OK Autrod 5556

Continuous solid wire suitable for welding of aluminium alloys with up to approx. 5 % Mg that are not age-hardenable and alloys where a higher tensile strength is required. The corrosion resistance in marine atmosphere is high.

Specifications	
Classifications	SFA/AWS A5.10 : ER5556 EN ISO 18273 : S Al 5556A (AlMg5Mn1Ti)
Approvals	ABS : ER 5556 BV : WC ClassNK : KA15WCG (I) CWB : ER5556

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

Alloy Type	AlMgMn
Shielding Gas	I1, I2, I3 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	145 MPa (21 ksi)	295 MPa (43 ksi)	25 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
As Welded	20 °C (68 °F)	24 J (18 ft-lb)

Typical Wire Composition %								
Mn	**Si**	**Cr**	**Al**	**Cu**	**Ti**	**Zn**	**Fe**	**Mg**
0.7	0.05	0.10	Rem	0.01	0.080	0.005	0.12	5.2

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
1.0 mm (0.040 in.)	90-180 A	22-26 V	7.0-14.0 m/min (276-551 in./min)	0.9-1.8 kg/h (2.0-4.0 lbs/h)

Recommended Welding Parameters		
Wire Diameter	**Current**	**Voltage**
1.2 mm (0.047 in.)	140-260 A	20-29 V
1.2 mm (0.047 in.)	125-150 A	20-24 V
1.2 mm (0.047 in.)	180-210 A	22-26 V
1.2 mm (0.047 in.)	170-240 A	24-28 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
1.6 mm (1/16 in.)	240-300 A	22-27 V
1.6 mm (1/16 in.)	190-260 A	21-26 V
1.6 mm (1/16 in.)	290-340 A	26-30 V
1.6 mm (1/16 in.)	260-310 A	22-27 V
1.6 mm (1/16 in.)	280-320 A	24-28 V