

# AS MIG AlMg5 / AS TIG AlMg5



## MIG Wire and TIG Rod for Welding of Aluminium Alloys

### Classification

AWS A5.10 : ER5356  
ISO 18273 : S Al 5356 / AlMg5

### General Description

Solid wire and rod for welding of aluminium alloys containing more than 3% magnesium.

### Chemical Composition (w%), Typical, Wire

Si	Mg	Mn	Fe	Cr	Cu	Zn	Ti	Al
0.15	4.5 - 5.5	< 0.20	< 0.40	< 0.15	< 0.10	< 0.10	< 0.06	kalan

### Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 130 N/mm <sup>2</sup>	Melting Range	: 565 - 635 °C
Tensile Strength	: 280 N/mm <sup>2</sup>	Density	: 2.65 gr/cm <sup>3</sup>
Elongation (L=5d)	: 25 %		

### Shielding Gases (acc. ISO 14175 and EN 439)

MIG : I1 - Ar (%100)  
TIG : I1 - Ar (%100)

### Materials to be Welded

#### Aluminium Wrought Alloys

DIN 1725-1	Mat. Nr.	Alloy Nr.
AlMg 3	3.3535	5754
AlMg 4.5	3.3345	5082
AlMg 5	3.3555	5056A
AlMg 2 Mn 0.8	3.3527	5049
AlMg 2.7 Mn	3.3537	5454
AlMg 4 Mn	3.3545	5086
AlZn 4.5 Mg 1	3.4335	7020

#### Aluminium Cast Alloys

DIN 1725-2	Mat. Nr.	Alloy Nr.
G-AlMg 3	3.3541	
G-AlMg 3 Si	3.3241	512.0
G-AlMg 5	3.3561	B535.0
G-AlMg 5 Si	3.3261	

### Packaging and Available Sizes

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	4.0	Spool/Tube Weight
MIG Wire	-	X	X	-	-	-	-	-	7 kg
TIG Rod	-	-	-	-	X	X	-	-	5 kg