



PRODUCT DATA SHEET

ALUMINIUM TIG WIRE

MAXAL ALI TIG 5356



SUMMARY

- > High strength
- > High ductility/fatigue strength/very high toughness
- > Moderate ductility/formability
- > Lower electrical conductivity and thermal conductivity
- > Higher column strength/better feedability
- > Very good color match after anodizing with 5xxx/6xxx

CLASSIFICATION

- > AS/NZS ISO 18273-S Al 5356
- > AWS A5.10: ER5356

DESCRIPTION AND APPLICATION

Maxal 5356 is designed to weld 5xxx series structural alloys and 6xxx series extrusions. It is mainly used where higher weld strength and greater ductility is required.

Suitable for lower strength alloys, truck frames, shipbuilding and rail cars and bus panels

OTHER

- > **Shielding Gas:** 100% Argon (Ar) or Argon/Helium mixtures, typical: GMAW (14-24 l/min), GTAW (10-14 l/min).
- > **Type of Current:** AC for GTAW
- > **Standard Diameters:** 2.4mm, 3.2mm,
- > **Storage:** Product should be stored in a dry, enclosed environment, and in its original intact packaging

CONFORMANCES & APPROVALS

- > **AWS A5.10:** ER5356, R5356
- > **ASME:** SFA 5.10, ER5356, R5356

TYPICAL ROD ANALYSIS

Si	Fe	Cu	Mn	Mg
0.25	0.40	0.10	0.05 - 0.20	4.5 - 5.5
Cr	Zn	Ti	Be	
0.05 - 0.20	0.10	0.06 - 0.20	<0.003	

TYPICAL WELD DEPOSIT ANALYSIS

Melting Range	270 - 635 °C
Electrical / Thermal Conductivity	29%
As Welded UTS Typical	262 MPa
Anodized Colour	White
Elevated Temp. Applications	+65°C

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
2.4	4.5kg packet	TIGMAX535624
3.2	4.5kg packet	TIGMAX535632

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