



Nexalloy ER5754 – PRODUCT DATA SHEET

Nexalloy ER5754 is an Aluminum-alloyed wire for welding of aluminum alloys up to 3% Mg. Good corrosion resistance and excellent color match after anodizing. The weld metal is seawater resistant. ER5754 is suitable for a wide range of applications in general construction and structural industry like Automotive, Storage tank and Shipbuilding.

NEXAL WELDING PRODUCTS APPROVALS AND SPECIFICATIONS

AWS A5.10/A5.10M/ASME SFA 5.10 classification ER 5754, R5754, EN ISO 18273: S Al 5754 (AlMg3), TUV, CE 0035-CPR-C809.

Chemical Composition (weight %)

Aluminum	Remainder	Silicon	0.4 Max
Manganese	0.50 Max	Magnesium	2.6-3.6
Iron	0.40 Max	Titanium	0.15 Max
Copper	0.10 Max	Zinc	0.20 Max
Beryllium	0.0003 Max		
Other Elements	0.05 Max each & Total 0.15 Max		

Typical Properties

Melting Range	1065 – 1175 F 574 – 635 C
Density	.097 lbs.\cu in.
Post Anodize Color	Gray
UTS	62ksi – 430MPA
Elongation	(2") 6%

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	30-45
3/64"	330-500	125-260	20-29	1.00-4.25	35-55
1/16"	250-400	170-300	24-30	3.8-66	45-75

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"	400-500	25-40	5/8"	40



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Aluminum Manufacturing since 1973