

TÜV-Verband Welding Consumable Leaflet

according to TÜV-Verband Technical Leaflet 1153 and DIN EN 14532

		1 Manufacturer/Supplier Rodacciai S.p.A. ITA Bosisio Parini			2 Number: 20358.00 23.07.2025	
3 Welding consumable*:		Drahtelektrode				
4 Trade name*:		Roda Aluweld 5356				
7 Type*:		EN ISO 18273-S Al 5356 (AlMg5Cr(A))				
11 Diameter range:		0,8 - 1,6 mm				
12 Auxiliary materials:		EN ISO 14175 - I1				
13 The validity is certified by the appearance of the welding consumable leaflet in the welding consumables portal.						
15 Materials and postweld heat treatment						
Pos	Wb	Group / Material 1	Text	Group / Material 2	Remarks	
	U	EN AW-5083 (AlMg4,5Mn0,7)				
16 Material groups acc. to CR ISO 15608						
21 Root weldability:		not verified				
23 Wall thickness:		20 mm				
24 Type of current and polarity:		G+				
25 Welding position according to DIN EN ISO 6947:1997-05: PA, PB, PC, PD, PE, PF						
26 Highest operating temperature in the short-term range as for parent metal, but not higher than:						40 °C
27 Highest operating temperature in the long-term range max.:						- - °C
28 Lowest operating temperature/as for parent metal, but not lower than:						-20 °C
29 Design stress value/as for parent metal:				wie Grundwerkstoff / as parent material		
30 For use in the long-term range:				- -		
31 Resistance to intergranular corrosion proven in accordance with:				- -		
32 Remarks :						
33 The approval test for the welding consumable was carried out on the basis of TÜV-Verband Technical Leaflet 1153 and DIN EN 14532. If no conflicting test principles are stated under heading 32 – Remarks –, this welding consumable is suitable for use according to the Pressure Equipment Directive 2014/68/EU, Annex I Point 4.						
34 Explanations		A tempered L solution annealed and quenched N normalized	S stress-relieved St stabilized U non-annealed V hardened and tempered	W soft annealed	G+ direct current plus pole G- direct current minus pole W alternating current	
35 Compiled in accordance with the data of:				TÜV NORD		
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