



## 5554 – PRODUCT DATA SHEET

Nexalloy 5554 is an aluminum filler typically used on 5454 and similar base metal that may be used in chemical tanks and other storage where 150F may be found.

## NEXAL WELDING PRODUCTS APPROVALS AND SPECIFICATIONS

AWS A5.10 classification ER5554, R5554 Canadian Bureau of Welding – CWB

### Chemical Composition (weight %)

Aluminum	Remainder	Silicon	0.25 Max
Manganese	0.50-1.00	Magnesium	2.4-3.0
Iron	0.40 Max	Chromium	0.05-0.20
Copper	0.10 Max	Titanium	0.05-0.20
Beryllium	0.0003 Max	Zinc	0.25 Max

Other Elements 0.05 Max & Total 0.15 Max

### Typical Properties

Melting Range	1155 – 1195 F	640 – 646 C
Density	.097 lbs\cu in.	
Post Anodize Color	White	

### Wire and Rod Diameters Available

0.030 0.035 3/64" 1/16" 3/32" 1/8" 5/32" 3/16" 1/4" 5/16"

### Packaging Available

**Plastic Spools** – 1LB/0.4KG, 5LB/2.2KG, 10LB/4.5KG, 16LB/7.2KG, 20LB/9KG

**Metal Spools** – 10LB/4.5KG, 15LB /6.8KG **TIG Rods** – 5LB/2.2KG, 10LB/4.5KG, 50LB/22.6KG

**Drums** – 150LB/68KG, 300LB/136KG

### MIG Welding Procedures: DCEP

Wire Diameter	WFS ipm	Amps	Volts	Consumption LB/100FT	Argon(cfh)
0.030	480-625	60-175	15-24	0.65-1.25	25-30
0.035	450-750	70-185	15-27	1.00-4.25	30-35
3/64"	330-500	125-260	20-29	1.00-4.25	35-45
1/16"	250-450	170-300	24-30	3.8-66	45-75
3/32"	160-200	275-400	26-31	35-66	60-85

### TIG Welding Procedures: ACHF- with Pure or Ziconiated Hemisphere shape tungsten tip

Base Thickness	Filler Wire Size	Tungsten	Amps	Consumption LB/100FT	Gas Cup Size	Argon(cfh)
1/16"	1/16"	1/16"	60-80	0.75	3/8"	20
3/32"	3/32"	3/32"	85-120	1.00	3/8"	20
1/8"	3/32"	3/32"	125-160	1.50	3/8"	20
3/16"	1/8"	1/8"	190-220	4.5-6.0	7/16"	25
1/4"	5/32"	5/32"	200-300	8-10	1/2"	30
3/8"	3/16"	3/16"	330-380	15-20	5/8"	35
1/2"	1/4"	1/4"	400-450	25-40	5/8"	40

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