

# ALUMINWELD™ 43

Aluminum ■ AWS A5.3-99

## KEY FEATURES

- Designed for arc welding or oxyacetylene flame
- Deposits dense, non-porous and excellent appearance

## WELDING POSITIONS

All, except vertical down

## CONFORMANCES

SFA/AWS A5.3-1999 E4043  
ASME SFA-5.3: E4043

## TYPICAL APPLICATIONS

- Aluminum-silicon alloys, containing less than 5% Mg and less than 2% Cu
- General Fabrication

## DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	0.5 lb Tube (0.23 kg) Carton 6 lb (2.72 kg)	1.0 lb Tube (0.45 kg) Carton 6 lb (2.72 kg)
3/32 2.4	14 (350)	ED035520	ED035521
1/8 3.2	14 (350)	ED035522	ED035523

## DEPOSIT COMPOSITION<sup>(1)</sup>

	%Al	%Mn	%Si	%Fe	Ti%
<b>Requirements</b> - AWS E4043	Remainder	0.05 max	4.5 – 6.00	0.80 max	0.20 max
<b>Typical Results</b> <sup>(3)</sup>	94.82	0.01	4.98	0.14	0.009
	Mg%	Zn%	Be%	%Cu	
<b>Requirements</b> - AWS E4043	0.05 max	0.10 max	0.0008 max	0.30 max	
<b>Typical Results</b> <sup>(3)</sup>	0.01	0.01	<0.0005	0.03	

## TYPICAL OPERATING PROCEDURES

Polarity <sup>(4)</sup>	Current (Amps)		
	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)
DC±	40 – 70	60 – 90	90 – 130

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup> Measured with 0.2% offset. <sup>(3)</sup> See test results disclaimer. <sup>(4)</sup> Preferred polarity is listed first.

# SUPERGLAZE® 4043

Aluminum ▪ AWS ER4043

## KEY FEATURES

- Designed for welding heat-treatable base alloys and more specifically 6XXX series alloys
- Lower melting point and more fluidity than 5XXX series filler alloys
- Low sensitivity to weld cracking with 6XXX series base alloys
- Suitable for sustained elevated temperature service, i.e. above 65°C (150°F)
- Not recommended for materials to be anodized

## WELDING POSITIONS

All, except vertical down

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

SFA/AWS A5.10/A5.10M:	ER4043
ASME SFA-A5.10:	ER4043
CWB/CSA W48-06:	ER4043

## TYPICAL APPLICATIONS

- For welding 6XXX alloys, and most casting alloys
- Automotive components such as frame and drive shafts
- Bicycle frames

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH

## DIAMETERS / PACKAGING

Diameter in (mm)	1 lb (0.5 kg) Plastic Spool 20 lb (9.1 kg) Master Carton	16 lb (7.3 kg) Plastic Spool	20 lb (9.1 kg) Plastic Spool	275 lb (125 kg) Gem-Pak™ Box
0.030 (0.8)	ED030307			
0.035 (0.9)	ED030308	ED028395		ED034721
3/64 (1.2)	ED030310		ED029234	ED034548
1/16 (1.6)			ED030281	ED034549

## WIRE COMPOSITION<sup>(1)</sup> – As Required per SFA/AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> – AWS ER4043	Remainder	4.50–6.00	0.80 max	0.30 max	0.05 max
<b>Typical Results</b> <sup>(2)</sup>	Remainder	5.26	0.15	0.01	0.01
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> – AWS ER4043	0.05 max	—	0.10 max	0.20 max	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	0.03	—	0.001	0.01	<0.0002

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

# SUPERGLAZE® 4047

Aluminum ▪ AWS ER4047

## KEY FEATURES

- Lower melting point and higher fluidity than 4043 wires
- Can be used as a substitute for 4043 wires to increase silicon in the weld metal, minimize hot cracking and produce higher fillet weld shear strength

## WELDING POSITIONS

All, except vertical down

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

SFA/AWS A5.10/A5.10M: ER4047

ASME SFA-A5.10 ER4047

## TYPICAL APPLICATIONS

- Automotive components
- Heat exchangers
- Body panels
- Brazing of aluminum sheets, extrusions and castings

