

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	SFA/AWS A5.10 : ER5356 EN ISO 18273 : S Al 5356 (AlMg5Cr(A))
Approvals	ABS : ER 5356 ABS : WB BV : WB CE : EN 13479 CWB : ER5356 DB : 61.039.01 DNV : 5356 LR : WB/I-3 S RINA : WB RINA : WC (*) UKCA : EN 13479 VdTÜV : 04664

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

Alloy Type	AlMg 5
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Wire Composition %							
Mn	Si	Cr	Al	Cu	Zn	Fe	Mg
0.13	0.05	0.12	94.560	0.01	0.01	0.13	4.9

Recommended Welding Parameters		
Wire Diameter	Current	Voltage
0.8 mm (0.030 in.)	60-170 A	13-24 V
1.0 mm (0.040 in.)	90-290 A	15-26 V
1.2 mm (0.047 in.)	140-300 A	20-29 V
1.6 mm (1/16 in.)	190-350 A	25-30 V
2.4 mm (3/32 in.)	280-400 A	26-31 V