

Description

OK Autrod 5554 is a solid aluminium wire with a content of 2.7% Mg. It is recommended for welding AlMg alloys like 5454. Typical applications include chemical storage tanks, automotive components like wheels and frame sections. The weld metal is not sensitive to stress corrosion cracking at elevated temperatures.

Welding current

DC +

Classifications

SFA/AWS A5.10	ER5554
EN ISO 18273	S Al 5554 (AlMg2.7Mn)

Wire composition

Si	Mn	Cr	Cu	Ti	Zn	Fe	Mg
<0.25	0.75	0.13	<0.10	0.13	<0.25	<0.40	2.7

Typical mech. properties all weld metal

Yield stress, MPa	110
Tensile strength, MPa	230
Elongation, %	17

Approvals

CWB	AWS A5.10 (Item no ending of A only)
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Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
1.2	6-13	140-260	20-29	1.1-2.4
1.6	4.5-7.5	190-350	25-30	1.5-2.5