



**DATA SHEET**  
**DS 139**  
**Rev. 0 dd 15/05/2014**  
**INETIG AL5%MG – 5356**

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**CLASSIFICATION**

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.10: ER5356	EN ISO 18273: S AlMg5Cr(A)
AWS A 5.10M: R5356	EN ISO 18273: S Al 5356
ASME SFA 5.10: ER5356	
ASME SFA 5.10M: R5356	

**APPROVALS**


**ALLOY TYPE**

5356 for welding aluminum alloy containing 5% magnesium.

**APPLICATIONS**

Tig rod designed for welding aluminum alloys with a magnesium content up to 5%. It finds application in car and rail fabrication and electro - domestic appliance. The weld material shows an excellent resistance to corrosion. To be used under the shield of Argon.

**MATERIALS TO BE WELDED**

ASTM	EN	Others
	(DIN 1725-1: AlMg3)	EN AW 5754 - AlMg3
	(DIN 1725-1: AlMg4,5)	EN AW 5056A - AlMg5
	(DIN 1725-1: AlMg5)	EN AW 6061 - AlMg1SiCu
	(DIN 1725-1: AlMg2Mn0,8)	
	(DIN 1725-1: AlMg4Mn)	
	(DIN 1725-1: AlZn4,5Mg1)	
	(DIN 1725-2: G-AlMg3)	
	(DIN 1725-2: G-AlMg3Si)	
	(DIN 1725-2: G-AlMg5)	
	(DIN 1725-2: G-AlMg5Si)	

**WELDING GUIDELINES**

PWHT is not required.

**TECHNICAL INFORMATION**

Gas: Argon (EN ISO 14175)  
Welding positions: all positions





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**TYPICAL CHEMICAL COMPOSITION OF WIRE**

Mn %	Si %	Cu %	Cr %	Ti %	Mg %	Zn %	Fe %	Al.	
0.15	0.05	0.01	0.14	0.10	5.00	0.01	0.13	Bal.	

**TYPICAL MECHANICAL PROPERTIES**

GAS		Yield strength	Tensile strength	Elongation on % 5d
		Rs	Rm	A 5d
		(MPa)	(MPa)	%
Argon	as welded	120	250	18

**PRODUCTS AVAILABLE**

Process	Product	Classification AWS	Classification EN
MIG/MAG	INEFIL AL5%MG - 5356	AWS A 5.10: ER5356	EN 18273: S AlMg5Cr(A)
Solid wire			
TIG			
Rods			
SMAW			
Electrodes			