



# OK Autrod 5356

GMAW

Alloy 5356 is the most widely used welding alloy and can be classified as a general purpose type filler alloy. Alloy 5356 is typically chosen because of its relatively high shear strength. The 5XXX alloy base material, welded with 5356, with a weld pool chemistry greater than 3% Mg and service temperatures in excess of 65°C are susceptible to stress corrosion cracking. Non-heat treatable.

**Welding Current**  
DC (+)

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Carton Weight (kg)	Pallet Weight (kg)
181508245A	0.8	6.35	438.15
181509243A	0.9	7.26	500.94
181510243A	1.0	7.26	500.94
181512243A	1.2	7.26	500.94
181516243A	1.6	7.26	500.94
181520243A	2.0	7.26	500.94
181524243A	2.4	7.26	500.94

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
SFA/AWS A5.10-92	DB 61.039.07	Si 0.125	Yield Stress, Mpa
ER 5356	Ü 61.039	Fe 0.2	120
EN ISO 18273	VdTUV 04664	Cu 0.05	Tensile Strength, Mpa
SAI 5356 (AlMg5Cr(A))	CWB AWS A5.10	Mn 0.125	265
	ABS ER 5356	Mg 5.0	Elongation, %
	BV WB	Cr 0.125	26
	DNV 5356 (WB)	Zn 0.05	
	GL S AMg5	Ti 0.13	
	LR WB/1-1	Other 0.075	
		Al Bal	

WELDING PARAMETERS				
Diameter (mm)	Wire Feed m/min	Welding Current, A	Arc Voltage	Deposition Rate (kg weld metal/hour arc time)
0.8	8.9-20.0	90-140	21-23	0.6-0.9
0.9	8.9-16.0	100-170	21-23	0.9-1.5
1.2	3.8-10.2	110-220	22-25	1.0-2.1
1.6	5.1-8.1	200-300	23-28	1.5-2.6

