

OK Autrod 5356

OK Autrod 5356 is the most widely used welding alloy and can be classified as a general purpose type filler alloy. OK Autrod 5356 is typically chosen because of its relatively high shear strength. The 5XXX alloy base material, welded with OK Autrod 5356, with a weld pool chemistry greater than 3 % Mg and service temperatures in excess of 65°C are susceptible to stress corrosion cracking. The alloy is non-heat treatable.

Classifications Wire Electrode:	SFA/AWS A5.10:ER5356, EN ISO 18273:S Al 5356 (AlMg5Cr(A))
Classifications:	JIS Z 3232:A53556, SFA/AWS A5.10:ER5356, EN ISO 18273:S Al 5356 (AlMg5Cr(A))
Approvals:	ABS ER 5356, BV WB, CE EN 13479, CWB A5.10/A5.10M:2012 ER5356, DB 61.039.01, DNV 5356, GL S-AlMg 5, JIS JIS Z 3232, LR WB/11, RINA WC (*), VdTÜV 04664

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type:	AlMg 5
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Typical Wire Composition %

Mn	Si	Cr	Al	Cu	Fe	Mg	Zn
0.13	0.05	0.12	94.560	0.01	0.13	4.9	0.01

Deposition Data

Diameter	Current	Voltage
0.8 mm	60-170 A	13-24 V
0.9 mm	60-170 A	13-24 V
1.0 mm	90-210 A	15-26 V
1.2 mm	140-260 A	20-29 V
1.6 mm	190-350 A	25-30 V
2.0 mm	-	-
2.4 mm	280-400 A	26-31 V