



Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925

5556 ALUMINUM Welding wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

5556 is an aluminum filler that has good ductility and improved crack resistance due to the content of manganese, magnesium and zinc. Commonly used on base metals 5154, 5254, 5454 and 5456.

TYPICAL GMAW WELDING PROCEDURES; DCEP

Wire Diameter	Amps	Volts	Travel speed (ipm)	Argon (cfh)
0.030	60-175	15-24	25-45	25-30
0.035	70-185	15-27	25-40	30-35
3/64	125-260	20-29	24-35	35-45
1/16	170-300	24-30	28-38	45-55
3/32	275-400	26-31	14-20	60-75

TYPICAL GTAW WELDING PROCEDURES; ACHF with Pure or Ziconiated

Hemisphere shape tungsten tip

Filler Wire Size	Tungsten	Amps	Volts	Gas Cup Size	Argon (cfh)	Base thickness
1/16"	1/16"	60-80	15	3/8"	20	1/16"
3/32"	3/32"	125-160	15	3/8"	20	1/8"
1/8"	1/8"	190-220	15	7/16"	20	3/16"
5/32"	5/32"	200-300	15	1/2"	25	1/4"
3/16"	3/16"	330-380	15-20	5/8"	25	3/8"
1/4"	1/4"	400-450	25	5/8"	25	1/2"

Procedures are base on flat position and may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL CHEMISTRY AND PROPERTIES;

Magnesium	Titanium	Manganese	Chromium	Copper	Silicon	Zinc	Iron	Beryllium
4.7-5.5	0.05-0.20	0.05-1.00	0.05-0.20	0.10	0.25	0.25	0.40	0.0008

Aluminum Remainder and others each 0.50 & total 0.15 All values are maximum percentage unless noted

Solidus:1065°F Liquidus:1175°F Density: 0.096 lbs./cu. In. Anodize color: White
Average Tensile Strength All weld metal (as welded) 46,000 psi (317 mpa)

AVAILABLE SIZES: TA 5556= Spools of .030, .035, .040, 3/64, 1/16,
TB 5556 = Cut lengths of .035, 3/64, 1/16, 5/64, 3/32, 1/8, 5/32
Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.10 ER/R 5556
ASME SFA5.10 ER/R 5556

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