



## 5556 – PRODUCT DATA SHEET

Nexalloy 5556 is an aluminum filler with higher levels of magnesium and zinc than 5356 which will yield increased crack resistance, tensile strength, and good ductility. Commonly used on 5154, 5254, 5454 and 6456.

## NEXAL WELDING PRODUCTS APPROVALS AND SPECIFICATIONS

AWS A5.10 classification ER5556, R5556 Canadian Bureau of Welding - CWB American Bureau of Shipping - ABS

### Chemical Composition (weight %)

Aluminum	Remainder	Silicon	0.25 Max
Manganese	0.50-1.00	Magnesium	4.70-5.50
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	1065 – 1175 F	574 – 636 C
Density	.096 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" 5/16"

### 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

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