

Aluminum Wires

OK® AUTROD 4043
AWS: ER4043

•Is one of the most widely used welding and brazing alloys and can be classified as a general-purpose filler alloy •The silicon additions results in improved fluidity (wetting action), making the alloy the preferred choice of welders •This alloy is not sensitive to weld cracking and produces bright, almost smut-free welds •Not recommended for anodising •Non-heat treatable •Welding current: DC (+)

Part No.	Package Weight	Diameter
180408215A	0.45 kg	0.030"
180408245A	6.35 kg	0.030"
180409215A	0.45 kg	0.035"
180409243A	7.26 kg	0.035"
180412215A	0.45 kg	3/64"
180412242A	9.07 kg	3/64"
180416242A	9.07 kg	1/16"

Mechanical Properties
Yield Stress: 8 ksi, 55 MPa
Tensile Strength: 24 ksi, 165 MPa
Elongation: 18%



OK® AUTROD 5356
AWS: ER5356

•Is the most widely used welding alloy and can be classified as a general-purpose type filler alloy •OK Autrod 5356 is typically chosen because of its relatively high shear strength •The 5XXX alloy base material, welded with OK Autrod 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 •Welding current: DC (+)

Part No.	Package Weight	Diameter
181508215A	0.45 kg	0.030"
181508245A	6.35 kg	0.030"
181509215A	0.45 kg	0.035"
181509243A	7.26 kg	0.035"
181512215A	0.45 kg	3/64"
181512242A	9.07 kg	3/64"
181516242A	9.07 kg	1/16"

Mechanical Properties
Yield Stress: 17 ksi, 120 MPa
Tensile Strength: 38 ksi, 265 MPa
Elongation: 26%



Stainless Steel Wires

OK® AUTROD 308LSi
AWS A5.9: 308Si/307LSi

•A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type •OK Autrod 308LSi has a good general corrosion resistance •The alloy has a low carbon content which makes this alloy particularly recommended where there is a risk of intergranular corrosion •The higher silicon content improves the welding properties, such as wetting •The alloy is widely used in the chemical and food processing industries as well as for pipes, tubes and boilers

Part No.	Package Weight	Diameter
1612089820	15.0 kg	.030"
1612099820	15.0 kg	.035"
1612119820	15.0 kg	.045"

Mechanical Properties
GMAW using 98% Argon / 2% Oxygen
Yield Stress: 54 ksi, 370 MPa
Tensile Strength: 90 ksi, 620 MPa
Elongation in 2": 36%



OK® AUTROD 309LSi
AWS A5.9: ER309Si/309LSi

•A continuous solid corrosion resistant chromium-nickel wire for welding of similar steels, wrought and cast steels of 23% Cr-12% Ni types •The alloy is also used for welding of buffer layers on CMn steels and welding of dissimilar joints •When using this wire for buffer layers and dissimilar joints it is necessary to control the dilution of the weld •OK Autrod 309LSi has a good general corrosion resistance •The higher silicon content improves the welding properties, such as wetting

Part No.	Package Weight	Diameter
1651089820	15.0 kg	.030"
1651099820	15.0 kg	.035"
1651119820	15.0 kg	.045"

Mechanical Properties
Yield Strength: 64 ksi, 440 MPa
Tensile Strength: 87 ksi, 600 MPa
Elongation in 2": 41%



OK® AUTROD 316LSi
AWS A5.9: ER316Si/316LSi

•A continuous solid corrosion resisting chromium-nickel-molybdenum wire for welding of austenitic stainless alloys of 18% Cr - 10% Ni - 3% Mo types •OK Autrod 316LSi has a good general corrosion resistance, in particular the alloy has very good resistance against corrosion in acid and chlorinated environments •The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion •The higher silicon content improves the welding properties, such as wetting •The alloy is widely used in the chemical and food processing industries as well as in ship building and various types of architectural structures

Part No.	Package Weight	Diameter
1632089820	15.0 kg	.030"
1632099820	15.0 kg	.035"
1632119820	15.0 kg	.045"

Mechanical Properties
Yield Strength: 64 ksi, 440 MPa
Tensile Strength: 90 ksi, 620 MPa
Elongation in 2": 37%



Please see pages G166 - G167 for information about electrodes and tubular wires.



Certificates can be found online at www.esab.com