

PRODUCT DATA SHEET

Afrox Filmax 5356 Afrox TIG 5356

Afrox Filmax 5356 and Afrox TIG 5356 are 95% aluminium, 5% magnesium wires for general purpose welding of the 5XXX series alloys when 40 000 psi (276 MPa) is not required. Afrox Filmax 5356 is suitable for spray arc and pulsed arc transfer using high purity argon on thin sections or an argon/helium mixture (Alushield®) as a shielding gas on thicker sections. Flow rates of 15-20 l/min should be used. Afrox TIG 5356 should be used with a zirconiated tungsten electrode with pure argon

or an argon/helium mixture (Alushield®) for thick sections, at flow rates of 10-15 l/min. For oxy-acetylene gas welding, a neutral flame should be used with aluminium welding flux (Item Number W001777).

Applications

Applications found in the construction of ships, bulk container, railway and the automotive industries.

Classifications

AWS	A5.10	ER5356
EN	18273	Al5356 (AlMg5Cr)

Typical Chemical Analysis (Wire analysis)

% Silicon	0,25 max	% Zinc	0,1 max
% Iron	0,4 max	% Titanium	0,07-0,15
% Copper	0,05 max	% Beryllium	0,0008 max
% Manganese	0,1 - 0,2	% Aluminium	Bal.
% Magnesium	4,5 - 5,6	% Chromium	0,1 - 0,3

Typical Mechanical Properties (All weld metal in the as welded condition)

0,2% Proof Stress	240 MPa
Tensile Strength	125 MPa
% Elongation on 5d	17

Packing Data

MIG			TIG			
Diameter (mm)	Pack Mass (kg)	Item Number	Diameter (mm)	Pack Mass (kg)	Consumable Length (mm)	Item Number
0,8	7,0	W077541	1,6	2,0	1 000	W030522
1,2	7,0	W033175	2,4	2,0	1 000	W030520
1,2	0,5	W033153	3,2	2,0	1 000	W030521
1,6	7,0	W033176	-	-	-	-

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