Alloy: COREWELD 5356 | Class: ER5356

ER5356 • Weld Process: MIG & TIG

CERTIFIED TO
AWS A5.10
ASME SFA A5.10

AWS CHEMICAL COMPOSITION REQUIREMENTS | DEPOSITED CHEMICAL COMPOSITION % (TYPICAL)

AWS REQUIREMENT (%)	
Si	0.25 max
Cr	0.05 – 0.20
Fe	0.40 max
Zn	0.10 max
Cu	0.10 max
Ti	0.06 – 0.20 max
Mn	0.05 – 0.20
Al	Remainder
Mg	4.5 – 5.5
Be	0.0003
Other	0.05 each – 0.15 max total

Deposited chemistry is influenced by many factors, so no typical analysis can be reported.

DEPOSITED ALL WELD METAL PROPERTIES % (AS-WELDED) | CHARPY-V-NOTCH IMPACT PROPERTIES %

Deposited all weld metal properties are influenced by many factors such as weld process used, so no typical weld metal properties can be reported.

CHARPY-V-NOTCH IMPACT
Not applicable

RECOMMENDED OPERATION OF WELDING RODS

EXAMPLE	GMAW (MIG)	GTAW (TIG)
Diameter	.030	All diameters (AC) or DCEP for thin gauge
Amps (DC)	120–150	
Volts	20–24	
Gas	Argon 30 CFH	Argon or Argon + Helium for thick base metal
Travel Speed	24–30 IPM	

APPLICATION

COREWELD 5356 ER5356 materials are used mainly for welding aluminum of like composition. This type is also useful if color match is important after anodizing.

– The proper choice of aluminum filler metal mainly depends on the base metal properties to be achieved and welding technique. Post weld cracking, corrosion resistance and behavior under elevated temperature also need to be taken into consideration.

– Cracking usually can be minimized by choosing a filler metal alloy of higher alloy content than the base metal.

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