

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 ClassNK : KA15WCG (I) CWB : ER5556

Alloy Type	AlMgMn
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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

Recommended Welding Parameters		
Current	Wire Diameter	Voltage
90-210 A	1.0 mm (0.040 in.)	15-26 V
140-260 A	1.2 mm (0.047 in.)	20-29 V
180-210 A	1.2 mm (0.047 in.)	22-26 V
125-150 A	1.2 mm (0.047 in.)	20-24 V
170-240 A	1.2 mm (0.047 in.)	24-28 V
190-350 A	1.6 mm (1/16 in.)	25-30 V
240-300 A	1.6 mm (1/16 in.)	22-27 V
190-260 A	1.6 mm (1/16 in.)	21-26 V
290-340 A	1.6 mm (1/16 in.)	26-30 V
260-310 A	1.6 mm (1/16 in.)	22-27 V
280-320 A	1.6 mm (1/16 in.)	24-28 V
280-400 A	2.4 mm (3/32 in.)	26-31 V