

ES TIG 5356

GTAW

R5356

ESWECO
The Art of Welding

Description

ES TIG 5356 is the most widely used welding alloy and can be classified as a general-purpose type filler alloy. ES TIG 5356 is typically chosen because of its relatively high shear strength. The 5XXX alloy base material, welded with ES TIG-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

AC

Classifications

SFA/AWS A5.10 R5356
EN ISO 18273 S Al 5356 (AlMg5Cr(A))

Typical all weld metal composition, %

Si	Mn	Cr	Cu	Ti	Zn	Fe	Mg
<0.25	0.15	0.13	<0.05	0.11	<0.1	<0.4	5.0

Typical mech. Properties all weld metal

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

Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	2.5
2.4	1000	2.5
3.2	1000	2.5
4.0	1000	2.5