

# OK TIGROD 5356

A Mg alloyed aluminium solid rod for GTAW

Classification AWS A5.10: R5356

## 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 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:** CE, CWB, DB & VdTÜV

**WELDING CURRENT:** AC

**SHIELDING GAS:** Ar or Ar/He

## TYPICAL PROPERTIES

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

## PACKING DATA

Size (mm)	Length (mm)	Packing (5 Kg.)
1.6	1000	✓
2.0	1000	✓
2.4	1000	✓
3.2	1000	✓

**PACKING:** The rods are packed in tubes weighing 5 kg.