



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
6056/7056
ER5356

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A5.10 ER5356

DIN 1732: SG-Al Mg 5

FEATURES & APPLICATIONS

APPLICATIONS:

ER5356 is a general purpose type aluminum alloy, which is typically chosen for its relatively high shear strength. It also offers excellent corrosion resistance when exposed to sea water. It is used for welding 5000 series aluminum base metals. Typical applications include automotive panels, truck/trailer frames, cargo tanks, ship structures and architectural structures.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Be	Al
.04	.06	0.0	.12	4.86	.12	.002	.09	.0002	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	39,000 psi (269 N/mm ²)
Yield Strength	19,000 psi (131 N/mm ²)
Elongation	17%

WELDING PARAMETERS & PROCEDURES

Parameters: (DC Reverse Polarity) Electrode Positive Spray Transfer

Typical GMAW (MIG) Welding Procedures:

Wire Diameter	Metal Thickness	Amps	Volts	Argon (cfh)
.030"	1/16"	70-110	15-20	25
.030-3/64"	1/8"	120-150	20-24	30
.030-3/64"	3/16"	130-210	22-26	30-35
3/64"-1/16"	1/4"	170-225	24-28	40
1/16"	3/8"	225-300	26-29	50

Parameters: (AC)

Typical GTAW (TIG) Welding Procedures:

Wire Diameter	Metal Thickness	Amps	Volts ACHF	Gas Cup	Argon (cfh)
1/16"-3/32"	1/16"	70-100	15	3/8"	20
1/8"-5/32"	1/8"	125-175	15	7/16"	20
5/32"-3/16"	3/16"	170-225	15	1/2"	25
3/16"	1/4"	220-275	15	5/8"	30