



5356 – PRODUCT DATA SHEET

Nexalloy 5356 is a 5% magnesium all position non-heat treatable wire used to weld the 5XXX series alloys with some common welding applications such as boats, ships, bicycles, trucks, pressure vessels, automotive parts and equipment.

NEXAL WELDING PRODUCTS APPROVALS AND SPECIFICATIONS

AWS A5.10 classification ER5356, R5356 Canadian Bureau of Welding - CWB American Bureau of Shipping - ABS

Chemical Composition (weight %)

Aluminum	Remainder	Silicon	0.25 Max
Manganese	0.05-0.20	Magnesium	4.5-5.5
Iron	0.40 Max	Chromium	0.05-0.20
Copper	0.10 Max	Titanium	0.06-0.20
Beryllium	0.0003 Max	Zinc	0.10 Max

Other Elements 0.05 Max & Total 0.15 Max

Typical Properties

Melting Range	1060 – 1175 F	571 – 635 C
Density	.096 lbs\cu in.	
Post Anodize Color	White	

TIG Rods – 5LB/2.2KG, 10LB/4.5KG, 50LB/22.6KG

TIG Welding Procedures: ACHF- with Pure or Ziconiated Hemisphere shape tungsten tip

Base Thickness	Filler Wire Size	Tungsten	Amps	Consumption LB/100FT	Gas Cup Size	Argon(cfh)
1/16"	1/16"	1/16"	60-80	0.75	3/8"	20
3/32"	3/32"	3/32"	85-120	1.00	3/8"	20
1/8"	3/32"	3/32"	125-160	1.50	3/8"	20
3/16"	1/8"	1/8"	190-220	4.5-6.0	7/16"	25
1/4"	5/32"	5/32"	200-300	8-10	1/2"	30
3/8"	3/16"	3/16"	330-380	15-20	5/8"	35
1/2"	1/4"	1/4"	400-500	25-40	5/8"	40

Nexal Aluminum Inc.
www.nexalloy.com

5938 Ambler Drive Mississauga, ON L4W 2N3
An ISO 9001:2008 Certified Company

Phone: 1-905-629-8282
Fax: 1-905-629-8532

The data and information contained or referenced is presented as typical results without guarantee or warranty and Nexal expressly disclaims liability incurred of any kind with reliance thereon

Aluminum Manufacturing since 1973