



SAFRA Al.Mg.2,7Mn./ER 5554

A.W.S. /ASTM A5.10:
ER 5554

DIN EN ISO 18273:
S Al 5554-AlMg2,7 Mn

DESCRIPTION

The alloy AlMg.2,7Mn has been developed for high temperature applications without becoming sensitive to stress corrosion. The alloy SAFRA Al.Mg.2,7Mn/ER5554 is also suitable for welding the basis metal 5454 with the 6000 series. This alloy is recommended for a wide range of applications in the industry in general and in the structural industry, in particular, whenever high temperature processing is needed.

MATERIALS TO BE WELDED

Al Mg Mn	Al Mg1	Al Mg2	Al Mg2,7Mn	Al Mg3	Al Mg Si 0,5	Al Mg Si 0,8

SHIELDING GASES FOR GMAW/GTAW

Ar 99,99% min.
Ar 75% + He 25%
Ar 50% + He 50%

MINIMAL VALUES OF THE MECHANICAL PROPERTIES (WELDED METAL)

Tensile strenght Rm: 215 N/mm²
Yeld strenght Rp 0,2: 100 N/mm²
Elongation L=5d: 17%

AVAILABLE SIZES

MIG: 6-7 Kg D300 or K300/KS300 Spools

TIG carton box of 10 kg
(x 1000 mm length)

DIAMETER OF THE WIRE

0,8 mm - 1,0 mm - 1,2 mm - 1,6 mm - 2,0 mm - 2,4 mm

DIAMETER OF THE RODS

1,6 mm-2,0 mm-2,4 mm-3,2 mm-4,0 mm-5,0 mm

MORE DIAMETERS AND PACKAGING UPON REQUEST

CHEMICAL COMPOSITION

Al	remainder
Si	<0,25
Fe	<0,40
Cu	<0,10
Mn	0,50 - 1,0
Mg	2,40 - 3,0
Cr	0,05 - 0,20
Zn	<0,25
Ti	0,05 - 0,20
Be	<0,0003

OTHERS EACH <0,05

OTHERS TOTAL <0,15