

## Classifications

EN ISO 18273-A	EN ISO 18273-B	AWS A5.10
S Al 5356 (AlMg5Cr(A))	-	ER5356

## Characteristics and typical fields of application

Solid wire for AlMg alloys containing up to 5 % Mg. Seawater resistant weld metal. Good colour matching with base metal after anodizing. Thorough cleaning of the workpiece bevels is necessary. Thicker plate materials require preheating to 150 °C (302 °F).

## Base materials

AlMg 5	3.3555	EN AW-5019 [AlMg 5]
AlMg 3	3.3535	EN AW-5754 [AlMg 3]
AlMg 4 Mn	3.3545	EN AW-5086 [AlMg 4]
AlMgSi 0.5	3.3206	EN AW-6060 [AlMgSi]
AlMgSi 0.7	3.3210	EN AW-6005A [AlSiMg(A)]
AlMgSi 1	3.2315	EN AW-6082 [AlSi 1 MgMn]
AlMg 1 SiCu	3.3211	EN AW-6061 [AlMg 1 SiCu]
AlZn 4.5 Mg 1	3.4335	EN AW-7020 [AlZn 4.5 Mg 1]
AlMg 2.7 Mn	3.3537	EN AW-5454 [AlMg 3 Mn]
G-AlMg 5	3.3561	EN AC-51300
G-AlMg 5 Si	3.3261	EN AC-51400
G-AlMg 3	3.3541	EN AC-51100
G-AlMg 3 Si	3.3241	-

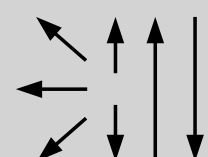
## Typical analysis of solid wire (wt.-%)

	Al	Mn	Cr	Mg	Ti	Fe	Si	Zn	Cu
wt.-%	bal.	0.05 – 0.2	0.05 – 0.2	4.5 – 5.5	0.06 – 0.2	< 0.4	< 0.25	< 0.1	< 0.1

## Mechanical properties of all-weld metal

Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )
MPa	MPa	%
110	240	17

## Operating data

	<b>Polarity:</b> DC (+)	<b>Shielding gas:</b> (EN ISO 14175) I1, I3	<b>ø (mm)</b> 1.0
			1.2
Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm			1.6

## Approvals

TÜV (2197.), DB (61.132.01), GL, LR