



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 5356

Signed by Mats Linde	Approved by Per-Åke Pettersson/Christos Skodras	Reg no EN003582	Cancelling EN003216	Reg date 2006-10-05	Page 1 (2)
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REASON FOR ISSUE

CE approval added

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 439)

Alloy Type: AlMg 5

CLASSIFICATIONS Wire Electrode

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

APPROVALS

CE EN 13479
CWB AWS A5.10 (Item no ending with A)
DB 61.039.02
VdTÜV 04665

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
Si		0.25
Mn	0.10	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

Properties	All Weld Metal	
	Min	Typ
	As welded	
Rp0.2 (MPa)	110	120
Rm (MPa)	235	265
A4-A5 (%)	17	26
	Comments: Typical values: Interpass temperature 150°C.	



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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.