



## COMWELD AL5356



## WELD DEPOSIT PROPERTIES:

Typical Weld Metal Tensile Strength	270 MPa.
Approximate Melting Point	640°C
Post Anodised colour tint	White

## ROD ANALYSIS LIMITS:

Single values are maximum allowable, unless otherwise stated.		
Si: 0.25%	Fe: 0.40%	Cu: 0.10%
Mn: 0.05-0.20%	Mg: 4.5-5.5%	Cr: 0.05-0.20%
Zn: 0.10%	Ti: 0.05-0.20%	
Total others: 0.15%	Al: Balance	

## COMPARABLE CIGWELD PRODUCTS:

Autocraft AL5356 GMAW wire  
AWS A5.10: ER5356

- ▲ Aluminium - 5% Magnesium Alloy Rod.
- ▲ Suitable for Gas Welding and Gas Tungsten Arc (GTAW / TIG) Welding Applications.
- ▲ Embossed with AS / AWS Class 5356'.
- ▲ Produces intermediate deposit strength and good ductility and corrosion resistance for the welding of a wide range of 3XXX, 5XXX, 6XXX and 5XX Aluminium alloys.

## Classifications:

AS/NZS 1167.2:	R5356.
AWS/ASME-SFA A5.10:	R5356.

## Packaging Data:

Rod Size (mm)	Pack Weight/Type	Carton Size	Approx. Rods/kg	Part No
1.6 x 914	2.5kg Pack	15kg	210	321640
2.4 x 914	2.5kg Pack	15kg	90	321641
	40 rod Handipack	8 Pks	-	322078
3.2 x 914	2.5kg Pack	15kg	51	321642

## COMWELD GENERAL PURPOSE, CAST IRON ROD (SUPER SILICON)



## TYPICAL PROPERTIES:

All Weld Metal Tensile Strength	230 MPa.
Approximate Melting Point	1150°C.

## TYPICAL ROD ANALYSIS:

C: 3.37%	Mn: 0.75%	Si: 3.25%
S: 0.008%	P: 0.011%	Fe: Balance

## JOINING PROCESS:

Gas (Fusion) and Gas Tungsten Arc Welding (TIG).

## TIP COLOUR:

Blue

- ▲ A High Strength, General Purpose, Cast Iron Alloy for Joining and Building up Grey Cast Iron Castings.
- ▲ Machinable Weld Deposit.

## Classifications:Classifications:

AS/NZS 1167.2:	RC11.
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## Packaging Data:

Rod Size (mm)	Pack Weight/Type	Approximate Rods/kg	Part No
5.0 x 700	2.5kg Pack	8	321420

## COMWELD SILICON BRONZE ROD



## TYPICAL WELD DEPOSIT PROPERTIES:

Weld Metal Tensile Strength	370 MPa.
Approximate Melting Range	970-1020°C
Weld Metal Density	8.85 gms / cm <sup>3</sup>
Hardness	90 HV (90HB)

## TYPICAL ROD ANALYSIS:

Fe: 0.25%	Mn: 1.00%	Pb: 0.02%
Si: 3.40%	Sn: 0.90%	Zn: 0.90%
Cu: Balance		

## JOINING PROCESS:

Gas (Fusion and Braze) and Gas Tungsten Arc Welding (TIG).

## COMPARABLE CIGWELD PRODUCTS:

Autocraft Silicon Bronze

- ▲ Premium Quality Deoxidised Silicon - Bronze alloy.
- ▲ Recommended for the Braze Welding and GTA (TIG) welding of Copper Silicon alloys (Everdur and Cusilman).
- ▲ CANARY YELLOW End Tip Colour.
- ▲ Produces excellent joints on copper, brass and copper-zinc sheet, tube and extruded section.

## Classifications:

AS/NZS 1167.1, AS/NZS 1167.2:	R Cu Si-A.
AWS/ASME-SFA A5.7:	R Cu Si-A (UNS No. C65600).

## Packaging Data:

Rod Size (mm)	Pack Weight/Type	Approx. Rods/kg	Part No
3.2 x 750	5kg Pack	19	321295