

TECHNICAL DATA SHEET

ALUMINUM ALLOY FILLER METAL



5554

Comparable specifications

ASME SFA- 5.10: ER5554
EN ISO 18273: S Al 5554 (AlMg2.7Mn)
Werkstoff Nr.: 3.3538

Description and applications*

* *Illustrative, not-exhaustive list*

Aluminum alloy filler metal commonly used for high temperature applications, where it is able to provide high resistance to stress corrosion. Typically used for welding of 5454 or similar base alloys: its low magnesium content closely matches with the base metal chemistry. Also suitable for welding 5454 with the 6000 series.

This grade may be used for:

- automotive wheels;
- transportation applications such as over-the-road trailers and rail tank cars;
- chemical storage tanks;
- industrial applications where high temperature resistance is required.

Weldable base materials*

* *Illustrative, not-exhaustive list*

Aluminium 5454 (AlMg2.7Mn), AlMgMn, AlMg1, AlMg3, AlMgSi0.8

All-weld metal mech. properties*

* *For reference only values*

Tensile strength (Rm): $\geq 215 \text{ N/mm}^2$ **Elongation:** $\geq 17\%$

Chemical composition*

* *For reference only values*

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Be
max	max	max	0.50	2.40	0.05	max	0.05	max
0.25	0.40	0.10	1.00	3.00	0.20	0.25	0.20	0.0003

Standard packaging data*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	7 (33)	n.a.
GTAW **	filler rod	1.60 - 4.00 (1/16 - 5/32)	cardboard boxes / tubes	5 (11)	1000 (39.4)

* *Other sizes and packing types are available upon request*

** *GMAW: gas metal arc welding; GTAW: gas tungsten arc welding*

Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

Customized labels are available upon request.

Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.