

OK Autrod 5183

OK Autrod 5183 was developed to provide the highest strengths possible in the as welded condition of alloy AA 5083 and other similar high magnesium alloys. The more common 5356 grade will typically fail to meet the as-welded tensile requirements of AA 5083. The alloy is typically utilised in marine and structural applications where high strengths, 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.

Specifications	
Classifications	SFA/AWS A5.10 : ER5183 EN ISO 18273 : S Al 5183 (AlMg4,5Mn0,7(A))
Approvals	ABS : WC ABS : ER 5183 BV : WC CE : EN 13479 ClassNK : KAI5RCG(I) CWB : ER5183 DB : 61.039.03 DNV : 5183 LR : WC1/I-1 S RINA : WC (*) UKCA : EN 13479 VdTÜV : 04666

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	AlMgMn
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Charpy V-Notch Properties	
Testing Temperature	Impact Value
20 °C (68 °F)	90 J (66 ft-lb)

Typical Wire Composition %								
Mn	Si	Cr	Al	Cu	Ti	Zn	Fe	Mg
0.65	0.04	0.08	94.200	0.01	0.100	0.01	0.13	4.9

Deposition Data		
Diameter	Current	Voltage
0.8 mm (.030 in.)	60-170 A	13-24 V
1.0 mm (.040 in.)	90-210 A	15-26 V
1.2 mm (.045 in.)	140-260 A	20-29 V
1.6 mm (1/16 in.)	190-350 A	25-30 V
2.4 mm (3/32 in.)	280-400 A	26-31 V

Recommended Welding Parameters		
Current	Wire Diameter	Voltage
90-275 A	1.0 mm (0.040 in.)	15-26 V
140-300 A	1.2 mm (0.047 in.)	20-29 V
190-350 A	1.6 mm (1/16 in.)	25-30 V