

ALUMINIO

ALAMBRES SOLIDOS Y VARILLAS (GMAW/GTAW)

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.

Especificaciones	
Clasificaciones	ANSI/AWS A5.10 : (ER & R)
Aprobaciones	ABS ClassNK CWB DNV KR LR

Las aprobaciones se basan en la ubicación de la fábrica. Póngase en contacto con ESAB para obtener más información.

tipo de aleación	Aluminum
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Propiedades típicas de Tensión			
Condición	Límite de flujo	Resistencia a la tracción	Alargamiento
Base Alloy 5456-H112			
Como queda soldado	159 MPa (23 ksi)	310 MPa (45 ksi)	14 %
5456-H112			
Aleación base	165 MPa (24 ksi)	317 MPa (46 ksi)	22 %

% típico de composición de alambre							
Mn	Si	Cr	Cu	Ti	Zn	Fe	Mg
0.7	0.05	0.10	0.01	0.080	0.005	0.12	5.2

Parámetros de soldadura		
Corriente	Diámetro del Alambre	Tensión
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