ALUROD AlMg5

OERLIKON

ALUROD AlMg5 is a 5356 type aluminum solid TIG welding rod depositing Al-5Mg weld metal. Suitable for use with Ar, or Ar+He mixed shielding gases.

ALUROD AlMg5 is used for the welding of Al-Mg alloys and Al-Mg-Zn alloys. The rod is also suitable for the welding of dissimilar aluminium alloy grades containing up to 5%Mg and components which are subsequently to be anodised.

ALUROD AlMg5 is the most widely used Al welding wire, because of the weld metals high yield strength and high resistance to corrosion, including seawater.

Classification	
EN ISO	18273: S Al 5356
AWS	A5.10: ER 5356

Approvals	Grade
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

Al	Si	Mn	Mg	Cr	Ti	Cu	Fe
Rem	0.2	0.1	5	0.1	0.1	0.1	0.3

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
As Welded	≥ 110	≥ 240	≥ 17

Gas test: 100% Ar
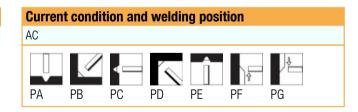
Shielding Gas - EN ISO 14175 : I1

Materials

Al Mg 1SiCu, Al Mg Si 0,7;

Al Mg 3, Al Mg 5, Al Zn 4,5 Mg 1;

G-Al Mg 3Si; G-Al Mg 5Si

Storage
Keep dry and avoid condensation

Current condition and welding position
AC

PA   PB   PC   PD   PE   PF   PG

Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
2.0	TUB	5	●
2.4	TUB	5	●
3.2	TUB	5	●
4.0	TUB	5	●

AIR LIQUIDE WELDING