

SUPERGLAZE® 5554

Aluminum ▪ AWS ER5554

KEY FEATURES

- Matching filler alloy for welding 5454 base alloys
- Low magnesium content to closely match the base material chemistry
- Suitable for sustained elevated temperature service, i.e. above 65 °C (150 °F)

WELDING POSITIONS

All, except vertical down

NOTE

- Typical Operating Procedures on pg. I-15 - I-16

CONFORMANCES

SFA/AWS A5.10/A5.10M:	ER5554
ASME SFA-A5.10:	ER5554
CWB/CSA W48-06:	ER5554

TYPICAL APPLICATIONS

- 5454 base alloys
- Automotive wheels
- Transportation applications such as over-the-road trailers and rail tank cars
- Chemical storage tanks

SHIELDING GAS

100% Argon
Argon / Helium Mixtures
Flow Rate: 30 - 50 CFH

DIAMETERS / PACKAGING

Diameter in (mm)	16 lb (7.3 kg) Plastic Spool	300 lb (136 kg) Gem-Pak® Box
3/64 (1.2)	ED029573	ED034725
1/16 (1.6)		ED034730

WIRE COMPOSITION⁽¹⁾ – As Required per SFA/AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
Requirements - AWS ER5554	Remainder	0.25 max	0.40 max	0.10 max	0.50 - 1.00
Typical Results ⁽²⁾	Remainder	0.06	0.13	0.03	0.51
	%Mg	%Cr	%Zn	%Ti	%Be
Requirements - AWS ER5554	2.40 - 3.00	0.05 - 0.20	0.25 max	0.05 - 0.20	0.0003 max
Typical Results ⁽²⁾	2.41	0.06	< 0.01	0.09	0.0001

⁽¹⁾Typical all weld metal. ⁽²⁾See test results disclaimer

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

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