

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)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	145 MPa	295 MPa	25 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
As Welded	20 °C	24 J

Typical Wire Composition %

Mn	Si	Cr	Cu	Ti	Fe	Mg
0.68	0.05	0.10	0.01	0.08	0.12	5.2

Welding Parameters

Amps	Wire Diameter	Volts
90-275 A	1.0 mm	15-26 V
140-260 A	1.2 mm	20-29 V
140-300 A	1.2 mm	20-29 V
190-350 A	1.6 mm	25-30 V
280-400 A	2.4 mm	26-31 V