

OK Autrod 5554

OK Autrod 5554 is a solid aluminium wire with a content of 2,7 % Mg. It's recommended for welding of AlMg alloys like 5454. Typical applications are chemical storage tanks, automotive components like wheels and frame sections. The weld metal is not sensitive to stress corrosion cracking at elevated temperatures.

Specifications	
Classifications	SFA/AWS A5.10 : ER5554 EN ISO 18273 : S Al 5554 (AlMg2,7Mn)
Approvals	CE : EN 13479 CWB : A5.10/A5.10:2012 ER5554

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

Alloy Type	AlMg 2.7Mn
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	110 MPa (16 ksi)	230 MPa (33 ksi)	17 %

Typical Wire Composition %								
Mn	Si	Cr	Al	Cu	Ti	Zn	Fe	Mg
0.7	0.1	0.1	96	0.01	0.15	0.01	0.1	2.7

Recommended Welding Parameters		
Wire Diameter	Current	Voltage
1.2 mm (0.047 in.)	140-260 A	20-29 V
1.2 mm (0.047 in.)	125-150 A	20-24 V
1.2 mm (0.047 in.)	180-210 A	22-26 V
1.2 mm (0.047 in.)	170-240 A	24-28 V
1.2 mm (0.047 in.)	140-300 A	20-29 V
1.6 mm (1/16 in.)	190-350 A	25-30 V
1.6 mm (1/16 in.)	240-300 A	22-27 V
1.6 mm (1/16 in.)	190-260 A	21-26 V
1.6 mm (1/16 in.)	290-340 A	26-30 V
1.6 mm (1/16 in.)	260-310 A	22-27 V
1.6 mm (1/16 in.)	280-320 A	24-28 V