



# Product Data Sheet

G 'Gas-shielded metal-arc welding'

# OK Tigrod 5556A

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## REASON FOR ISSUE

Classification and mechanical data update.

## GENERAL

This is a Continuous solid wire suitable for welding of aluminium alloys with grater or equal to 5.0 % 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 ER5556A  
EN ISO 18273 S Al 5556A (AlMg5Mn)

## APPROVALS

VdTÜV 05795

## CHEMICAL COMPOSITION

### Wire/Strip (%)

	Min	Max
Si		0.25
Mn	0.6	1.0
Cr	0.05	0.20
Cu		0.10
Al		
Ti	0.05	0.20
Zn		0.20
Fe		0.40
Be		0.0003
Mg	5.0	5.5
Other each		0.05
Others tot		0.15

## 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.