

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
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 _{p0.2}			Tensile strength R _m			Elongation A (L ₀ =5d ₀)		
MPa			MPa			%		
110			240			17		
Operating data								
	Ø (mm)		Shielding gas: (EN ISO 14175)				Polarity: DC (+)	
	1.0		I1, I3					
	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								