



# MIG ALG5

Old reference: MIG AlMg5

## Classification

ISO 18273 : S Al 5356 (AlMg5Cr)  
 AWS A5.10 : ER5356

Material N° : 3.3556

## Description & Applications

Solid wire for GMAW used to weld Aluminium alloys with more than 3% Mg, up to 5 % of Mg. Very often used in marine construction for their excellent resistance to salt water corrosion and for their very good mechanical characteristics, but also in the railway sector for the welding of wagons to transport phosphate, and also in the road sector for trucks and tractors.

### Base material:

Alloy	DIN	Material N°.
5056	Al Mg5	3.3555
5083	Al Mg4.5	3.3345
5086		
5454		
5754		
6005 A		

## Typical Chemical Composition ( % )

Si	Fe	Cu	Mn	Mg	Zn	Cr	Ti	Al
0.06	0.17	0.004	0.15	4.8	0.01	0.12	0.08	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
130	300	29

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	60-120	18-22	Ar/He: 18-20 l/min Argon: 18-20 l/min
	1.0	100-150	18-25	
	1.2	130-250	18-27	
	1.6	170-250	20-27	

Ind.10



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