

Brand Name & Classification

AWS/ASME SFA-5.3: E 4043
DIN 1732: EL-AISI 5

Approvals Grade

Properties

Electrode with special covering for the welding of aluminium silicon alloys and for joining dissimilar aluminium alloys. Electrode should be held perpendicular to the work piece and a short arc length maintained. Plates thicker than 10mm and larger work pieces require preheating in the range of 150 – 250^o c. Since slag residues are corrosive, they must be completely removed from the weld bead. Electrode serves well as consumable in oxyacetylene welding. The covering being hygroscopic, the electrodes must be stored in an absolutely dry location, or redried as required.

Application

AlMgSi and AlMg alloys up to 2.5% Mg, AlMnCu, AlSi cast alloys.

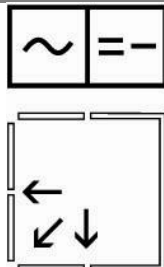
**Weld Metal Analysis
Typical values**

Aluminium: Base
Silicon: 5.00
Iron: 0.30

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation
>90 N/MM ²	160 N/mm ²	>15 %

Welding Current & Positions



Current

Dia	Length	Amperes
2.5	300	60-90
3.2	350	80-110
4.0	350	110-150