

PRODUCT INFORMATION

SIFAlumin No27

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

DESCRIPTION

A general purpose aluminium 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 Sif No.36 aluminium brazing and welding flux.

WELDING POSITIONS



Suitable for all positions, except vertical down.

TYPICAL WELD METAL COMPOSITION

Mg	5%
Al	Bal

TYPICAL MECHANICAL PROPERTIES

Melting Point	640°C
Ult Tensile Strength	250 N/mm ²
Hardness	60

MATERIAL TO BE WELDED

Suitable for welding forged and cast aluminium-manganese/ aluminium-magnesium components and dissimilar aluminium alloy grades containing a maximum of 5% Mg. Can also be used to weld components which are to be subsequently anodised. Pre-heating up to 1200C may be necessary, subject to material size and thickness. Wire brushing between passes is recommended to ensure removal of surface oxide build up. Suitable for use on plate, pipe, tube and components. Ensure that parent metal surface is cleaned and fully degreased prior to welding.

AVAILABLE FORMATS

WIRE RODS		
Dia	1kg	2.5kg
1.6mm	RO271601	RO271625
2.4mm	RO272401	RO272425
3.2mm	RO273201	RO273225

Shielding Gas :	Ar, ArHe
Current :	AC

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email service@weldability-sif.com



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