## SHIELDING GAS

100% Argon

Argon / Helium Mixtures

Flow Rate: 30 - 50 CFH

## DIAMETERS / PACKAGING

Diameter in (mm)	16 lb (7.3 kg) Plastic Spool	275 lb (125 kg) Gem-Pak™ Box
0.035 (0.9)	EDS28415	
3/64 (1.2)	EDS28417	ED034759
1/16 (1.6)	EDS28418	ED034760

## WIRE COMPOSITION<sup>(1)</sup> – As Required per SFA/AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER4047	Remainder	11.00-13.00	0.80 max	0.30 max	0.15 max
<b>Typical Results</b> <sup>(2)</sup>	As Reported per AWS Requirements				
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER4047	0.10 max	—	0.20 max	—	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	As Reported per AWS Requirements				

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

# SUPERGLAZE® 5183

Aluminum ▪ AWS ER5183

## KEY FEATURES

- Designed for applications where higher strength is required
- For 5083 and 5456 base materials

## WELDING POSITIONS

All, except vertical down

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

<b>SFA/AWS A5.10/A5.10M:</b>	ER5183
<b>ASME SFA-A5.10:</b>	ER5183
<b>ABS:</b>	IACS W26 Grade WC
<b>Lloyd's Register:</b>	WC/I-1 S
<b>DNV Grade:</b>	5183
<b>GL:</b>	RAIMg4,5
<b>BV Grade:</b>	WC
<b>CWB/CSA W48-06:</b>	ER5183

## TYPICAL APPLICATIONS

- Marine fabrication and repair
- Cryogenic tanks
- Shipbuilding and other high strength structural aluminum applications
- Bicycle frames
- Railing industry
- Offshore industry

## DIAMETERS / PACKAGING

Diameter in (mm)	1 lb (0.5 kg) Plastic Spool 20 lb (9.1 kg) Master Carton	16 lb (7.3 kg) Plastic Spool	300 lb (136 kg) Gem-Pak™ Box
0.035 (0.9)	EDS30322	EDS28437	ED034789
3/64 (1.2)		EDS28438	ED034791
1/16 (1.6)			ED034792

## WIRE COMPOSITION<sup>(1)</sup> – As Required per SFA/AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER5183	Remainder	0.40 max	0.40 max	0.10 max	0.50 - 1.00
<b>Typical Results</b> <sup>(2)</sup>	Remainder	0.03	0.13	0.001	0.65
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER5183	4.30 - 5.20	0.05 - 0.25	0.25 max	0.15 max	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	4.99	0.10	0.02	0.07	0.0002

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

# SUPERGLAZE® HD 5183

Aluminum ■ AWS ER5183

## KEY FEATURES

- Designed for heavy duty applications
- Reduced shavings and improved feedability
- For 5083 and 5456 base materials

## WELDING POSITIONS

All

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH for Argon

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

<b>SFA/AWS A5.10/A5.10M:</b>	ER5183
<b>ABS:</b>	WC/I-1
<b>Lloyd's Register:</b>	WC/I-1
<b>DNV Grade:</b>	5183/I1
<b>ISO 18273:</b>	S Al 5183 (AlMg4.5Mn0.7CA1)

## TYPICAL APPLICATIONS

- Ideal for aggressive work environments and applications with long conduit lengths
- Marine fabrication and repair
- Cryogenic tanks
- Shipbuilding and other high strength structural aluminum applications
- Railcars
- Offshore industry

## DIAMETERS / PACKAGING

Diameter in (mm)	16 lb (7.3 kg) Steel Spool	20 lb (9.1 kg) Plastic Spool	300 lb (136 kg) Gem-Pak™ Box
0.035 (0.9)	ED035690	ED035691	ED036341
3/64 (1.2)	ED035692	ED035693	ED036342
1/16 (1.6)	ED035694	ED035695	ED036343

## WIRE COMPOSITION<sup>(1)</sup> – As Required per AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER5183	Remainder	0.40 max	0.40 max	0.10 max	0.50-1.0
<b>Typical Results</b> <sup>(2)</sup>	Remainder	0.03	0.13	0.001	0.65
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER5183	4.3-5.2	0.05-0.25	0.25 max	0.15 max	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	5.0	0.10	0.02	0.07	0.00002

