



AlMg3Mn

ISO 18273: S-Al 5554 (AlMg2,7Mn)

DESCRIPTION

Alloy 5554 was originally developed as a filler alloy for use with alloy 5454 as this combination of alloys does not become sensitive to stress corrosion cracking at elevated temperatures.

WELDING POSITIONS



CURRENT

DC (+) Mig
AC Tig

GAS

Ar

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	
250	100	18	

WELD METAL COMPOSITION(%)

Mg	Mn	Fe	Cr	Al	Zn	Si	Ti
2,4-3,0	0,5-1,0	0,4	0,1	rest	0,25	0,25	0,05-0,2

PACKAGING & WELDING PARAMETERS

Mig(mm)	1,0	1,2		
Kg/spole	7	7		
Ampere(A)	90-175	120-240		
Tig(mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000
Kg/hylsa	2,5	2,5	2,5	2,5