

OK Autrod 5754

OK Autrod 5754 is a solid aluminium wire with a content of 3 % Mg. It is recommended for welding of Al-Mg alloys with less than 3 % magnesium. The alloy has a relatively high strength and corrosion resistance.

Specifications

Classifications	SFA/AWS A5.10 : ER5754 EN ISO 18273 : S Al 5754 (AlMg3)
Approvals	VdTÜV : 04758

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	AlMg
Shielding Gas	I1, I2, I3 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	110 MPa (16 ksi)	230 MPa (33 ksi)	23 %

Typical Wire Composition %

Mn	Si	Cr	Al	Cu	Ti	Zn	Fe	Mg
0.26	0.03	0.15	96.19	0.01	0.13	0.01	0.09	3.1

Recommended Welding Parameters

Current	Wire Diameter	Voltage
60-170 A	0.8 mm (0.030 in.)	13-24 V
60-170 A	0.9 mm (0.035 in.)	13-24 V
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