



# Alumi Glide™ ALUMINUM WELDING WIRE

## 5356 – PRODUCT DATA SHEET

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.

### Welding Products Approvals/Specifications

AWS A5.10 classification ER5356, R5356  
Canadian Bureau of Welding – CWB A5.10  
ISO 9001:2008

### 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

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

### 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

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