5556 ALUMINUM WELD WIRE

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NOMINAL COMPOSITION:

```
Aluminum       BALANCE
Magnesium      4.7-5.5 %
Manganese      .50-.10 %
Silicon        .25 % max.
Beryllium      .0008 % max.
Others         Each .05% max. Total .15% max
Titanium       .05-.20 %
Copper         .10 % max.
Chromium       .05-.20 %
Zinc           .25 % max.
Iron           .40% max.
```

PHYSICAL PROPERTIES:

```
Solidus: 1065 °F (574 °C)
Liquidus: 1175 °F (635 °C)
Density lbs/cu.in: .096
Post Anodize Color: White
As Welded Base Plate of 5456
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Tensile Strength: 46,000 psi
Elongation in 2": 14%
Yield Strength: 23,000 psi
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RECOMMENDED WELDING PARAMETERS:

* GMAW (MIG) Parameters (DC Reverse Polarity) Electrode Positive Spray transfer

```
<table>
<thead>
<tr>
<th>Metal Thickness</th>
<th>Wire Diameter</th>
<th>Amps</th>
<th>Volts</th>
<th>Argon</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/16&quot;</td>
<td>.030</td>
<td>70-110</td>
<td>15-20</td>
<td>25</td>
</tr>
<tr>
<td>1/8&quot;</td>
<td>.030-3/64</td>
<td>120-150</td>
<td>20-24</td>
<td>30</td>
</tr>
<tr>
<td>3/16&quot;</td>
<td>.030-3/64</td>
<td>130-210</td>
<td>22-26</td>
<td>30-35</td>
</tr>
<tr>
<td>1/4&quot;</td>
<td>3/64-1/16</td>
<td>170-225</td>
<td>24-28</td>
<td>40</td>
</tr>
<tr>
<td>3/8&quot;</td>
<td>1/16</td>
<td>225-300</td>
<td>26-29</td>
<td>50</td>
</tr>
</tbody>
</table>

*GTAW (TIG) Parameters (AC) Hemisphere tip shape tungsten electrode

```
<table>
<thead>
<tr>
<th>Metal (1)</th>
<th>Pure or zirconiated</th>
<th>Filler Wire Size</th>
<th>Amps</th>
<th>Volts</th>
<th>ACHF</th>
<th>Gas Cup</th>
<th>Argon (cfh)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/16&quot;</td>
<td></td>
<td>1/16&quot;-3/32&quot;</td>
<td>70-100</td>
<td>15</td>
<td>3/8</td>
<td>20</td>
<td></td>
</tr>
<tr>
<td>1/8&quot;</td>
<td></td>
<td>1/8&quot;-5/32&quot;</td>
<td>125-175</td>
<td>15</td>
<td>7/16</td>
<td>20</td>
<td></td>
</tr>
<tr>
<td>3/16&quot;</td>
<td></td>
<td>5/32&quot;-3/16&quot;</td>
<td>170-225</td>
<td>15</td>
<td>7/16-1/2</td>
<td>25</td>
<td></td>
</tr>
<tr>
<td>1/4&quot;</td>
<td></td>
<td>3/16&quot;-1/4&quot;</td>
<td>220-275</td>
<td>15</td>
<td>1/2</td>
<td>30</td>
<td></td>
</tr>
<tr>
<td>3/8&quot;</td>
<td></td>
<td>1/4&quot;</td>
<td>330-380</td>
<td>15</td>
<td>5/8</td>
<td>35</td>
<td></td>
</tr>
<tr>
<td>1/2&quot;</td>
<td></td>
<td>1/4&quot;</td>
<td>400-450</td>
<td>25</td>
<td>5/8</td>
<td>35</td>
<td></td>
</tr>
</tbody>
</table>
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Additional information available at our web site: www.harrisproductsgroup.com
* All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.

SPECIFICATION COMPLIANCE: ANSI/AWS A5.10, ASME SFA 5.10, QQ-R-566B
Class R/ER 5356

(2) QQ-R-566B = SILICON PLUS IRON SHALL NOT EXCEED .50 %

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health.
ARC RAYS can injure eyes and burn skin.
ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.

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