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**ESAB**

**- A CENTURY OF INNOVATION IN WELDING AND CUTTING**

**OK Autrod 5183  
GMAW**

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.

**Welding current**  
DC(+)

Classifications	Approvals	Typical all weld metal composition, %		Typical mech. properties all weld metal	
<u>SFA/AWS A5.10</u> ER5183	ABS	ER5183 for dim 1,2 and 1,6 mm	Si <0,25	Yield stress, MPa 140	
<u>EN ISO 18273</u> S Al 5183			Mn 0,8	Tensile strength, MPa 290	
(AlMg4,5Mn0,7 (A))	BV	WC	Cr 0,15	Elongation, % 25	
	CWB	AWS A5.10 (Item number ending with A)	Cu <0,10	Charpy V Test temps, °C	
			Ti <0,15	Impact values, J 30	
			Zn <0,25		
			Fe <0,40		
			Mg 4,8		
			Wire composition		
	DB	61.039.03			
	DNV	5183 (WC)			
	GL	RAIMg4.5			
	LR	WC/I-1			
	VdTÜV				
	Ü	61.039			
<b>Diameter, mm</b>	<b>1,0</b>	<b>1,2</b>	<b>1,6</b>	<b>2,4</b>	
Arc voltage, V	15-26	20-29	25-30	26-31	
Welding current, A	90-210	140-260	190-350	280-400	

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