



# Product Data Sheet

W 'Tungsten inert gas arc welding'

# OK Tigrod 5356

Prepared by Mats Linde	Qualified by Tero Tolonen	Approved by Michael Spieß	Reg no EN006183	Cancelling EN005833	Reg date 2013-08-29	Page 1 (2)
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## REASON FOR ISSUE

Comment to mechnaical data added. Chemical composition update.

## GENERAL

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 are susceptible to stress corrosion cracking. The alloy is non-heat treatable.

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

**Alloy Type:** AlMg 5

## CLASSIFICATIONS Wire

JIS Z 3232          A5356

## CLASSIFICATIONS Wire Electrode

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

## APPROVALS

ABS	R5356 for dim. 0.8 to 3.2 mm
CE	EN 13479
CWB	AWS A5.10
DB	61.039.02
JIS	JIS Z 3232
VdTÜV	04665

## CHEMICAL COMPOSITION

### Wire/Strip (%)

	Min	Max
Si		0.25
Mn	0.05	0.20
Cr	0.05	0.20
Cu		0.10
Ti	0.06	0.20
Zn		0.10
Fe		0.40
Be		0.0003
Mg	4.5	5.5
Other each		0.05
Others tot		0.15

## MECHANICAL PROPERTIES OF WELD METAL

### All Weld Metal

Properties	As welded	
	Min	Max
Rp0.2 (MPa)	110	
Rm (MPa)	235	
A4-A5 (%)	17	
Comments: Typical values: Interpass temperature 150°C.		

## 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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### OTHER DATA

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. 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.