<sup>(1)</sup>Typical wire chemistry. <sup>(2)</sup>See test results disclaimer

# SUPERGLAZE® 5356

Aluminum ▪ AWS ER5356

## KEY FEATURES

- General purpose filler alloy for welding 5XXX series alloys
- The most widely used welding alloy

## WELDING POSITIONS

All, except vertical down

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

SFA/AWS A5.10/A5.10M:	ER5356
ASME SFA-A5.10:	ER5356
Lloyd's Register:	WB/I-1 S
DNV Grade:	5356
GL:	RAIMg4
BV Grade:	WB
CWB/CSA W48-06:	ER5356

## TYPICAL APPLICATIONS

- Automotive bumpers and supports
- Structural frames in the shipbuilding industry
- Formed truck panels
- Railing Industry
- Power Industry
- Trailer Manufacturing

## DIAMETERS / PACKAGING

Diameter in (mm)	1 lb (0.4 kg) Plastic Spool 20 lb (9.1 kg) Master Carton	16 lb (7.3 kg) Platic Spool	20 lb (9.1 kg) Plastic Spool	300 lb (136 kg) Accu-Pak® Box	300 lb (136 kg) Gem-Pak™ Box
0.035 (0.9)	ED030312	ED028385		ED033178 <sup>(a)</sup>	ED034722
3/64 (1.2)	ED030314		ED030282	ED031826 <sup>(b)</sup>	ED034550
1/16 (1.6)			ED030283	ED030985 <sup>(b)</sup>	ED034551

<sup>(a)</sup>This part number is Made-To-Order. <sup>(b)</sup>Wire payoff kit K2860-1 sold separately.

## WIRE COMPOSITION<sup>(1)</sup> – As Required per SFA/AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER5356	Remainder	0.25 max	0.40 max	0.10 max	0.05 - 0.20
<b>Typical Results</b> <sup>(2)</sup>	Remainder	0.05	0.09	0.03	0.12
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER5356	4.50 - 5.50	0.05 - 0.20	0.10 max	0.06 - 0.20	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	4.90	0.08	< 0.01	0.15	0.0002

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

# SUPERGLAZE® HD 5356

Aluminum ▪ AWS ER5356

## KEY FEATURES

- Designed for heavy duty applications
- Reduced shavings and improved feedability
- General purpose filler alloy for welding 5XXX series alloys

## WELDING POSITIONS

All

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH for Argon

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

<b>SFA/AWS A5.10/A5.10M:</b>	ER5356
<b>ABS:</b>	WB/I-1
<b>Lloyd's Register:</b>	WB/I-1
<b>DNV Grade:</b>	5356/I-1
<b>ISO 1B273:</b>	S Al 5356 (ALMg5CrCA1)

## TYPICAL APPLICATIONS

- Ideal for aggressive work environments and applications with long conduit lengths
- Automotive bumpers and supports
- Structural frames in the shipbuilding industry
- Formed truck panels
- Railcars
- Power industry
- Trailer manufacturing

## DIAMETERS / PACKAGING

Diameter in (mm)	16 lb (7.3 kg) Steel Spool	20 lb (9.1 kg) Plastic Spool	300 lb (136 kg) Gem-Pak™ Box
0.035 (0.9)	ED035672	ED035673	ED036335
3/64 (1.2)	ED035674	ED035675	ED036336
1/16 (1.6)	ED035676	ED035677	ED036337

## WIRE COMPOSITION<sup>(1)</sup> – As Required per AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER5356	Remainder	0.25 max	0.40 max	0.10 max	0.05-0.20
<b>Typical Results</b> <sup>(2)</sup>	Remainder	0.05	0.09	0.03	0.12
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER5356	4.5-5.5	0.05-0.20	0.10 max	0.06-0.20	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	4.9	0.08	<0.01	0.15	0.0002

<sup>(1)</sup>Typical wire chemistry. <sup>(2)</sup>See test results disclaimer

# SUPERGLAZE® 5356 TM™

Aluminum ▪ AWS ER5356

## KEY FEATURES

- Unparalleled bead profile and appearance which are critical for groove and fillet welds on aluminum trailer beds.
- SuperGlaze® 5356 TM™ has an engineered chemical composition developed specifically to outperform standard ER5356 electrodes and gives the operator unprecedented control.
- Proprietary manufacturing processes give SuperGlaze® 5356 TM™ the smoothest surface finish in the industry, making it ideal for automatic applications on formed truck panels.

