



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

Typical Properties

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

Other Elements 0.05 Max & Total 0.15 Max

Wire and Rod Diameters Available

0.030 0.035 3/64" 1/16" 3/32" 1/8" 5/32" 3/16" 1/4" 5/16

Packaging Available

Plastic Spools – 1LB/0.4KG, 5LB/2.2KG, 10LB/4.5KG, 16LB/7.2KG, 20LB/9KG

Metal Spools – 10LB/4.5KG, 15LB /6.8KG

Drums – 150LB/68KG, 300LB/136KG

MIG Welding Procedures: DCEP

Wire Diameter	WFS ipm	Amps	Volts	Consumption LB/100FT	Argon(cfh)
0.030	480-625	60-175	15-24	0.65-1.25	25-30
0.035	450-750	70-185	15-27	1.00-4.25	30-35
3/64"	330-500	125-260	20-29	1.00-4.25	35-45
1/16"	250-450	170-300	24-30	3.8-66	45-75
3/32"	160-200	275-400	26-31	35-66	60-85

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