

SUPERGLAZE® HD 5356 TM™

Aluminum ▪ AWS ER5356

KEY FEATURES

- Designed for heavy duty applications
- Reduced shavings and improved feedability
- High speed groove welds on formed truck panels
- Multi-pass fillet and lap welds on 6XXX series base materials
- Robotic fillet welds on trailer tanks requiring minimal post-weld clean up

WELDING POSITIONS

All

NOTE

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

CONFORMANCES

SFA/AWS A5.10/A5.10M:	ER5356
ASME SFA-A5.10:	ER5356
ISO 18273:	S Al5356 (AlMg5CrCa1)

TYPICAL APPLICATIONS

- Ideal for aggressive work environments and applications with long conduit lengths
- Trailer manufacturing

SHIELDING GAS

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

DIAMETERS / PACKAGING

Diameter in (mm)	16 lb (7.3 kg) Steel Spool	20 lb (9.1 kg) Plastic Spool	60 lb (27.2 kg) Mini-Drum	300 lb (136 kg) Gem-Pak™ Box
0.035 (0.9)				ED036338
3/64 (1.2)	ED035698	ED035699	ED036596	ED036339
1/16 (1.6)	ED035700	ED035701		ED036340

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

	%Al	%Si	%Fe	%Cu	%Mn
Requirements - AWS ER5356	Remainder	0.25 max	0.40 max	0.10 max	0.05-0.20
	%Mg	%Cr	%Zn	%Ti	%Be
Requirements - AWS ER5356	4.5-5.5	0.05-0.20	0.10 max	0.06-0.20	0.0003 max

⁽¹⁾Typical wire chemistry.

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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