



MIG ALG5

Old reference: MIG AlMg5

Classification

AWS A5.10 : ER5356

ISO 18273 : S Al 5356 (AlMg5Cr)

Description & Applications

Solid wire for GMAW of Aluminium alloys with more than 3% Mg, up to 5 % of Mg and for heterogeneous assemblies. Very often used in marine construction for their excellent resistance to salt water corrosion and for their very good mechanical characteristics, but also in the railway sector for the welding of wagons to transport phosphate, and also in the road sector for trucks and tractors.

Main applications: Ship building, wagons building, tanks and trailers manufacturing.

Base materials:

Alloys	DIN
5056	AlMg5Cr
5083	AlMg4.5Mn
5086	AlMg4Mn
5454	AlMg3Mn
5754	AlMg3
6005A	AlSi5Mg

Typical Chemical Composition (%)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Be	O/E	O/T	Al
Min				0.05	4.5	0.05		0.06				
Max	0.25	0.40	0.10	0.20	5.5	0.20	0.10	0.20	0.0003	0.05	0.15	Rem.
Type	0.05	0.13	0.01	0.15	4.8	0.10	0.01	0.13	0.0001	<0.05	<0.15	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max			
Type	135	280	30

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = + / Pulsed	1.0	100-150	18-22	ISO 14175: I1 (100% Ar) I3 (Ar+ 5-30%He) 15-20L/min
	1.2	130-200	18-25	
	1.6	170-260	20-27	

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Fumes: Consult information on MSDS, available upon request.

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