

**Standards**

TS EN ISO 18273	: S Al 5356 (AlMg5Cr(A))
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DIN 1732	: SG-AlMg5
AWS A5.10	: ER 5356

**Chemical Composition of  
Welding Wire % (Typical)**

Al	Mg	Si	Mn
rest	5.0	0.5	0.5

**Mechanical Properties**

Densitt (kg/dm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)	Melting Range (°C)	Hardness (HB)
2.6	120	250	25	560 - 630	70

**Features and Applications**

- AlMg5 is magnesium alloyed aluminum TIG rod
- It is used for joining of aluminum alloys required high mechanical properties
- The weld deposit has a good resistance to atmospheric influences and sea water
- And the weld metal is proper for surface treatment such as anodizing and polishing
- it is recommended that preheating to 150°C before welding of plates thicker than 15mm
- For gas welding, GeKaTec F-LH1 is recommended
- Shielding gas: Ar

**Welding Method**

TIG Welding - Gas Welding

Current Type	MIG Wire
TIG A.C.	GeKa AlMg 5

**Welding Positions**

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6011100062	1,60 x 1000	1/16 x 39"	5
6011100281	2,00 x 1000	5/64 x 39"	5
6011100282	2,40 x 1000	3/32 x 39"	5

Approvals: SEPRO