

JACKSUN ALLOY-5356

ALUMINIUM FILLER WIRE WITH 5% MAGNESSIUM

BASIC ALLOY: AL, MG,
AWS/SFA-5.10: ER5356
UNS A95356

KEY FEATURES:

Roalloy-5356 is a 5% magnesium, all position, non-heat treatable wire which is chosen for its relatively high shear strength. In addition, it also offers excellent corrosion resistance when exposed to salt water.

APPLICATIONS

- Boats, Ships
- Trucks
- Automotive
- Bicycles
- Pressure Vessels
- Equipments

SHEILDING GAS:

- Welding with 100% Ar gas

WELDING NOTE:

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded

CHEMICAL COMPOSITION:

Si	Mn	Mg	Cr	Al	Others
0.25	0.05-0.20	4.50-5.50	0.05-0.20	Remainder	0.15
Fe	Zn	Ti			
0.40	0.10	0.06-0.20			

MECHANICAL PROPERTIES:

UTS (N/mm)	Proof strength (N/mm2)	EL % (l=5d)
200-310	83-207	10-18

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR MIG WELDING)

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	✓	✓	X
1.20	0.047	150-300	24-34	15-25	✓	✓	✓
1.60	1/16"	150-350	28-36	15-30	✓	✓	✓

DIEMENSION, CURRENT CONDITION & PACKING DATA (FOR TIG WELDING)

Size (mm)	Size (inch)	Length (mm)	Length (Inch)	Current Condition (DC-)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	✓	✓
2.0	5/ 64"	1000	36"	50-100	12-18	✓	✓
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	✓	✓
3.2	1/ 8"	1000	36"	100-150	16-24	✓	✓