



# 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 Stress     | 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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