

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 BV : WC ClassNK : KA15WCG (I) CWB : ER5556

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	Al	Cu	Ti	Zn	Fe	Mg
0.7	0.05	0.10	Rem	0.01	0.080	0.005	0.12	5.2

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm (0.040 in.)	90-180 A	22-26 V	7.0-14.0 m/min (276-551 in./min)	0.9-1.8 kg/h (2.0-4.0 lbs/h)

Recommended Welding Parameters		
Current	Wire Diameter	Voltage
140-260 A	1.2 mm (0.047 in.)	20-29 V
125-150 A	1.2 mm (0.047 in.)	20-24 V
180-210 A	1.2 mm (0.047 in.)	22-26 V
170-240 A	1.2 mm (0.047 in.)	24-28 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
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