

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

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	Wire Feed Speed	Deposition Rate
0.8 mm	60-170 A	13-24 V	0.0-0.0 m/min	0.0-0.0 kg/h
0.9 mm	60-170 A	13-24 V	0.0-0.0 m/min	0.0-0.0 kg/h
1.0 mm	90-210 A	15-26 V	0.0-0.0 m/min	0.0-0.0 kg/h
1.2 mm	140-260 A	20-29 V	0.0-0.0 m/min	0.0-0.0 kg/h
1.6 mm	190-350 A	25-30 V	0.0-0.0 m/min	0.0-0.0 kg/h
2.0 mm	-	-	0.0-0.0 m/min	0.0-0.0 kg/h
2.4 mm	280-400 A	26-31 V	0.0-0.0 m/min	0.0-0.0 kg/h