



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	0.0001 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" 5/64"

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

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

Nexal Aluminum Inc.
www.nexalloy.com

5938 Ambler Drive Mississauga, ON L4W 2N3
An ISO 9001:2008 Certified Company

Phone: 1-905-629-8282
Fax: 1-905-629-8532

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