

Technical data sheet

011121MBA

Aluminium - Solid wire
SPEEDAI 5356**CLASSIFICATION**

EN ISO 18273: S Al 5356 (AlMg5)
 AWS A 5.10: ER5356
 Material number: 3.3556

DESCRIPTION

- Solid GTAW rod / GMAW aluminium-magnesium wire
- With large workpieces and wall thicknesses above 15mm, preheat the area of the welding groove to 150°C

APPLICATIONS

SPEEDAI 5356 are designed for joining aluminium-magnesium alloys.

Examples

EN	Material number	UNS
AW-5005 (AlMg1)	3.3315	5050A
AW-5754 (AlMg3)	3.3535	5754
AW-5454 (AlMg3Mn)		
EN AW-5019 (AlMg5),		
EN AW-5086 (AlMg4)		
EN AW- 5454 (AlMg3Mn)		
EN AW-6061 (AlMg1SiCu)		
EN AW-6082 (AlSi1MgMn)		
EN AC-51100 (G-AlMg3)		
EN AC-51300 (G-AlMg5)		
EN AC-51400 (G-AlMg5Si)		

TYPICAL WIRE ANALYSIS

Mg	Mn	Cr	Ti	Al
5.0	0.35	0.1	0.15	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]
250	110	18

TYPICAL ALL-WELD METAL PHYSICAL PROPERTIES

Electrical conductivity [S*m/mm ²]	Thermal conductivity [W/(m*K)]	Expansion coefficient [1/K]
15 - 19	110 - 150	23.7*10 ⁻⁶

SHIELDING GAS

GTAW	EN ISO 14175: I1 (Argon)
GMAW	EN ISO 14175: I1 (Argon), I3 e.g. (Argon + 30% helium)

Preheating at 150°C for base metal thicknesses exceeding 15 mm is recommended.

WELDING POSITIONS

GTAW	GMAW

PACKAGING

Welding process	Product type	Diameter x Length	Packing type EN ISO 544	
GTAW	Rod	1.6 - 5.0 mm x 1000 mm	Tube	5 kg
GMAW	Wire	0.8 - 2.4 mm	Spool	15 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.