

## PRODUCT INFORMATION

### SIFALUMIN No 27

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 use on plate, pipe, tube and components. Ensure that parent metal surface is cleaned and fully degreased prior to welding.

#### TYPICAL WELD METAL COMPOSITION

Mg	5 %
Al	Bal

#### TYPICAL MECHANICAL PROPERTIES

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

#### MATERIAL TO BE WELDED

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). Also 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 120°C may be necessary, subject to material size and thickness. Wire brushing between passes is recommended to ensure removal of surface oxide build up.

#### AVAILABLE FORMATS

1M ROD (TIG / GTAW)			
Dia		1kgPkt	2.5kgPkt
1.6mm		RO271601	RO271625
2.4mm		RO272401	RO272425
3.2mm		RO273201	RO273225

TIG WELDING	
Current :	DC =+
Shielding Gas:	Argon, Argon/Helium
Oxy Acetylene Welding	

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email [service@wholeweld.co.uk](mailto:service@wholeweld.co.uk)



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