## WELDING POSITIONS

All, except vertical down

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

SFA/AWS A5.10/A5.10M:	ER5356
ASME SFA-A5.10:	ER5356
CWB/CSA W48-06:	ER5356

## TYPICAL APPLICATIONS

- High speed groove welds on formed truck panels
- Multi-pass fillet and lap welds on 6XXX series base materials
- Robotic fillet welds on trailer tanks requiring minimal post-weld clean up

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH

## DIAMETERS / PACKAGING

Diameter in (mm)	1 lb (0.4 kg) Plastic Spool 20 lb (9.1 kg) Master Carton	16 lb (7.3 kg) Steel Spool	20 lb (9.1 kg) Plastic Spool	275 lb (125 kg) Gem-Pak™
0.035 (0.9)	ED034064	ED034067		ED034723
3/64 (1.2)	ED034065	ED034068	ED034070	ED034724
1/16 (1.6)	ED034066	ED034069	ED034071	ED034729

## WIRE COMPOSITION<sup>(1)</sup> – As Required per SFA/AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> – AWS ER5356	Remainder	0.25 max	0.40 max	0.10 max	0.05 - 0.20
<b>Typical Results</b> <sup>(2)</sup>	Remainder	0.065	0.15	0.0035	0.125
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> – AWS ER5356	4.50 - 5.50	0.05 - 0.20	0.10 max	0.06 - 0.20	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	4.565	0.11	0.0075	0.085	0.0002

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer



# SUPERGLAZE® HD 5356 TM™

Aluminum ▪ AWS ER5356

## KEY FEATURES

- Designed for heavy duty applications
- Reduced shavings and improved feedability
- High speed groove welds on formed truck panels
- Multi-pass fillet and lap welds on 6XXX series base materials
- Robotic fillet welds on trailer tanks requiring minimal post-weld clean up

## WELDING POSITIONS

All

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

SFA/AWS A5.10/A5.10M: ER5356  
 ASME SFA-A5.10: ER5356  
 ISO 18273: S Al5356 (AlMg5CrCa1)

## TYPICAL APPLICATIONS

- Ideal for aggressive work environments and applications with long conduit lengths
- Trailer manufacturing

## SHIELDING GAS

100% Argon  
 Argon / Helium Mixtures  
 Flow Rate: 30 - 50 CFH for Argon

## DIAMETERS / PACKAGING

Diameter in (mm)	16 lb (7.3 kg) Steel Spool	20 lb (9.1 kg) Plastic Spool	300 lb (136 kg) Gem-Pak™ Box
0.035 (0.9)			ED036338
3/64 (1.2)	ED035698	ED035699	ED036339
1/16 (1.6)	ED035700	ED035701	ED036340

## WIRE COMPOSITION<sup>(1)</sup> – As Required per AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER5356	Remainder	0.25 max	0.40 max	0.10 max	0.05-0.20
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER5356	4.5-5.5	0.05-0.20	0.10 max	0.06-0.20	0.0003 max

<sup>(1)</sup>Typical wire chemistry.

# SUPERGLAZE® 5554

Aluminum ▪ AWS ER5554

## KEY FEATURES

- Matching filler alloy for welding 5454 base alloys
- Low magnesium content to closely match the base material chemistry
- Suitable for sustained elevated temperature service, i.e. above 65°C (150°F)

## WELDING POSITIONS

All, except vertical down

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

<b>SFA/AWS A5.10/A5.10M:</b>	ER5554
<b>ASME SFA-A5.10:</b>	ER5554
<b>CWB/CSA W48-06:</b>	ER5554

## TYPICAL APPLICATIONS

- 5454 base alloys
- Automotive wheels
- Transportation applications such as over-the-road trailers and rail tank cars
- Chemical storage tanks

