

BOC Aluminium MIG Wire 5356

Welding characteristics

- Excellent corrosion resistance and high strength
- Triple shaved for smoother feeding and consistent contact

Applications

- Used to weld aluminium magnesium base metal alloys with a maximum of 5% Mg. Suitable for a wide range of 3XXX, 5XXX, 6XXX and 5XX series
- Applications in ship building, storage tanks, railways and the car industry

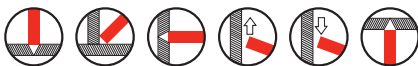
Classifications

AS 2717.2 E5356
AWS/ASTM A5.10 ER5356
DIN 1732 SG.AL Mg 5
BS 2901 Pt.4 5356

Approvals

Lloyds Register of Shipping	D O BF 5083-OandF S NA
American Bureau of Shipping	AWS A5.10.92
Det Norske Veritas	AlMg5 / 11
BV	

Welding positions



Recommended shielding gases

Alushield® Light
Alushield® Heavy
Welding Grade Argon

Mechanical properties – all weld metal

	Typical as welded
Yield strength (Rm)	110
Tensile strength (MPa)	240
Elongation (%)	17

Chemical composition, wt% – all weld metal

	Si	Fe	Cu	Mn	Mg	Zn	Ti
Min.				0.10	4.5		0.07
Typical	<0.25	<0.40	<0.05			<0.10	
Max.				0.30	5.6		0.15

Packing and welding data

Dia. (mm)	Current (A)	Voltage (V)	Weight/spool (kg)	Part No.
0.8	50–150	14–21	0.5	S530805
0.8	50–150	14–21	5.0	S530850
0.9	80–180	16–22	0.5	S530905
0.9	80–180	16–22	2.0	S530920
0.9	80–180	16–22	6.0	S530960
1.0	110–220	17–23	0.5	S531005
1.0	110–220	17–23	2.0	S531020
1.0	110–220	17–23	6.0	S531060
1.2	150–250	20–25	0.5	S531205
1.2	150–250	20–25	2.0	S531220
1.2	150–250	20–25	6.0	S531260

WARNING Welding can give rise to electric shock, excessive noise, eye and skin burns due to the arc rays, and a potential health hazard if you breathe in the emitted fumes and gases. Read all the manufacturer's instructions to achieve the correct welding conditions and ask your employer for the Materials Safety Data Sheets. Refer to www.boc.com.au or www.boc.co.nz