



OK AUTROD 4043

A Si alloyed general purpose aluminium solid wire for GMAW

Classification AWS A5.10: ER4043

DESCRIPTION

OK AUTROD 4043 is one of the most widely used welding and brazing alloys and can be classified as a general purpose filler alloy. The silicon additions result in improved fluidity (wetting action) to make the alloy a preferred choice of welders. The alloy is not sensitive to weld cracking and produces bright and almost smut free welds. Not recommended for anodizing. Non-heat treatable.

APPROVALS: CE, CWB, DB & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	5.00	YS (N/mm ²)	55
Mn	<0.05	UTS (N/mm ²)	165
Cu	<0.10	Elongation (%)	18
Ti	<0.15		
Zn	<0.10		
Fe	<0.60		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	60-170	13-24
0.9	60-170	13-24
1.0	90-210	15-26
1.2	140-260	20-29
1.6	190-350	25-30
2.0	280-400	26-31
2.4	280-400	26-31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 7/9 kg or select sizes in Marathon Pac weighing 25/80/141 kg.

OK AUTROD 5183

A Mg-Mn alloyed aluminium solid wire for GMAW

Classification AWS A5.10: ER5183

DESCRIPTION

OK AUTROD 5183 is designed to provide the highest possible strength in the as welded condition of alloy AA 5083 and similar high magnesium alloys. The alloy is typically used in marine and structural applications where high strength, high fracture toughness for impact resistance and exposure to corrosive elements are important. The alloy is not recommended for elevated temperature applications due to its susceptibility to stress corrosion cracking. The alloy is non-heat treatable.

APPROVALS: ABS, BV, CE, Class NK, CWB, DB, DNV, GL, LR & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.40	YS (N/mm ²)	140
Mn	0.80	UTS (N/mm ²)	290
Cr	0.15	Elongation (%)	25
Cu	<0.10	Impact (CVN)	
Ti	<0.15	@ +200C (Joules)	30
Zn	<0.25		
Fe	<0.40		
Mg	4.80		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.0	90-210	15-26
1.2	140-260	20-29
1.6	190-350	25-30
2.4	280-400	26-31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 7/9 kg or select sizes in Marathon Pac weighing 25/80/141 kg.



OK AUTROD 5356

A Mg alloyed aluminium solid wire for GMAW

Classification AWS A5.10: ER5356

DESCRIPTION

OK AUTROD 5356 is the most widely used welding alloy and can be classified as a general purpose type filler alloy. OK AUTROD 5356 is typically chosen because of its relatively high shear strength. The 5XXX alloy base material, welded with OK AUTROD 5356, with 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.

APPROVALS: ABS, BV, CE, CWB, DB, DNV, GL, LR, RINA & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.25	YS (N/mm ²)	120
Mn	0.15	UTS (N/mm ²)	265
Cr	0.13	Elongation (%)	26
Cu	<0.10		
Ti	0.11		
Zn	<0.10		
Fe	<0.40		
Mg	5.00		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	60-170	13-24
0.9	60-170	13-24
1.0	90-210	15-26
1.2	140-260	20-29
1.6	190-350	25-30
2.4	280-400	26-31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 7/9 kg or select sizes in Marathon Pac weighing 25/80/141 kg.

OK AUTROD 5556A

A Mg-Mn alloyed aluminium solid wire for GMAW

Classification AWS A5.10: ER5556

DESCRIPTION

OK AUTROD 5556A is a continuous solid wire suitable for welding of aluminium alloys (approx. up to 5 % Mg) that are not age-hardenable and alloys where a higher tensile strength is required. The corrosion resistance in marine atmosphere is high.

APPROVALS: CE & VdTÜV

WELDING CURRENT: DC+

SHIELDING GAS: Ar or He or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.25	YS (N/mm ²)	145
Mn	0.80	UTS (N/mm ²)	295
Cr	0.13	Elongation (%)	25
Cu	<0.10	Impact (CVN)	
Ti	0.13	@ +200C (Joules)	25
Zn	<0.20		
Fe	<0.40		
Mg	5.30		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.0	90-210	15-26
1.2	140-260	20-29
1.6	190-350	25-30
2.4	280-400	26-31

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 7/9 kg or select sizes in Marathon Pac weighing 25/80/141 kg.