

Description

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

Welding current

AC

Classifications

SFA/AWS A5.10	R5356
EN ISO 18273	S Al 5356 (AlMg5Cr(A))

Wire composition

Si	Mn	Cr	Cu	Ti	Zn	Fe	Mg
<0.25	0.15	0.13	<0.05	0.11	<0.10	<0.40	5.0

Typical mech. properties all weld metal

Yield stress, MPa	120
Tensile strength, MPa	265
Elongation, %	26

Approvals

CWB	AWS A5.10 (Item number ending with A)
DB	61.039.02
VdTÜV	
Ü	61.039

Packing data

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	2.5/5
2.0	1000	2.5/5
2.4	1000	2.5/5
3.2	1000	2.5/5
4.0	1000	2.5/5
5.0	1000	2.5/5