

Solid Wire Electrode for MIG/MAG Welding

BA-MIG AlMg5

Classification: ISO 18273: S Al 5356 (AlMg5Cr)
SFA-5.10: ER5356

Main Application:

BA-MIG AlMg5 is a solid wire electrode for GMAW with 5% Mg. Suitable for welding Al Mg-and Al Mg Si- alloys. Excellent welding characteristics and good mechanical properties. High corrosion resistance. Applications in shipbuilding, storage tanks, railway and car industry.

Typical analysis and chemical composition acc. to ISO 18273 and AWS A5.10:

(Weight Percent)

Wire electrode	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al
Typical analysis BA-MIG AlMg5	0.05	0.12	0.01	0.13	4.7	0.08	0.010	0.10	Rem
S Al 5356 acc. to ISO 18273	0.25	0.4	0.1	0.05- 0.20	4.5-5.5	0.05- 0.20	0.1	0.06- 0.20	Rem
ER5356 acc. to AWS A5.10	0.25	0.4	0.1	0.05-0.2	4.5-5.5	0.05- 0.20	0.1	0.06- 0.20	Rem

All - Weld Metal Mechanical Properties / Welding Data:

Heat Treatment	As Welded
Yield Strength Re, N/mm ² (ksi)	110 (16)
Tensile Strength Rm, N/mm ² (ksi)	> 240 (35)
Elongation A5 [%]	> 18
Impact Energy ISO-V, J (ft lbs)	
Current/polarity	DC +
Shielding Gas	ISO 14175: I1, I2, I3

Base Materials:

Al Mg Si 1, G-Al Mg 5, G-Al Mg 3 Si, Al Mg 5, Al Mg2 Mn 0,8, G-Al Mg 5 Si, Al Mg 3, Al Zn 4,5 Mg 1, G-Al Mg 3

Package Forms:

Spools BS300/7 kg, D200/2 kg, and drums as standard package forms for GMAW wire electrodes.

Diameter:

0,8 – 1,6 mm. Sizes and tolerances acc. to ISO 544 and AWS A5.10.

Wire Electrode Surface:

Smooth finish free from surface defects and foreign matter.