

ALMIGWELD 5556

Alloy 5556 was first utilized in 1956. It develops the highest as-welded strengths in fillet welds and it is nearly double that of 4043. The 5Xxx Series Of Alloys offer an Excellent Combination of Corrosion Resistance, Strength, Toughness, Workability, and Weldability. As a result, they are used in a wide variety of Applications. A Characteristic of this series of Alloys, However, is their susceptibility to stress corrosion cracking when the weld pool chemistry is greater than 3% Mg and there is exposure to prolonged temperatures in excess of 150° F. Special Alloys and Tempers are often required to overcome this problem. Contact Alcotec for assistance in Alloy/Temper selection.

Caractéristiques	
Classements	ANSI/AWS A5.10 : (ER & R)
Agréments	ABS ClassNK CWB DNV KR LR

Les approbations sont basées sur l'emplacement de l'usine. Veuillez contacter ESAB pour plus d'informations.

Type d'alliage	Aluminum
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Propriétés de traction types			
Condition	Limite d'élasticité	Résistance la traction	Allongement
Base Alloy 5456-H112			
Brut de soudage	159 MPa (23 ksi)	310 MPa (45 ksi)	14 %
5456-H112			
Alliage de base	165 MPa (24 ksi)	317 MPa (46 ksi)	22 %

composition du fil							
Mn	Si	Cr	Cu	Ti	Zn	Fe	Mg
0.7	0.05	0.10	0.01	0.080	0.005	0.12	5.2

Paramètres de soudage		
Courant	Diamètre du fil	Tension
100-130 A	0.8 mm (0.030 in.)	18-22 V
125-150 A	0.8 mm (0.030 in.)	20-24 V
85-120 A	0.9 mm (0.035 in.)	20-23 V
125-150 A	0.9 mm (0.035 in.)	20-24 V
170-190 A	0.9 mm (0.035 in.)	21-26 V
140-260 A	1.2 mm (0.047 in.)	20-29 V
125-150 A	1.2 mm (0.047 in.)	20-24 V
180-210 A	1.2 mm (0.047 in.)	22-26 V
170-240 A	1.2 mm (0.047 in.)	24-28 V
140-300 A	1.2 mm (0.047 in.)	20-29 V
190-350 A	1.6 mm (1/16 in.)	25-30 V
240-300 A	1.6 mm (1/16 in.)	22-27 V
190-260 A	1.6 mm (1/16 in.)	21-26 V
290-340 A	1.6 mm (1/16 in.)	26-30 V
260-310 A	1.6 mm (1/16 in.)	22-27 V
280-320 A	1.6 mm (1/16 in.)	24-28 V
300-400 A	2.4 mm (3/32 in.)	26-32 V
280-360 A	2.4 mm (3/32 in.)	26-30 V