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH

## DIAMETERS / PACKAGING

Diameter in (mm)	16 lb (7.3 kg) Plastic Spool	300 lb (136 kg) Gem-Pak® Box
3/64 (1.2)	ED029573	ED034725
1/16 (1.6)		ED034730

## WIRE COMPOSITION<sup>(1)</sup> – As Required per SFA/AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER5554	Remainder	0.25 max	0.40 max	0.10 max	0.50 - 1.00
<b>Typical Results</b> <sup>(2)</sup>	Remainder	0.06	0.13	0.03	0.51
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER5554	2.40 - 3.00	0.05 - 0.20	0.25 max	0.05 - 0.20	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	2.41	0.06	< 0.01	0.09	0.0001

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

# SUPERGLAZE® 5556

Aluminum ▪ AWS ER5556

## KEY FEATURES

- Provide higher tensile strengths for welding of higher strength 5XXX alloys, such as 5456
- Increased amounts of magnesium and manganese

## WELDING POSITIONS

All, except vertical down

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

SFA/AWS A5.10/A5.10M: ER5556  
ASME SFA-A5.10: ER5556

## TYPICAL APPLICATIONS

- 5XXX alloys, such as 5083 and 5456
- Pressure vessels
- Storage tanks
- Military

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH

## DIAMETERS / PACKAGING

Diameter in (mm)	1 lb (0.4 kg) Plastic Spool 20 lb (9.1 kg) Master Carton	16 lb (7.3 kg) Plastic Spool	300 lb (136 kg) Gem-Pak™ Box
3/64 (1.2)	EDS30329	EDS29581	ED034767
1/16 (1.6)		EDS29582	ED034731
3/32 (2.4)		ED034175	

## WIRE COMPOSITION<sup>(1)</sup> – As Required per SFA/AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER5556	Remainder	0.25 max	0.40 max	0.10 max	0.50 - 1.00
<b>Typical Results</b> <sup>(2)</sup>	Remainder	0.03	0.13	0.001	0.65
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER5556	4.70 - 5.50	0.05 - 0.20	0.25 max	0.05 - 0.20	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	5.00	0.10	0.02	0.07	0.0002

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

# SUPERGLAZE® HD 5556

Aluminum ■ AWS ER5556

## KEY FEATURES

- Designed for heavy duty applications
- Reduced shavings and improved feedability
- Provide higher tensile strengths for welding 5XXX series alloys
- Increased amounts of magnesium and manganese

## WELDING POSITIONS

All

## NOTE

- Typical Operating Procedures on pg. I-15 - I-16

## CONFORMANCES

**AWS A5.10/A5.10M:** ER5556  
**ISO:** S Al5556 (AlMg5Mn6Ti)

## TYPICAL APPLICATIONS

- Ideal for aggressive work environments and applications with long conduit lengths
- Pressure vessels
- Storage tanks

## SHIELDING GAS

100% Argon  
 Argon / Helium Mixtures  
 Flow Rate: 30 - 50 CFH for Argon

## DIAMETERS / PACKAGING

Diameter in (mm)	16 lb (7.3 kg) Steel Spool	20 lb (9.1 kg) Plastic Spool	300 lb (136 kg) Gem-Pak™ Box
0.035 (0.9)			ED036380
3/64 (1.2)	ED035680	ED035681	ED036381
1/16 (1.6)			ED036382

## WIRE COMPOSITION<sup>(1)</sup> – As Required per AWS A5.10/A5.10M

	%Al	%Si	%Fe	%Cu	%Mn
<b>Requirements</b> - AWS ER5556	Remainder	0.25 max	0.40 max	0.10 max	0.50 - 1.0
<b>Typical Results</b> <sup>(2)</sup>	Remainder	0.03	0.13	0.001	0.65
	%Mg	%Cr	%Zn	%Ti	%Be
<b>Requirements</b> - AWS ER5556	4.7 - 5.5	0.05 - 0.20	0.25 max	0.05 - 0.20	0.0003 max
<b>Typical Results</b> <sup>(2)</sup>	5.0	0.10	0.02	0.07	0.0002

<sup>(1)</sup>Typical wire chemistry. <sup>(2)</sup>See test results disclaimer