

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 OK Autrod 5356 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.

Approvals	CWB AWS A5.10/A5.10M: ER5183 NAKS/HAKC 1.2-1.6 mm ABS ER5183 BV WC CE EN 13479 ClassNK KA15RCG(I-1)(I-4) DB 61.039.03 DNV-GL 5183 JIS Z 3232 LR WC1/I-1 RINA WC VdTUV 04666
------------------	--

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

Alloy Type	AlMgMn
-------------------	--------

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	90 J

Recommended Welding Parameters

Wire Diameter	Current	Voltage
1.0 mm	90-210 A	15-26 V
1.2 mm	140-260 A	20-29 V
1.2 mm	125-150 A	20-24 V
1.2 mm	180-210 A	22-26 V
1.2 mm	170-240 A	24-28 V
1.6 mm	190-350 A	25-30 V
1.6 mm	240-300 A	22-27 V
1.6 mm	260-310 A	22-27 V
1.6 mm	190-260 A	21-26 V
1.6 mm	290-340 A	26-30 V
1.6 mm	280-320 A	24-28 V