



## **M-90 ER5356**

### **FEATURES**

- \*GOOD FLUIDITY AND LESS CRACK SENSITIVITY
- \*GOOD CORROSION RESISTANCE TYPICALLY USED AS FILLER MATERIAL FOR WELDING OF ALUMINUM PARTS

### **APPLICATION**

- \*WELDING FILLER WIRE
- \*SPRAY AND FLAME METALLIZING WIRE

### **CLASSIFICATION**

- \*A5.10/ASME SFA A5.10ER5356

### **CHEMICAL COMPOSITIONS**

Al	Be	Mn	Cu	Mg	Si	Zn	Cr
Remainder	0.0008	0.05	0.10	0.05	0.25	0.10	0.15

### **MECHANICAL PROPERTIES**

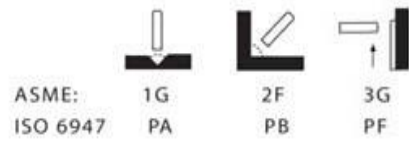
T.S	Y.S
MPa	MPa
290	198

### **WELDING PARAMETERS**

DIAMETER (mm)	1.6	2.4	3.2
LENGTH (mm)	1000	1000	1000
CURRENT (amps)	50-70	70-100	100-150

### **CURRENT**

## WELDING POSITIONS



### *Current*

= +	~	(U <sub>0</sub> : 60V)
-----	---	------------------------