

TECHNICAL DATA SHEET

AWS /ASTM A5.10: **ER5356**
 DIN 1732:SG-AL Mg 5% Werks 3.3556
 BS2901 Pt. 4: 5356

| DESCRIPTION: Excellent strength and resistance to corrosion with max. magnesium content of 5% USE: Shipbuilding, tanks, railways, car industry | | | | | | | | | | | | | | | | | | | | | |
|--|--|---|-----------|-------|-------|-----------|-----------|-----------|---------|----|----|-----|-------|-------|-----------|-------|-------|-----------|-----------|-----------|---------|
| Material to be welded Al Mg 4,5 Mn – Al Mg 5 – Al Mg Mn Al Zn Mg 1 – Al Mg Si 0,7 G-Al Mg 3 Si – G-Al Mg5 Si –G-Al Mg 10 – Al Mg1 Si Cu | Shielding gas for Gmaw/Gtaw Ar 99,95% min Ar 75% + He 25% Ar 50% + He 50% | | | | | | | | | | | | | | | | | | | | |
| ANALISI CHIMICA DI COLATA (TIPICA) <i>Analyse de colée / Cast analysis / schmelzanalyse</i> <table border="1"> <thead> <tr> <th>Al</th> <th>Si</th> <th>Fe</th> <th>Mg</th> <th>Zn</th> <th>Cu</th> <th>Mn</th> <th>Cr</th> <th>Ti</th> <th>Be</th> </tr> </thead> <tbody> <tr> <td>Rem</td> <td><0.25</td> <td><0.40</td> <td>4,50-5.60</td> <td><0.10</td> <td><0.05</td> <td>0.10-0.20</td> <td>0.10-0.35</td> <td>0.07-0.15</td> <td><0.0008</td> </tr> </tbody> </table> | | Al | Si | Fe | Mg | Zn | Cu | Mn | Cr | Ti | Be | Rem | <0.25 | <0.40 | 4,50-5.60 | <0.10 | <0.05 | 0.10-0.20 | 0.10-0.35 | 0.07-0.15 | <0.0008 |
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| VALORI MINIMI DELLE CARATTERISTICHE MECCANICHE (METALLO SALDATO) <i>Valeurs Min des Propriétés mecaniques du metal soudé / Min . Values of the meccanical properties (welded metal)</i> | | | | | | | | | | | | | | | | | | | | | |
| TENSILE STRENGHT(Rm) N/mm2 resistenza alla trazione(Rm) N/mm2 <p style="text-align: center;">240</p> | YELD STRENGHT Rp 0.2 N/mm2 Resistenza allo snervamento N/mm2 <p style="text-align: center;">110</p> | ELONGATION L=5d (%) allungamento L=5d (%) <p style="text-align: center;">17</p> | | | | | | | | | | | | | | | | | | | |
| Available sizes: Mig: 0.80 – 2.40 mm Tig Rods: 1.60 – 4.00 mm Packaging: Mig 0.5(D-100) – 7 Kgs (BS/D 300) TIG Rods: 2.5/kgs tubes APPROVALS: TUV-CE-ABS-LR-ISO 9001 | | | | | | | | | | | | | | | | | | | | | |