



PRODUCT DATA SHEET

SOLID MIG WIRES - ALUMINIUM

WCD 6413

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
- > AWS 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

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
0.9	80 - 190	16 - 22
1.0	100 - 230	18 - 22
1.2	150 - 250	20 - 27
1.6	200 - 330	23 - 30

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 AWS A5. 10-92/ER5356; DNV 5356

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

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

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.
0.9	2kg spool	M5356092KG
	6kg spool	M535609S
1.0	2kg spool	M5356102KG
	6kg spool	M535610S
1.2	2kg spool	M5356122KG
	6kg spool	M535612S
1.6	6kg spool	M535616S

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