

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	SFA/AWS A5.10 : ER5356 JIS Z 3232 : A53556 EN ISO 18273 : S Al 5356 (AlMg5Cr(A))
Approvals	ABS ER 5356 BV WB CE EN 13479 CWB ER5356 DB 61.039.01 DNV-GL 5356 JIS JIS Z 3232 LR WB/I-1 RINA WC (*) VdTUV 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

Recommended Welding Parameters

Wire Diameter	Current	Voltage
0.8 mm (0.030 in.)	60-170 A	13-24 V
0.8 mm (0.030 in.)	100-130 A	18-22 V
0.8 mm (0.030 in.)	125-150 A	20-24 V
0.9 mm (0.035 in.)	60-170 A	13-24 V
0.9 mm (0.035 in.)	85-120 A	20-23 V
0.9 mm (0.035 in.)	170-190 A	21-26 V
0.9 mm (0.035 in.)	125-150 A	20-24 V
1.0 mm (0.040 in.)	90-210 A	15-26 V
1.2 mm (0.047 in.)	140-260 A	20-29 V
1.2 mm (0.047 in.)	170-240 A	24-28 V
1.2 mm (0.047 in.)	180-210 A	22-26 V
1.2 mm (0.047 in.)	125-150 A	20-24 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.)	260-310 A	22-27 V
1.6 mm (1/16 in.)	280-320 A	24-28 V

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Recommended Welding Parameters

Wire Diameter	Current	Voltage
1.6 mm (1/16 in.)	290-340 A	26-30 V
2.0 mm (5/64 in.)	-	-
2.4 mm (3/32 in.)	280-400 A	26-31 V
2.4 mm (3/32 in.)	280-360 A	26-30 V
2.4 mm (3/32 in.)	300-400 A	26-32 V