

DESCRIPTION

Executive 5554 is most common aluminum-magnesium alloy for welding 5454 base metal where sustained elevated temperatures above 150°F (65°C) are experienced.

Executive aluminum wire is non-annealed which allows for smoother feedability especially when utilizing long MIG guns.

Our enhanced feedability design uses less lubricant than standard aluminum wire resulting in considerably less fume generation.

APPLICATIONS & FEATURES

Executive 5554 is selected for applications where moderate strength and high ductility are required. Executive 5554 has a strong color match after anodizing with similar base materials.

Suitable for automotive wheels, heat exchangers, chemical storage tanks, over-the-road trailers and rail tank cars.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

| Al | Mn | Fe | Cu | Si | Mg | Ti | Zn | Cr |
|--------------------------|----------------|-----|--------------------|-----|-----|------|------|-----|
| Rem. | 0.7 | 0.1 | 0.01 | 0.1 | 2.7 | 0.15 | 0.01 | 0.1 |
| Tensile Strength: | 33,000 PSI min | | Elongation: | | 17% | | | |
| Yield Strength: | 16,000 PSI min | | | | | | | |

TYPICAL WELDING PARAMETERS

| Process | Diameter | Voltage | Amperage | Gas Flow | Shielding Gas / Flux |
|-------------|----------------|-----------------------------|----------|--------------|----------------------|
| GMAW | .035" | 23-25 | 90-170 | 30 to 50 CFH | 100% Ar |
| | .047" | 25-27 | 110-220 | | |
| | .062" | 26-30 | 200-300 | | |
| GTAW | .093" .125" | Direct Current; Electrode - | | 20 to 30 CFH | 100% Ar |

STANDARD PACKAGING

| | | | |
|-------------------|---------------------------|----------------------------|-----------------------|
| GMAW (MIG) | 16-lb / 20-lb wire spools | 1,536-lb / 1,920-lb pallet | 300-lb / 500-lb drums |
| | 1-lb plastic spools | 20-lb box | |
| GTAW (TIG) | 10-lb tube | 50-lb box | |



CLASSIFICATION

AWS/SFA 5.10, Class **ER5554**