



PRODUCT DATA SHEET

SOLID MIG WIRES - ALUMINIUM

AUSTMIG 5356



SUMMARY

- > Aluminium - 5% Magnesium Alloy, Metal Inert Gas (MIG) welding wire
- > Double shaved and precision layer wound for superb feedability
- > For welding cast and wrought aluminium alloys containing magnesium

CLASSIFICATION

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

DESCRIPTION AND APPLICATION

Austmig 5356 is a precision layer wound Aluminium - 5% Magnesium wire suitable for a wide range of gas metal arc welding applications on wrought or cast aluminium alloys containing magnesium as a major alloying element. Some grades of wrought aluminium - magnesium alloys which can be welded with Austmig 5356 are, 5083, 5086, 5454 and 5456.

OPERATIONAL DATA

Welding parameters shown below are for DC Electrode negative only.

| WIRE SIZE (MM) | WELDING CURRENT RANGE (A) | ARC VOLT. RANGE *(V) |
|----------------|---------------------------|----------------------|
| 1.0 | 100 - 290 | 16 - 29 |
| 1.2 | 120 - 350 | 18 - 34 |

Welding Current DC +

*Voltage is determined by arc current and electrode arc length.

Welding currents and voltage shown are operational guides only.

SHIPPING APPROVAL

- > LR WC/I-1S;
- > ABS WS A5. 10-92/ER5356;
- > DNV 5356

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

| Si | Fe | Mn | Mg | Cr | Ti | Al | Zn |
|------|-----|------|-----|-----|------|-----|-----|
| 0.25 | 0.4 | 0.15 | 5.2 | 0.1 | 0.15 | Bal | 0.1 |

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

| | |
|------------------|---------|
| Gas Type | Ar |
| Yield Strength | 125 MPa |
| Tensile Strength | 275 MPa |
| Elongation | 17% |

PACKAGING DATA

| WIRE SIZE (MM) | PACK SIZE AND TYPE | PART NO. |
|----------------|--------------------|-----------|
| 1.0 | 6kg spool | MIG535610 |
| 1.2 | 6kg spool | MIG535612 |

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