

Union AlMg 5

Welding rod / bare wire electrode

| Classifications | EN ISO 18273 | AWS A5.10 | Mat. No. |
|-----------------|------------------------|-----------|----------|
| | S Al 5356 (AlMg5Cr(A)) | ER5356 | 3.3556 |

Characteristics and field of use
 Welding rods and bare wire electrodes for GTAW and GMAW of AlMg alloys containing up to 5 % Mg. Seawater resistant weld metal.

Thorough cleaning of the workpiece bevels is necessary. Thicker plate materials require preheating to 150 °C (302 °F).

Marks
 (nur bei Stäben)  3.3556 / AlMg5

| Materials (EN 573/1706) | EN AW-5019 [AlMg 5] EN AW-5086 [AlMg 4] EN AW-6005A [AlSiMg(A)] EN AW-6061 [AlMg 1 SiCu] EN AW-5454 [AlMg 3 Mn] EN AC-51400 | EN AW-5754 [AlMg 3] EN AW-6060 [AlMgSi] EN AW-6082 [AlSi 1 MgMn] EN AW-7020 [AlZn 4,5 Mg 1] EN AC-51300 EN AC-51100 |
|----------------------------|--|--|
|----------------------------|--|--|

| Typical analysis in % | Mg | Mn | Cr | Ti | Al |
|-----------------------|---------|---------|------|-------|------|
| | 4.5-5.5 | 0.1-0.5 | <0.3 | <0.15 | Bal. |

| Mechanical properties of the weld metal acc. to DIN 1732-3 (min. values at RT) | Yield strength 0.2 % MPa | Tensile strength MPa | Elongation ($L_0=5d_0$) % | Electrical conductivity Sm/mm ² |
|---|--------------------------------|-------------------------|-----------------------------------|---|
| | 110 | 235 | 18 | 14-19 |

Welding position  **Polarity GTAW ~ / GMAW = +**
Shielding gas (EN ISO 14175) I

Approvals
 TÜV (Certificate No. 2198 [GTAW] and 2197 [GMAW])
 DB (Reg. form No. 61.132.01 [GTAW and GMAW])
 GL [GMAW], LR [GMAW]

| Packaging and weights (Tolerances acc. EN ISO 544) | Diam. x Length (mm) | Spool | kg/pack | Drum (kg) |
|---|--------------------------------|-------|---------|-----------|
| | 1.6 x 1000 | — | 10 | — |
| | 2.0 x 1000 | — | 10 | — |
| | 2.4 x 1000 | — | 10 | — |
| | 3.2 x 1000 | — | 10 | — |
| | 4.0 x 1000 | — | 10 | — |
| | 0.8 | B300 | 5 | — |
| | 1.0 | B300 | 7 | — |
| | 1.2 | B300 | 7 | 80 |
| | 1.6 | B300 | 7 | 80 |
| | Other spool types upon request | | | |