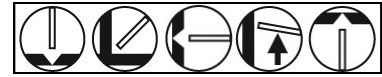


Hobart® Maxal® 5554



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
- 5554 alloy has been spec'd by Ford for aluminum vehicle repair

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),

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

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with AWS A5.10 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers LLC.

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Diameter		Base Material Thickness		Amps	Volts	Wire-Feed Speed (ipm)
Inches	(mm)	Inches	(mm)			
0.035	(0.9)	1/16	(1.6)	100	21	350
0.035	(0.9)	1/8	(3.2)	140	22	450
3/64	(1.2)	3/32	(2.4)	120	24	220
3/64	(1.2)	1/8	(3.2)	160	25	330
3/64	(1.2)	1/4	(6.4)	220	25	370
3/64	(1.2)	3/8	(9.5)	230	25	450
1/16	(1.6)	1/4	(6.4)	210	24	200
1/16	(1.6)	3/8	(9.5)	240	25	230
1/16	(1.6)	1/2	(12.7)	270	26	270
1/16	(1.6)	3/4	(19.1)	290	27	300
1/16	(1.6)	1	(25.4)	310	28	320

Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of aluminum being welded.

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	16-lb. (7.3 kg)	300-lb. (136 kg)
Inches (mm)	Wire Basket	Drum
Net Pallet Weight	1296-lb. (588 kg)	600-lb. (272 kg)
3/64 (1.2)	555404712	—
1/16 (1.6)	—	555406223

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

CONFORMANCES AND APPROVALS:

- AWS A5.10, ER5554, R5554
- ASME SFA 5.10, ER5554, R5554
- AWS A5.01 Class S1, Schedule F
- CWB ER5554, (1.2 mm - 1.6 mm), R5554 (1.2 mm - 1.6 mm)
- vd TUV 1153

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

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, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

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

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

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Revision Date: 230302 (Replaces 210805)

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