



OK Autrod 5554

OK Autrod 5554 is a solid aluminium wire with a content of 2,7 % Mg. It's recommended for welding of AlMg alloys like 5454. Typical applications are chemical storage tanks, automotive components like wheels and frame sections. The weld metal is not sensitive to stress corrosion cracking at elevated temperatures.

Классификации	AWS A5.10 : ER5554 EN ISO 18273 : S Al 5554 (AlMg2 7Mn)
----------------------	--

Тип сплава	AlMg 2.7Mn
-------------------	------------

Хим. состав проволоки

Mn	Si	Cr	Al	Cu	Ti	Fe	Mg	Zn
0.7	0.1	0.1	96	0.01	0.15	0.1	2.7	0.01

Данные наплавки

Диаметр проволоки	Current	Voltage
1.2 mm	140-260 A	20-29 V
1.2 mm	180-210 A	22-26 V
1.2 mm	125-150 A	20-24 V
1.2 mm	170-240 A	24-28 V
1.6 mm	190-350 A	25-30 V
1.6 mm	240-300 A	22-27 V
1.6 mm	190-260 A	21-26 V
1.6 mm	290-340 A	26-30 V
1.6 mm	260-310 A	22-27 V
1.6 mm	280-320 A	24-28 V