

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)

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	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	Amps	Volts	Wire Feed Speed	Deposition Rate
1.0 mm	90-180 A	22-26 V	7.0-14.0 m/min	0.9-1.8 kg/h

Welding Parameters		
Amps	Wire Diameter	Volts
140-260 A	1.2 mm	20-29 V
125-150 A	1.2 mm	20-24 V
180-210 A	1.2 mm	22-26 V
170-240 A	1.2 mm	24-28 V
140-300 A	1.2 mm	20-29 V
190-350 A	1.6 mm	25-30 V
240-300 A	1.6 mm	22-27 V
190-260 A	1.6 mm	21-26 V
290-340 A	1.6 mm	26-30 V
260-310 A	1.6 mm	22-27 V
280-320 A	1.6 mm	24-28 V
280-400 A	2.4 mm	26-31 V