

# SUPERGLAZE® 5356 TM™

Aluminum ▪ AWS ER5356

## KEY FEATURES

- Unparalleled bead profile and appearance which are critical for groove and fillet welds on aluminum trailer beds.
- SuperGlaze® 5356 TM™ has an engineered chemical composition developed specifically to outperform standard ER5356 electrodes and gives the operator unprecedented control.
- Proprietary manufacturing processes give SuperGlaze® 5356 TM™ the smoothest surface finish in the industry, making it ideal for automatic applications on formed truck panels.

## WELDING POSITIONS

All, except vertical down

## NOTE

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

## CONFORMANCES

<b>SFA/AWS A5.10/A5.10M:</b>	ER5356
<b>ASME SFA-A5.10:</b>	ER5356
<b>CWB/CSA W48-06:</b>	ER5356

## TYPICAL APPLICATIONS

- High speed groove welds on formed truck panels
- Multi-pass fillet and lap welds on 6XXX series base materials
- Robotic fillet welds on trailer tanks requiring minimal post-weld clean up

## SHIELDING GAS

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

## DIAMETERS / PACKAGING

Diameter in (mm)	1 lb (0.4 kg) Plastic Spool 20 lb (9.1 kg) Master Carton	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™
0.035 (0.9)	ED034064	ED034067			ED034723
3/64 (1.2)	ED034065	ED034068	ED034070	ED036594	ED034724
1/16 (1.6)	ED034066	ED034069	ED034071		ED034729

## WIRE COMPOSITION<sup>(1)</sup> – As Required per SFA/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<sup>(2)</sup></b>	Remainder	0.065	0.15	0.0035	0.125
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> – AWS ER5356	4.50 - 5.50	0.05 - 0.20	0.10 max	0.06 - 0.20	0.0003 max
<b>Typical Results<sup>(2)</sup></b>	4.565	0.11	0.0075	0.085	0.0002

<sup>(1)</sup>Typical all weld metal. <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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