

OK Autrod 5556A

Continuous solid wire suitable for welding of aluminium alloys more than or equal to 5.0 % 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 : ER5556A EN ISO 18273 : S Al 5556A (AlMg5Mn)
Approvals	CE : EN 13479 VdTÜV : 05794

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	Cu	Ti	Fe	Mg
0.68	0.05	0.10	0.01	0.08	0.12	5.2

Recommended Welding Parameters		
Current	Wire Diameter	Voltage
90-275 A	1.0 mm (0.040 in.)	15-26 V
140-260 A	1.2 mm (0.047 in.)	20-29 V
140-300 A	1.2 mm (0.047 in.)	20-29 V
190-350 A	1.6 mm (1/16 in.)	25-30 V
280-400 A	2.4 mm (3/32 in.)	26-31 V