

Aluminium wire

Classification

AWS A5.10 :ER5356
 ISO 18273 :S Al 5356 (AlMg5Cr)

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 WUTPACK®Mini, that increases productivity by reducing time to change spools.

Shielding gas (acc. EN)

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

Approvals

	ABS	BV	DNV	GL	LR	TÜV
GTAW						+
GMAW	WC	WC	5356	S AlMg5	+	+

Chemical composition (w%), typical, all weld metal

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

Mechanical properties, all weld metal

	Process	Shielding gas	Condition	0.2% Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact (ISO), J		Hardness HB
							+20°C	-60°C	
Typical values	GTAW	I1	AW	130	285	25			
after welding	GMAW	I1	AW	110	250	25			

Physical properties

Melting range 562-633°C
 Density approximately 2640 kg/m³

Materials to be welded

Material	Code	Type	W.Nr.	Int.Reg.Nr.	Int.Cast.Nr.
Aluminium wrought alloys	DIN 1725-1	Al Mg Si 3	3.3535	5754	
		Al Mg Si 4.5	3.3345	5082	
		Al Mg Si 5	3.3555	5056A	
		Al Mg Si 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, available sizes and identification

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 kg plastic spool S200			X						
	7.6 kg plastic spool S300	X	X	X	X					
	7.0 kg basket spool BS300	X	X	X	X					
	90 kg WUTPACK®Mini				X					

Other sizes and packaging on request

Identification Imprint: Reval®5356

Tip colour:

Reval®5356 : rev.EN 20