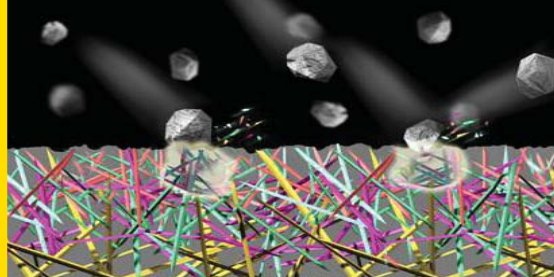


Premium Gas Shielded Wire for High Strength Welding of Aluminum

5356 FW - Alum



WIRE

- High deposition rate reduces labor expenses
- Weld deposits are extremely tough and impact resistant
- General purpose, easy to use wire



DESCRIPTION:

5356 FW-Alu is specially formulated to be a general-purpose, high strength aluminum welding wire for welding selected grades of wrought and extruded aluminum alloys.

TECHNICAL DATA:

Typical Tensile Strength 28,000 Psi
Typical Yield Strength: 12,000 Psi
Typical Elongation: 39%
Power Source Type: Constant voltage & Integrated Wire Drive
Current & Polarity: DC (+) electrode positive

PROCEDURE FOR USE:

Caution: Although a 2-roll wire drive assembly will work the optimum for maintaining arc voltage stability and consistent and smooth wire feeding is a smooth or “U-groove” 4-roll drive assembly. **Serrated drive rolls are not recommended!**

Step 1: Remove all “old” cracked or spalled weld metal down to a sound base.

Step 2: FW-Aluminum is unlimited build-up.

Step 3: Preheat the part to be hardfaced/joined depending on the wrought alloy type.

Step 4: After checking that the welding conditions are optimal by testing on scrap metal, position the gun head at a 70-80° angle and use a “push” technique for downhand welding. For fully automated welding such as hardfacing cement crusher rolls, the wire should exit at about a 10° lagging angle from top dead center. Using this technique will assure a smooth and regular weld deposit profile with the optimum level of fusion.

Note: If welding is interrupted and the part being welded cools to room temperature, make sure to reheat to the original preheat temperature. For hardenable steels slow cooling is advised using silicone blankets, vermiculite, or other environmentally suitable heat-retardant material.

PARAMETERS

DIAMETER	VOLTAGE	AMPERAGE	STICK-OUT	SHIELDING GAS	FLOW RATE
1/16” (1.6mm)	21-28	150-250	1/2” - 1/16” (Long nozzle)	Argon	30-35 SCFH

Note: Parameter adjustments will be needed depending on the size, weight, and shape of the part to be welded. For optimum wear resistance keep to the low end of the amperage & voltage ranges

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