# SIFTIG 5356 Aluminium TIG Rod

## SIFALUMIN No. 27

A general-purpose aluminium alloy rod containing 5% magnesium that has excellent corrosion resistance and high strength. Suitable for welding magnesium-bearing aluminium alloys such as 5251 (N4), 5154 (N5), 5454 (N51), and also heat-treatable alloys 6063 (H9), 6061 (H20), and 6082 (H30). Can be used in TIG or Oxy/Acetylene. If used in Oxy/Acetylene, use with our SIFALUMINIUM Flux - No. 36 welding flux.

Suitable for welding forged and cast aluminium-manganese/aluminium-magnesium components and dissimilar aluminium alloy grades containing a maximum of 5% Mg. It can also be used to weld components which are to be subsequently anodised. Pre-heating may be necessary, subject to material size and thickness. Wire brushing between passes is recommended to ensure the removal of surface oxide build-up.

Also suitable for use on plates, pipes, tubes, and components. Ensure that the parent metal surface is cleaned and fully degreased before welding.

### Positions



For use in all positions, except vertical down.

| | |
|---|---|
| **Current** | AC |
| **Shielding Gas** | Ar, ArHe |

### Typical Weld Metal Composition

| | | | |
|---|---|---|---|
| Mg | 5% | Al | Bal |

### Typical Mechanical Properties

| | |
|---|---|
| Melting Point | 640°C |
| Ultimate Tensile Strength | 250N/mm$^2$ |
| Hardness | 60 |

### Available Formats

| Dia. | 2.5kg |
|---|---|
| **1.6mm** | RO271625 |
| **2.4mm** | RO272425 |
| **3.2mm** | RO273225 |

### Standards

EN ISO 18273-S Al 5356 (AlMg5)
(BS 2901 5356)
(BS 1845 (NG6))

CE