typical

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)
Typical values	GTAW	I1	AW	130	285	25
	GMAW	I1	AW	110	250	25

Physical properties

Melting range	562 - 633°C
Density	approximately 2640 kg/m ³

Materials to be welded

Material	Code	Type	W.Nr.	Int.Reg.Nr.	Int.Cast.Nr.
Aluminium wrought alloys	DIN 1725-1	Al Mg 3	3.3535	5754	
		Al Mg 4,5	3.3345	5082	
		Al Mg 5	3.3555	5056A	
		Al Mg 2 Mn 0,8	3.3527	5049	
		Al Mg 2,7 Mn	3.3537	5454	
		Al Mg 4 Mn	3.3545	5086	
		Al Zn 4,5 Mg 1	3.4335	7020	
Aluminium cast alloys	DIN 1725-2	G-Al Mg 3	3.3541		
		G-Al Mg 3 Si	3.3241		512.0
		G-Al Mg 5	3.3561		B 535.0
		G-Al Mg 5 Si	3.3261		

Packaging

Process	Unit	Sizes (mm)								
		0.8	1.0	1.2	1.6	2.0	2.4	3.2	4.0	5.0
GTAW	5 kg tube				X	X	X	X	X	X
GMAW	0.5 kg plastic spool S100	X	X	X	X					
	2.0 kg plastic spool S200			X						
	7.26 kg plastic spool S300	X	X	X	X					
	7.0 kg basket spool BS300	X	X	X	X					
	90 kg AccuPak				X					

Other sizes and packaging on request

SuperGlaze® 5356: rev. EN 15

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