

SUPERGLAZE[®] 5356 PLUS

Aluminum · AWS A5.10 : ER5356

KEY FEATURES

- Premium Spooled 5356 Product
- Optimal for semi-automatic applications
- Stable arc and easy to manipulate puddle

WELDING POSITIONS

- All, except vertical down

SHIELDING GAS

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

CONFORMANCES

AWS	RINA
CWB	LR
DNV	KR
TUV	CCS
ABS	BV
CWB	DB



TYPICAL APPLICATIONS

- Trailer Manufacturing
- Formed truck panels
- Structural frames in the shipbuilding industry

DIAMETERS / PACKAGING

Diameter in [mm]	16 lb Plastic Spool	20lb Plastic Spool
3/64 [1.2]	ED038143	ED038141
1/16 [1.6]		ED038144

WIRE COMPOSITION⁽¹⁾ - As Required per SFA/AWS A5.1.0

	%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				
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

TYPICAL OPERATING PARAMETERS

SuperGlaze 5356 Plus	Base Material	WFS (ipm)	Current	Volts
3/64" [1.2mm]	3/16" [4.8mm]	450 - 490	190 - 210	21 - 23
	1/4" [6.4mm]	490 - 520	200 - 230	22 - 24
1/16" [1.6mm]		310 - 350	240 - 260	22 - 24

**Only as a suggested starting point, pure Argon gas.*

**Optimal parameters will vary based on joint design, weld position, requirements, gas type, base material, etc.*

**For support in obtaining optional parameters, please contact your local Lincoln Electric representative.*

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 business of Lincoln Electric is manufacturing and selling high quality welding equipment, automated welding systems, consumables, and cutting equipment. Our challenge is to meet the needs of our customers, who are experts in their fields, and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or technical information about their use of our products. Our employees respond to inquiries to the best of their ability based on information and specifications 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, or to provide engineering advice in relation to a specific situation. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or communications. Moreover, the provision of such information or technical information does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or technical information, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose or any other equivalent or similar warranty is specifically disclaimed. Lincoln Electric is a responsive manufacturer, but the definition of specifications, and the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information



LINCOLN ELECTRIC COMPANY OF CANADA
179 Wicksteed Ave · Toronto, ON · M4G 2B9
www.lincolnelectric.ca