



Changzhou Giant Welding Co.,Ltd
www.giantweld.com

Standard AWS A5.10 ER5356	Chemical Composition %										
	Si	Fe	Cu	Mn	Zn	Mg	Cr	Ti	AL	Other Each	Other Total
Grade ER5356	≤ 0.25	≤ 0.4	≤ 0.1	0.05 – 0.2	≤ 0.1	4.5 – 5.5	0.05 – 0.2	0.06 – 0.2	Rest	≤ 0.05	≤ 0.15
Type	Spool (MIG)						Tube (TIG)				
Specification (MM)	0.8、 0.9、 1.0、 1.2、 1.6、 2.0						1.6、 2.0、 2.4、 3.2、 4.0、 5.0				
Package	S100/0.5kg S270,S300/6kg-7kg						S200/2kg S360/20kg	5kg/box	10kg/box	length :1000MM	
Mechanical Properties	Fusion Temperature ℃		Electrical IACS		Density g/mm3		Tensile Mpa		Yield Mpa		Elongation %
	574 – 638		29%		2.64		250 – 300		120 – 160		15 – 25
	Diameter (MM)		1.2			1.6			2.0		
MIG Welding	Welding Current - A		180 – 300			200 – 400			240 – 450		
	Welding Voltage- V		18 – 28			20 – 24			22 – 34		
TIG Welding	Diameter (MM)		1.6 – 2.4			2.4 – 4.0			4.0 – 5.0		
	Welding Current - A		150 – 250			200 – 320			220 – 400		
Performance characteristics	It is also called HS331, an aluminum alloy welding wire containing 5% magnesium. It has good corrosion resistance, thermal cracking resistance, high strength and good Forgability; The weld formation is beautiful and fine, the spatter is little, and the anodizing treatment is white; Can provide good color matching, is a widely used general purpose welding materials。										
Application	It is also used in the welding of aluminum, silicon, magnesium, aluminum, zinc and magnesium alloy and the repair welding of aluminum and magnesium alloy castings.										
Notice	1、 The product can be kept for two years under the condition of factory packing and sealed, and the packing can be removed for three months under the usual atmospheric environment. 2、 Products should be stored in a ventilated, dry and place. 3、 After the wire is removed from the package, it is recommended that appropriate dust proof cover be applied over the wire.										

