

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.

Specifications	
Classifications	JIS Z 3232 : A53556 SFA/AWS A5.10 : ER5356 EN ISO 18273 : S Al 5356 (AlMg5Cr(A))
Approvals	ABS : ER5356 BV : WB CE : EN 13479 CWB : AWS A5.10/A5.10M: ER5356 DB : 61.039.01 DNV-GL : 5356 JIS : Z 3232 LR : WB/I1 RINA : WC VdTÜV : 04664

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

Alloy Type	AlMg5
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	120 MPa	265 MPa	26 %

Typical Wire Composition %							
Mn	Si	Cr	Al	Cu	Zn	Fe	Mg
0.13	0.05	0.12	94.56	0.01	0.01	0.13	4.90

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
2.4 mm	280-400 A	26-31 V

Recommended Welding Parameters		
Current	Wire Diameter	Voltage
60-170 A	0.8 mm	13-24 V
90-275 A	1.0 mm	15-26 V
140-300 A	1.2 mm	20-29 V
190-350 A	1.6 mm	25-30 V
280-400 A	2.4 mm	26-31 V