

SUPERGLAZE® 5356

Aluminum ■ AWS ER5356

KEY FEATURES

- General purpose filler alloy for welding 5XXX series alloys
- The most widely used welding alloy

WELDING POSITIONS

All, except vertical down

SHIELDING GAS

100% Argon
Argon / Helium Mixtures
Flow Rate: 30 - 50 CFH

NOTE

- Typical Operating Procedures on pg. I-15 - I-16

CONFORMANCES

SFA/AWS A5.10:	ER5356
ASME SFA-A5.10:	ER5356
Lloyd's Register:	WB/I-1 S
DNV Grade:	5356
GL:	RAIMg4
BV Grade:	WB
CWB/CSA W48-06:	ER5356

TYPICAL APPLICATIONS

- Automotive bumpers and supports
- Structural frames in the shipbuilding industry
- Formed truck panels
- Railing Industry
- Power Industry
- Trailer Manufacturing

DIAMETERS / PACKAGING

Diameter in (mm)	1 lb (0.4 kg) Plastic Spool 20 lb (9.1 kg) Master Carton	16 lb (7.3 kg) Platic Spool	20 lb (9.1 kg) Plastic Spool	60 lb (27.2 kg) Mini-Drum	300 lb (136 kg) Accu-Pak® Box	300 lb (136 kg) Gem-Pak® Box
0.035 (0.9)	ED030312	ED028385		ED036720	ED033178 ^(a)	ED034722
3/64 (1.2)	ED030314		ED030282	ED036593	ED031826 ^(b)	ED034550
1/16 (1.6)			ED030283	ED036721	ED030985 ^(b)	ED034551

^(a)This part number is Made-To-Order. ^(b)Wire payoff kit K2860-1 sold separately.

WIRE COMPOSITION⁽¹⁾ – As Required per SFA/AWS A5.10

	%Al	%Si	%Fe	%Cu	%Mn
Requirements - AWS ER5356	Remainder	0.25 max	0.40 max	0.10 max	0.05 - 0.20
Typical Results ⁽²⁾	Remainder	0.05	0.09	0.03	0.12
	%Mg	%Cr	%Zn	%Ti	%Be
Requirements - AWS ER5356	4.50 - 5.50	0.05 - 0.20	0.10 max	0.06 - 0.20	0.0003 max
Typical Results ⁽²⁾	4.90	0.08	< 0.01	0.15	0.0002

⁽¹⁾Typical all weld metal. ⁽²⁾See test results disclaimer

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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