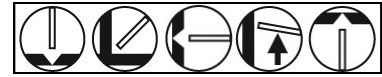


Hobart® Maxal® 5356



AWS A5.10: ER5356, R5356

WELDING POSITIONS:



FEATURES:

- High strength (38 ksi typical)
- High ductility/fatigue strength/very high toughness
- Moderate ductility/formability
- Lower electrical conductivity and thermal conductivity

BENEFITS:

- Higher column strength/better feedability
- Very good color match after anodizing with 5xxx/6xxx base materials

APPLICATIONS:

- 5086 and lower strength alloys (35 ksi minimum UTS)
- Truck frames
- Shipbuilding
- Rail cars/Bus panels

SHIELDING GAS: 100% Argon (Ar) or Argon/Helium mixtures, typical: GMAW - 35-50 cfh (14-24 l/min), GTAW 20-30 cfh (10-14 l/min).

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP) for GMAW, AC for GTAW

STANDARD DIAMETERS: 0.035" (0.9 mm), 3/64" (1.2 mm), 1/16" (1.6 mm), 3/32" (2.4 mm), 1/8" (3.2 mm), 5/32" (4.0)

STORAGE: Product should be stored in a dry, enclosed environment, and in its original intact packaging

TYPICAL CHEMICAL VALUES*:

Weld Metal Analysis (%)	ER & R 5356
Silicon (Si)	0.25
Iron (Fe)	0.40
Copper (Cu)	0.10
Manganese (Mn)	0.05-0.20
Magnesium (Mg)	4.5-5.5
Chromium (Cr)	0.05-0.20
Zinc (Zn)	0.10
Titanium (Ti)	0.06-0.20
Beryllium (Be)	<0.0003
Others Each	0.05
Others Total	0.15
Aluminum (Al)	Remainder

*Unless noted-single values are maximums.

TYPICAL PROPERTIES:

Melting Range	Density	Electrical/Thermal Conductivity
1060-1175°F	0.096 lbs/in ³	29% IACS/820 EU

As Welded UTS Typical	Anodized Color	Elevated Temp. Applications +150°F
38 ksi	White	NO

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with AWS A5.10 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers LLC.

Hobart® Maxal® 5356

Diameter		Base Material Thickness		Amps	Volts	Wire-Feed Speed
Inches	(mm)	Inches	(mm)	5xxx	5xxx	(ipm) 5xxx
0.035	(0.9)	1/16	(1.6)	100	21	350
0.035	(0.9)	1/8	(3.2)	140	22	450
0.035	(0.9)	1/4	(6.4)	180	23	600
3/64	(1.2)	3/32	(2.4)	120	24	220
3/64	(1.2)	1/8	(3.2)	160	25	330
3/64	(1.2)	1/4	(6.4)	220	25	370
3/64	(1.2)	3/8	(9.5)	230	25	450
1/16	(1.6)	1/4	(6.4)	210	24	200
1/16	(1.6)	3/8	(9.5)	240	25	230
1/16	(1.6)	1/2	(12.7)	270	26	270
1/16	(1.6)	3/4	(19.1)	290	27	300
1/16	(1.6)	1	(25.4)	310	28	320

Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of aluminum being welded.

See Above: This information was determined by welding using 100%Argon shielding gas with a flow rate between 35-50 cfh (14-24 l/min).

AVAILABLE DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543 or (937) 332-5188 for International Customer Service.

Diameter	1-lb. (0.45 kg)	16-lb. (7.3 kg)	16-lb. (7.3 kg)	22-lb. (10 kg)	32-lb. (14.5 kg)	100-lb (45 kg)	300-lb. (136 kg)	10-lb. (4.5 kg)
Inches (mm)	Plastic Spool	Plastic Spool	Wire Basket	Plastic Spool	Plastic Spool	Drum	Drum	Tube, 36-In Long Cut Length TIG Rod
Net Pallet Weight	1458-lb. (661 kg)	1296-lb. (588 kg)	1296-lb. (588 kg)	1782-lb. (808 kg)	2016-lb. (914 kg)	200-lb (91 kg)	600-lb. (272 kg)	2160-lb (980 kg)
0.035 (0.9)	535603504	535603512P	535603512	—	—	—	—	—
3/64 (1.2)	535604704	535604712P	535604712	535604712P22	—	535604723L	535604723	—
1/16 (1.6)	—	—	535606212	535606212P22	535606214P	—	535606223	535606270
3/32 (2.4)	—	—	—	—	—	—	—	535609470
1/8 (3.2)	—	—	—	—	—	—	—	535612570
5/32 (4.0)	—	—	—	—	—	—	—	535615670

300 lb drum dimensions: diameter = 23-1/2"; height = 36"
 100 lb drum dimensions: diameter = 23-1/2"; height = 18"

CONFORMANCES AND APPROVALS:

- **AWS A5.10**, ER5356, R5356
- **ASME SFA 5.10**, ER5356, R5356
- **AWS A5.01**, Class S1, Schedule F
- **CE Marked** per CPR 305/2011
- **CWB**, ER5356 (0.9 mm - 2.4 mm), R5356 (1.6 mm - 4.0 mm)
- **ABS**, ER5356, 100% Ar or Ar/He Mix (0.035" - 0.062")
- **ABS**, R5356, 100% Ar (0.062" - 0.125")
- **DB**, EN ISO 18273-S Al 5356 AlMg5Cr(A)

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers LLC is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

Hobart is a registered trademark of Hobart Brothers LLC, Troy, Ohio.

Revision Date: **240320** (Replaces 230302)
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