

## Description

Continuous solid wire suitable for welding aluminium alloys with up to approx. 5% Mg that are not age hardenable and alloys where a higher tensile strength is required.

The corrosion resistance in a marine atmosphere is high.

## Welding current

DC(+)

## Classifications

SFA/AWS A5.10 ER5556  
EN ISO 18273 S Al 5556A (AlMg5Mn)

## Wire composition

Si	Mn	Cr	Cu	Ti	Zn	Fe	Mg
<0.25	0.8	0.13	<0.10	0.13	<0.20	<0.40	5.3

## Typical mech. properties all weld metal

Yield stress, MPa	145
Tensile strength, MPa	295
Elongation, %	25

## Charpy V

Test temps, °C	Impact values, J
+20	25

## Approvals

CWB AWS A5.10  
(Item number ending with A)  
VdTÜV

## Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
1.0	7-14	90-210	15-26	0.9-1.8
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