Inweld Aluminum 5356

AWS A5.10 ER5356

Chemical Composition of Inweld Aluminum 5356

Fe	Al	Cr	Ni	Mg	Mn	Si	Zn	Ti	Cu	Other
0.40	Balance	0.05-0.20	---	4.5-5.5	0.05-0.20	0.25	0.10	0.06-0.20	0.10	

Single values are maximum unless otherwise specified.

Description and Applications

Inweld 5356 is a 5% magnesium alloyed aluminum welding wire. A great general purpose filler alloy, designed for the welding of 5XXX series alloys, when 40 KSI tensile strength is not required. Excellent color match after anodizing. Inweld 5356 offers much netter corrosion resistance when exposed to salt water. Average tensile strength as welded is 28,000 psi.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	39,000 psi
Yield Strength:	19,000 psi
Elongation:	17%

Recommended Parameters

GMAW (DCEP – Electrode+)

Wire Diameter	Voltage	Amperage	Wire Feed IPM
0.030”	15-24	60-175	25-45
0.035”	15-27	70-185	25-40
3/64”	20-29	125-260	24-35
1/16”	24-30	170-300	28-38
3/32”	26-31	275-400	14-20

GTAW (DCEN – Electrode-)

Filler Wire Size	Tungsten Dia.	Voltage	Amperage	Argon (CFH)
1/16”	1/16”	15	60-80	20
3/32”	3/32”	15	125-160	20
1/8”	1/8”	15	190-220	20
5/32”	5/32”	15	200-300	25
3/16”	3/16”	15-20	330-380	25
¼”	¼”	25	400-450	25