



OK Tigrod 5356

GTAW

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

AC

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Per Pack (kg)	Pallet Weight (kg)
181516R150	1.6	5	1020
181520R150	2.0	5	1020
181524R150	2.4	5	1020
181532R150	3.2	5	1020
181540R150	4.0	5	1020
181547R150	4.7	5	1020

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.10</u>	DB 61.039.04	Si <0.25	As Welded
R 5356	VdTüV 04667	Fe <0.40	Tig Wire
<u>EN ISO 18273</u>	U 62.039	Cu <0.10	Yield Stress, Mpa 120
SAI 5183 (AlMg5Cr(A))		Mn 0.15	Tensile Strength, Mpa 265
		Mg 5.0	Elongation, % 26
		Cr 0.125	
		Zn <0.10	
		Ti 0.13	
		Other <0.15	
		Al Bal	

