

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	JIS Z 3232 : A53556 SFA/AWS A5.10 : ER5356 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 (*) VdTÜV : 04664

Alloy Type	AlMg 5
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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		
Current	Wire Diameter	Voltage
60-170 A	0.8 mm (0.030 in.)	13-24 V
100-130 A	0.8 mm (0.030 in.)	18-22 V
125-150 A	0.8 mm (0.030 in.)	20-24 V
60-170 A	0.9 mm (0.035 in.)	13-24 V
85-120 A	0.9 mm (0.035 in.)	20-23 V
170-190 A	0.9 mm (0.035 in.)	21-26 V
125-150 A	0.9 mm (0.035 in.)	20-24 V
90-210 A	1.0 mm (0.040 in.)	15-26 V
140-260 A	1.2 mm (0.047 in.)	20-29 V
170-240 A	1.2 mm (0.047 in.)	24-28 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
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
260-310 A	1.6 mm (1/16 in.)	22-27 V
280-320 A	1.6 mm (1/16 in.)	24-28 V
290-340 A	1.6 mm (1/16 in.)	26-30 V
280-400 A	2.4 mm (3/32 in.)	26-31 V
280-360 A	2.4 mm (3/32 in.)	26-30 V



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Recommended Welding Parameters

Current	Wire Diameter	Voltage
300-400 A	2.4 mm (3/32 in.)	26-32 V
	2.0 mm (5/64 in.)	