

# SUPERGLAZE® HD 5356

Aluminum ▪ AWS ER5356

## KEY FEATURES

- Designed for heavy duty applications
- Reduced shavings and improved feedability
- General purpose filler alloy for welding 5XXX series alloys

## WELDING POSITIONS

All

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH for Argon

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

<b>SFA/AWS A5.10/A5.10M:</b>	ER5356
<b>ABS:</b>	WB/I-1
<b>Lloyd's Register:</b>	WB/I-1
<b>DNV Grade:</b>	5356/I-1
<b>ISO 1B273:</b>	S Al 5356 (ALMg5CrCA1)

## TYPICAL APPLICATIONS

- Ideal for aggressive work environments and applications with long conduit lengths
- Automotive bumpers and supports
- Structural frames in the shipbuilding industry
- Formed truck panels
- Railcars
- Power industry
- Trailer manufacturing

## DIAMETERS / PACKAGING

Diameter in (mm)	16 lb (7.3 kg) Steel Spool	20 lb (9.1 kg) Plastic Spool	60 lb (27.2 kg) Mini-Drum	300 lb (136 kg) Gem-Pak™ Box
0.035 (0.9)	ED035672	ED035673		ED036335
3/64 (1.2)	ED035674	ED035675	ED036595	ED036336
1/16 (1.6)	ED035676	ED035677		ED036337

## WIRE COMPOSITION<sup>(1)</sup> – As Required per AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER5356	Remainder	0.25 max	0.40 max	0.10 max	0.05-0.20
<b>Typical Results</b> <sup>(2)</sup>	Remainder	0.05	0.09	0.03	0.12
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER5356	4.5-5.5	0.05-0.20	0.10 max	0.06-0.20	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	4.9	0.08	<0.01	0.15	0.0002

<sup>(1)</sup>Typical wire chemistry. <sup>(2)</sup>See test results disclaimer

*Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at [www.lincolnelectric.com](http://www.lincolnelectric.com)*

#### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

#### CUSTOMER ASSISTANCE POLICY

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