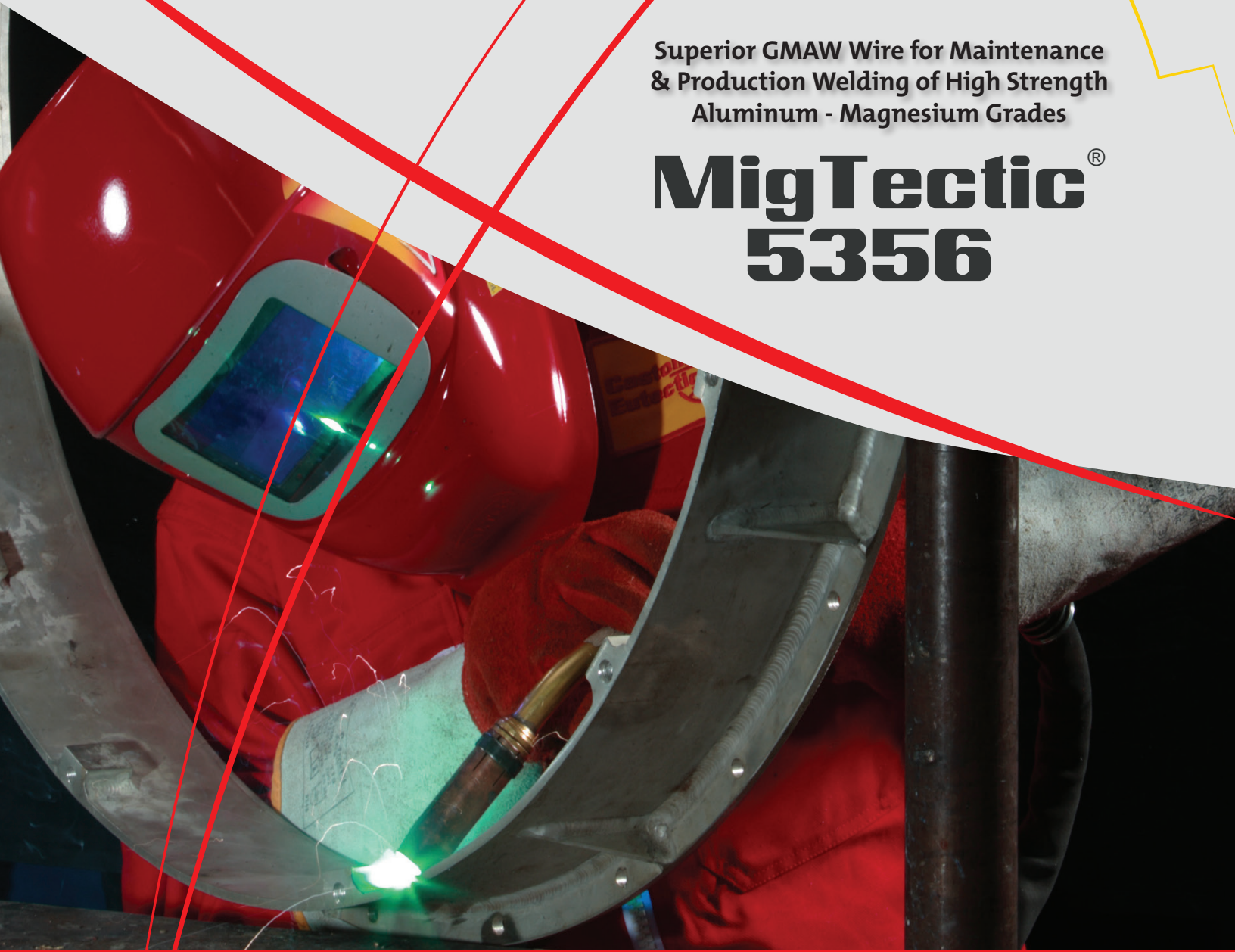




Superior GMAW Wire for Maintenance
& Production Welding of High Strength
Aluminum - Magnesium Grades

MigTectic® 5356



- Excellent for joining extruded and structural tubing
- Dense and smooth deposit
- Easy to use, forgeable, machinable
- Good color match even after anodization
- Good bead appearance and uniform fusion

MigTectic® 5356

MigTectic 5356 is a gas metal-arc welding alloy for aluminum which provides for a cosmetically clean and oxide-free weld deposit. No post-weld clean up is necessary. Alloys can be used in all positions depending on the skill of the welder. Smooth running. Deposits are porous-free with a uniform profile.

MigTectic 5356 is recommended when welding the high strength aluminum-magnesium grades (5xxx group). Also suitable for grade 6061. Can be used for both joining and cladding.

TECHNICAL DATA

Typical Values

Tensile Strength:	35,000 psi (240 N/mm ²)
Hardness:	75 BHN
Electrical Conductivity:	IACS 41
Shielding Gas:	100% Argon
Color Match Properties:	Good
Current & Polarity:	AC with imposed high frequency

Diameter	Item Code	Gas Flow	Amperage	Voltage
1.6 mm (1/16")	M5356-09.9.091k	30-35	70-185	15-27
2.4 mm (3/32")	M5356-12.9.091k	35-45	125-260	20-29
3.2 mm (1/8")	M5356-16.9.091k	45-75	170-300	24-30

PROCEDURE FOR USE

PREPARATION:

Clean weld area. Preheat heavy sections within a range of 500-800°F for non-heat treated alloys. Adjust argon shielding gas flow. Complex or large parts should be supported by tack-welds and jigs. Adjust standoff distance so that the molten pool is always protected by the shielding gas and allow the rod-end to solidify before removing it from the gas envelope.

TYPICAL APPLICATIONS

MigTectic 5356 is used for fabrications involving 5xxx series alloys where good strength and improved anodized color match are required: repair and maintenance of sheet aluminium, office furniture, appliances, structural components, extruded shape and tube.

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.



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