

# ALLOY 5554 | AlMg2.7Mn

## KEY FEATURES

- Matching filler alloy for welding 5454 base alloys
- Low magnesium content to closely match base material chemistry

## ADVANTAGES

- All-position aluminum MIG wire
- Superior wire surface finish for the best feedability and arc performance
- Optimal manufacturing process to precisely control chemical composition
- State-of-the-art testing equipment to ensure trouble-free performance of the weld wire
- Manufactured under a quality system certified to ISO 9001 requirements

## TYPICAL APPLICATIONS

- Automotive wheels
- Transportation applications such as over-the-road trailers and rail tank cars
- Chemical storage tanks

## CONFORMS TO

- EN ISO 18273:2004
- AWS/ASTM A5.10/A5.10M:2012

## SHIELDING GAS

- 100% Argon
- Argon/Helium Mixtures
- Flow Rate: 30 - 50 CFH (14.2 - 23.6 L/min)

## CHEMICAL COMPOSITION

ALUMINUM ASSOCIATION	5554
AWS/ASTM A5.10 /A5.10M: 2012	ER5554 R5554
ISO 18273:2004 Numeral	S Al 5554
ISO 18273:2004 Chemical	AlMg2.7Mn
EN 573-3	EN AW-AlMg2.7Mn

CHEMICAL COMPOSITION (%)		TYPICAL RESULTS
Al	Remainder	Remainder
Si	≤0.25	0.06
Fe	≤0.40	0.16
Cu	≤0.10	0.005
Mn	0.05-1.0	0.63
Mg	2.4-3.0	2.60
Cr	0.05-0.20	0.08
Zn	≤0.25	0.003
V	-	-
Ti	0.05-0.20	0.09
Be	0.0003	0.0002
Zr	-	-

## APPROVALS

<b>CWB</b>	CANADIAN WELDING BUREAU	per AWS A5.10-2012
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See Product Approval Chart Pg.21

## PACKAGING

WIRE DIAMETER inches (mm)	PLASTIC SPOOL				BASKET SPOOL	ACCUPAK	ROD DIAMETER inches (mm)	TIG BOX	
	1 LB (0.45 KG)	5 LB (2.26 KG)	16 LB (7.26 KG)	20 LB (9 KG)	15.43 LB (7 KG)	300 LB (136KG)		10 LB (4.54 KG)	22.05 LB (10 KG)
0.030" (0.8 mm)	✓	✓	✓	✓	✓	✓	1/16" (1.6 mm)	✓	✓
0.035" (0.9 mm)	✓	✓	✓	✓	✓	✓	5/64" (2.0 mm)	✓	✓
0.040" (1.0 mm)	✓	✓	✓	✓	✓	✓	3/32" (2.4 mm)	✓	✓
3/64" (1.2 mm)	✓	✓	✓	✓	✓	✓	1/8" (3.2 mm)	✓	✓
1/16" (1.6 mm)	✓	✓	✓	✓	✓	✓	5/32" (4.0 mm)	✓	✓
							3/16" (4.8mm)	✓	✓

See AccuPak Payoff Accessories Pg.25