Aluminium Alloyed MIG Welding Wires & Rods
ER 5356

Standards

EN ISO 18273	: S Al 5356 / AlMg5Cr(A)
TS EN ISO 18273	: S Al 5356 / AlMg5Cr(A)
AWS A5.10/A5.10M	: ER 5356

Chemical Composition of Weld Metal % (Typical)

Mn	Si	Fe	Cu	Cr	Mg
0.20	0.25	0.40	0.10	0.20	5.50

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Elongation Lo=5do- (%)
180	260	min. 18

Typical Base Material Grades

- AlMg 5, AlMg 4.5, AlMgSi 1, AlMg 2.5Mn, AlMg 2 Mn 0.8, AlMg 3, AlMg 3 Si, AlMg 4.5 Mn,
- AlMg Si 0.5, AlMgSi 0.7, AlMgSi 0.8, AlMgSi 1 Cu, AlZn 4.5 Mg 1
- G-AlMg 5, G-AlMg 10, G-AlMg 3(Cu), G-AlMg 3, G-AlMg 3 Si

Features and Applications

- Used for joining magnesium alloy materials.
- The filler metal is suitable for anodizing and polishing.
- Used in storage tanks, columns, and marine applications.
- It is recommended that preheating to 150°C before welding of plates thicker than 10mm.
- In MIG welding, Ar, He, and Ar+He gas mixtures are used as shielding gases.
- In TIG welding, Ar gas is used as the shielding gas.

Welding Positions

Current Type

D.C.(-) / A.C.

Operating Data

Product Code		Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
BS 300	D 300				
		0.8	0.030”		
		1.0	0.040”		
		1.2	0.047”		
		1.6	0.062”		
		1,60 x 1000	1/16 x 39”		
		2,00 x 1000	5/64 x 39”		
		2,40 x 1000	3/32 x 39”		
		3,20 x 1000	1/8 x 39”		