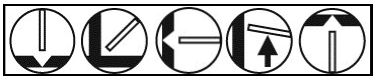
Hobart® MAXAL® 5554

AWS A5.10: ER5554, R5554

WELDING POSITIONS:



FEATURES:

- Moderate/high strength (33 ksi typical)
- Most common 5xxx filler alloy for welding 5454 base material in elevated temperature applications
- Higher ductility/formability

BENEFITS:

- Higher column strength/better feedability
- Good color match after anodizing with 5xxx/6xxx base materials
- Higher hot cracking sensitivity in some applications

APPLICATIONS:

- Matched filler alloy for 5454 applications
- Elevated temperature applications (+150°F)
- Automotive wheels
- Heat exchangers

SHIELDING GAS: 100% Argon (Ar) or Argon/Helium mixtures, typical: GMAW - 35-50 cfh (14-24 l/min), GTAW 20-30 cfh (10-14 l/min).

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP) for GMAW, AC for GTAW

STANDARD DIAMETERS: 3/64" (1.2 mm), 1/16" (1.6 mm), 3/32" (2.4 mm), 1/8" (3.2 mm)

STORAGE: Product should be stored in a dry, enclosed environment, and in its original intact packaging

TYPICAL CHEMICAL VALUES*:

Weld Metal Analysis (%)	ER & R 5554
Silicon (Si)	0.25
Iron (Fe)	0.40
Copper (Cu)	0.10
Manganese (Mn)	0.50-1.0
Magnesium (Mg)	2.4-3.0
Chromium (Cr)	0.05-0.20
Zinc (Zn)	0.25
Titanium (Ti)	0.05-0.20
Beryllium (Be)	<0.0003
Others Each	0.05
Others Total	0.15
Aluminum (Al)	Remainder

*Unless noted-single values are maximums.

TYPICAL PROPERTIES:

Melting Range	Density	Electrical/Thermal Conductivity
1115-1195°F	0.096 lbs/in^3	34% IACS/930 EU

As Welded UTS Typical	Anodized Color	Elevated Temp. Applications +150°F
33 ksi	White	YES

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Diameter Inches	(mm)	Base Material Thickness Inches	(mm)	Amps 4xxx	5xxx	Volts 4xxx	5xxx	Wire-Feed Speed (ipm) 4xxx	5xxx
0.030	(0.8)	1/16	(1.6)	90	100	20	18	260	300
0.030	(0.8)	3/32	(2.4)	110	120	22	21	350	400
0.030	(0.8)	1/8	(3.2)	130	140	23	21	450	500
0.030	(0.8)	3/16	(4.8)	150	160	24	22	550	600
0.035	(0.9)	1/16	(1.6)	90	100	23	21	300	350
0.035	(0.9)	1/8	(3.2)	130	140	24	22	400	450
3/64	(1.2)	3/32	(2.4)	110	120	25	24	170	220
3/64	(1.2)	1/8	(3.2)	150	160	26	25	270	330
3/64	(1.2)	1/4	(6.4)	190	220	26	25	320	370
3/64	(1.2)	3/8	(9.5)	220	230	27	25	390	450
1/16	(1.6)	1/4	(6.4)	200	210	26	24	170	200
1/16	(1.6)	3/8	(9.5)	230	240	27	25	200	230
1/16	(1.6)	1/2	(12.7)	260	270	28	26	240	270
1/16	(1.6)	3/4	(19.1)	280	290	29	27	260	300
1/16	(1.6)	1	(25.4)	300	310	30	28	280	320

See Above: This information was determined by welding using 100%Argon shielding gas with a flow rate between 35-50 cfh (14-24 l/min).

AVAILABLE DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543, or (937) 332-5188 for International Customer Service.

Diameter Inches	(mm)	16-lb. Reel	300-lb. Drum	36-In Cut Length (10-lb)
3/64	(1.2)	555404712	555404723	
1/16	(1.6)	555406212		
3/32	(2.4)			555409470
1/8	(3.2)			555412570

300 lb drum dimensions: diameter = 23-1/2"; height = 36"
100 lb drum dimensions: diameter = 23-1/2"; height = 18"

CONFORMANCES AND APPROVALS:

- **AWS A5.10,** ER5554, R5554
- **ASME SFA 5.10,** ER5554, R5554
- **AWS A5.01** Class S1, Schedule F
- **CWB**

CAUTION:
Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

Revision Date: 130801 (Replaces 110705)
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