



GMAW/GTAW ALUMINIUM ALLOYS

AUTOMIG 5356 / TIGFIL 5356

5356 TYPE ALUMINIUM WIRE



CLASSIFICATION : EN ISO 18273

AWS A/SFA 5.10

APPROVALS :

S Al 5356

ER 5356

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KEY FEATURES :

- Al-5Mg solid wire
- Excellent feedability with consistent welding performance
- Most versatile and universally used filler material
- High strength weld with very good corrosion resistance in marine environment
- Radiographic weld quality

WELDING POSITION :



GMAW: DCEP
GTAW: AC

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
GMAW: Ar or Ar/He	15-22	10-20
GTAW: Ar	10-15	-

TYPICAL APPLICATIONS :

- Welding of similar composition Al-Mg, Al-Mg-Zn and Al-Mg-Si alloys
- Automotive, Marine application
- Structural fabrication
- Welding Al alloys containing more than 3% Mg

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al
Specification	0.25 max	0.40 max	0.10 max	0.05-0.20	4.5-5.5	0.05-0.20	0.10 max	0.06-0.20	Bal.

PACKING DATA :

Automig 5356	Ø, mm		Kg/Spool	
	1.0		7	
	1.2		7	
	1.6		7	
Tigfil 5356	Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
	1.6 x 1000	2	4	8
	2.0 x 1000	2	4	8
	2.4 x 1000	2	4	8