



# Product Data Sheet

G 'Gas-shielded metal-arc welding'

# OK Autrod 5556

Prepared by Mats Linde	Qualified by Tero Tolonen	Approved by Michael Spieß	Reg no EN006209	Cancelling EN005648	Reg date 2013-09-12	Page 1 (2)
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## REASON FOR ISSUE

Approval and mechanical data update.

## GENERAL

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.

**Shielding Gas:** I1, I2, I3 (EN ISO 14175)

**Alloy Type:** AlMgMn

## CLASSIFICATIONS Wire Electrode

SFA/AWS A5.10 ER5556  
EN ISO 18273 S Al 5556A (AlMg5Mn1Ti)

## APPROVALS

ABS ER5556  
CWB AWS A5.10

## CHEMICAL COMPOSITION

### Wire/Strip (%)

	Min	Max
Si		0.25
Mn	0.50	1.0
Cr	0.05	0.20
Cu		0.10
Al		
Ti	0.05	0.20
Zn		0.25
Fe		0.40
Be		0.0003
Mg	4.7	5.5
Other each		0.05
Others tot		0.15

## MECHANICAL PROPERTIES OF WELD METAL

### All Weld Metal

Properties	As welded	
	Typ	
Rp0.2 (MPa)	145	
Rm (MPa)	295	
A4-A5 (%)	25	

## Comments:

THIS INFORMATION IS BASED ON DATA DEVELOPED UNDER LABORATORY CONDITIONS AND IS DESIGNED AS A GUIDELINE ONLY. INDIVIDUAL CONDITIONS, WELDING EQUIPMENT AND ENVIRONMENT CAN AFFECT RESULTS.



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### ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W Nom	η Nom	H Min Max		Feed Min Max		Min	U Max
	Min	Max			Min	Max	Min	Max		
1.0	90	210	16						15	26
1.2	140	260	19						20	29
1.6	190	350	25						25	30
2.4	280	400	30						26	31

**W** = Gas consumption (l / min)

**η** = Recovery, g weld metal / 100g wire (%)

**H** = Deposit rate (kg weld metal / hour arc time)

**Feed** = Feeding rate (m/min)

**U** = Arc voltage (V)

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### OTHER DATA

Preheating: is not required for welds in sections up to 20 mm but risk of porosity can be reduced by preheating sections over 10 mm. Preheating temperature is usually 150-200 °C.

Clean material is essential for a good weld quality. Remove oxide, dirt, oil, humidity etc. before welding. If brushing use a stainless steel wire brush.

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