

# ES MIG 5356

GMAW  
ER5356

**ESWECO**  
*The Art of Welding*

## Description

ES MIG 5356 is the most widely used welding alloy and can be classified as a general-purpose type filler alloy. ES MIG 5356 is typically chosen because of its relatively high shear strength. The 5XXX alloy base material, welded with ES MIG 5356, with a weld pool chemistry greater than 3% Mg and service temperatures in excess of 65°C, is susceptible to stress corrosion cracking. The alloy is non-heat treatable.

## Current

DC+

## Classifications

SFA/AWS A5.10 ER5356  
EN ISO 18273 S Al 5356 (AlMg5Cr(A))

## Typical all weld metal composition, %

Si	Mn	Cr	Cu	Fe	Ti	Zn	Mg
<0.25	0.15	0.13	<0.05	<0.40	0.11	<0.10	5.0

## Typical mech. Properties all weld metal

Yield stress, MPa	120
Tensile strength, MPa	265
Elongation, %	26

## Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	5-13	60-170	13-24
1.0	7-14	90-210	15-26
1.2	6-13	140-260	20-29
1.6	4.5-7.5	190-350	25-30