

## TECHNICAL DATA SHEET

AWS /ASTM A5.10: **ER5554**

DIN 18273: S-ALMg 2,7 Mn

<b>DESCRIPTION:</b>		Aluminium used to weld base alloys 5554 (and all 6000 series) at high temperatures with extremely low sensitivity to tension corrosion. Main applications of this alloy is in the Automotive and in general to all construction businesses where high welding temperatures are requested.							
Material to be welded					Shielding gas for Gmaw/Gtaw				
Al Mg 1 – Al Mg 2 – Al Mg 2,7 Mn – Al Mg Si 0,5 Al Mg Si 0.8 – Al Mg Mn – Al Mg 3					<b>Ar 99,95% min.</b> <b>Ar 75% + He 25%</b> <b>Ar 50% + He 50%</b>				
<b>CHEMICAL ANALYSIS (TYPICAL)</b> <i>Analyse de colée / Cast analysis / schmelzanalyse</i>									
<b>Al</b> Rem	<b>Mg</b> 2,40-3,0	<b>Fe</b> <0,40	<b>Si</b> <0,25	<b>Zn</b> <0,25	<b>Cu</b> <0,10	<b>Mn</b> 0,50- 1,00	<b>Cr</b> 0,50-0,20	<b>Ti</b> <0,25	<b>Be</b> <0,0003
<b>VALORI MINIMI DELLE CARATTERISTICHE MECCANICHE (METALLO SALDATO)</b> <i>Valeurs Min des Propriétés mecaniques du metal soudé / Min . Values of the meccanical properties ( welded metal)</i>									
<b>TENSILE STRENGHT</b>  Resistenza alla trazione(Rm) N/mm <sub>2</sub>  <b>215</b>			<b>YELD STRENGHT</b> R <sub>p</sub> 0.2 N/mm <sub>2</sub>  Resistenza allo snervamento N/mm <sub>2</sub>  <b>100</b>			<b>ELONGATION</b>  Allungamento L=5d (%)  <b>17%</b>			
<b>Available sizes:</b>		Mig: 0.80 – 2.40 mm – Tig Rods: 1.60 – 4.00 mm							
<b>Packaging:</b>		Mig 0.5(D-100) – 7 Kgs (BS/D 300) TIG Rods: 2.5/kgs tubes							
<b>Approvals:</b>		<b>CE, ISO 9001</b>							