

SMT-5356(H)

Type : MIG/TIG

Conformances

AWS A5.10/ ASME SFA5.10 ER5356
 EN ISO 18273 S Al 5356 (AlMg5Cr(A))
 DNV-GL 5356

Applications

- Used for welding casting Al-Mg alloys with maximum 5% Magnesium and parts of wrought alloy of 5000 series, 6000 and 7000 series.

Features

- ER5356 is a about 5% Magnesium Aluminum filler metal which has high strength, high corrosion resistance, and matches the color well with the parent metal after anodizing
- SMT-5356H is used for shipbuilding, automobile, railway parts industry, etc. because it has excellent feedability by controlling impurities

Welding Position

Current

GMAW: DC+(Pulse)
 GTAW: DC-

Shielding Gas

Ar, Ar+He

Diameter / Packaging

Diameter	MIG	TIG
mm (in)	12.5kg (27.6lbs)	5kg (11lbs)
1.0 (0.039)	√	
1.2 (0.045)	√	
1.6 (1/16)	√	√
2.0 (5/64)		√
2.4 (3/32)		√
3.2 (1/8)		√

Typical Chemical Composition of the Wire (%)

	Si	Fe	C	Mn	Mg	Cr	Zn	Ti	Al
SMT-5356(H)	0.07	0.14	0.005	0.11	4.7	0.11	0.01	0.08	Rem

Typical Mechanical Properties of All-Weld Metal

YS	TS	EL	Temp	CVN-Impact Value
Mpa(lbs/in ²)	Mpa(lbs/in ²)	(%)	°C(°F)	J (ft.-lbs)
-	≥275 (≥39,700)	≥17		

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX