

## DESCRIPTION

The alloy AlMg<sub>2,7</sub>Mn/5554 has been developed for high temperature applications without becoming sensitive to stress corrosion. The alloy AlMg<sub>2,7</sub>Mn/5554 is also suitable for welding the basis metal 5454 with the 6000 series. This alloy is recommended for a wide range of applications in the industry in general and in the structural industry, in particular, whenever high temperature processing is needed.

**AWS A5.10/A5.10M**  
ER5554,R5554

**EN ISO 18273**  
S Al 5554 / AlMg<sub>2,7</sub>Mn

## MATERIALS TO BE WELDED

Al Mg Mn / Al Mg<sub>1</sub> / Al Mg<sub>2</sub> / Al Mg<sub>2,7</sub> Mn / Al Mg<sub>3</sub> / Al Mg Si 0,5  
Al Mg Si 0,8

### SHIELDING GASES FOR GMAW/GTAW

1, 12, 13

### MINIMAL VALUES OF THE MECHANICAL PROPERTIES *(welded metal)*

Tensile strenght R <sub>m</sub> :	215 N/mm <sup>2</sup>
Yeld strenght R <sub>p 0,2</sub> :	100 N/mm <sup>2</sup>
Elongation L=5d:	18%

## AVAILABLE SIZES\*

### MIG: 5-6-7 Kg D300 or K300/KS300 spools

*Diameter of the wire*

0,8 mm - 0,9 mm - 1,0 mm - 1,2 mm - 1,6 mm - 2,0 mm - 2,4 mm

### TIG carton box of 10 Kg (x 1000 mm length)

*Diameter of the rods*

1,6 mm - 2,0 mm - 2,4 mm - 3,2 mm - 4,0 mm - 5,0 mm

### MINI-MIG: 0,5 Kg D100 spools / 2 Kg D200 spools

*Diameter of the wire*

0,8 mm - 0,9 mm - 1,0 mm - 1,2 mm - 1,6 mm

## CHEMICAL COMPOSITION

in%(m/m)<sup>(a)</sup>

<b>Al</b>	remainder
<b>Si</b>	0,25
<b>Fe</b>	0,40
<b>Cu</b>	0,10
<b>Mn</b>	0,5-1,0
<b>Mg</b>	2,40 -3,0
<b>Cr</b>	0,05-0,20
<b>Zn</b>	0,25
<b>Ti</b>	0,05 -0,20
<b>Be</b>	0,0003
	others each 0,05
	others total 0,15

\* More diameters and packaging upon request

*(a) Single values shown in the table are maximum values, unless otherwise noted.*