

DESCRIPTION

Executive 5556 is an aluminum filler with higher levels of magnesium and zinc than 5356 which will yield increased crack resistance, tensile strength and good ductility.

APPLICATIONS & FEATURES

Executive 5556 may be used for MIG or TIG welding processes. Commonly used on base metals 5154, 5254, 5454 and 5456

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

Al	Mn	Fe	Cu	Si	Mg	Ti	Zn	Cr	Others	TOE
Rem	0.50-1.00	0.40 Max	0.10 Max	0.25 Max	4.70-5.50	0.05-0.20	0.25 Max	0.05-0.20	0.05 Max	0.15 Max
Tensile Strength:		45,000	Elongation:		14%					
Yield Strength:		23,000								

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW	.035"	15-27	70-185	30 to 50 CFH	100% Ar
	.047"	20-29	125-260		
	.062"	24-30	170-300		
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
	1-lb plastic spools	20-lb box
GTAW (TIG)	10-lb tube	50-lb box

CLASSIFICATION

AWS/SFA 5.10, Class **ER5556**

Executive ER5556 can be dual-certified as AWS/SFA 5.10, Class ER5183 when the chemistries overlap.

