OK TIGROD 4043

A Si alloyed general purpose aluminium solid rod for GTAW

Classification AWS A5.10: R4043

DESCRIPTION

OK TIGROD 4043 is one of the most widely used welding alloys. It is used for welding AlMgSi types and AlSi alloys (up to 7% silicon). Not recommended for anodising. Non-heat treatable.

APPROVALS: CE, CWB, DB

WELDING CURRENT: AC

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	5.00	YS (N/mm²)	55
Mn	<0.05	UTS (N/mm²)	165
Cu	<0.10	Elongation (%)	18
Ti	<0.15		
Zn	<0.10		
Fe	<0.60		

PACKING DATA

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

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

OK TIGROD 5183

A Mg-Mn alloyed aluminium solid rod for GTAW

Classification AWS A5.10: R5183

DESCRIPTION

OK TIGROD 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 impact fracture toughness 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: CE, CWB, DB & VdTÜV

WELDING CURRENT: AC

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.40	YS (N/mm²)	140
Mn	0.80	UTS (N/mm²)	290
Cr	0.15	Elongation (%)	25
Cu	<0.10	Impact (CVN)	
Ti	<0.15	@ +20°C (Joules)	30
Zn	<0.25		
Fe	<0.40		
Mg	4.80		

PACKING DATA

Size (mm)	Length (mm)	Packing (2.5 Kg.)
1.6	1000	✓
2.0	1000	✓
2.4	1000	✓
3.2	1000	✓

PACKING: The rods are packed in 2.5 kg cartons and four of them in a Cardboard box.

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 & VdTŰV

WELDING CURRENT: AC

SHIELDING GAS: Ar or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.25	YS (N/mm²)	120
Mn	0.15	UTS (N/mm²)	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.

OK TIGROD 5556A

A Mg-Mn alloyed aluminium solid rod for GTAW

Classification AWS A5.10: R5556

DESCRIPTION

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

APPROVALS: VdTÜV

WELDING CURRENT: AC

SHIELDING GAS: Ar or He or Ar/He

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
Si	<0.25	YS (N/mm²)	145
Mn	0.80	UTS (N/mm²)	295
Cr	0.13	Elongation (%)	25
Cu	<0.10	Impact (CVN)	
Ti	0.13	@ +20ºC (Joules)	25
Zn	<0.20		
Fe	<0.40		
Mg	5.30		

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.