



## ALU Si5

Electrodes MMA [SMAW]

Aluminium alloys

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 18273-A : AlSi5 (4032A) DIN 1732 : EL-AlSi5 AWS A-5.3 : E 4043 W.Nr. : 3.2245		Hardfacing and repairing Metallurgy (Steelworks)
<ul style="list-style-type: none"><li>• Very good weldability</li><li>• Good penetration and pore-free deposit.</li><li>• Unique easily removable slag.</li></ul>		
Base material		
EN/DIN	W.Nr.	ISO/EN
AlMgSi0,5	3.3206	6060
AlMgSi0,7	3.3210	6005A
AlMgSi1	3.2315	6082
AlMg1SiCu	3.3211	6061
AlSi7Mg0,3	3.2371	4210
G-AlSi5Mg	3.2341	3XXX
G-AlSi6Cu4	3.2151	4500
AlMgSi	3.2305	6060
AlZn4,5Mg1	3.4335	7072
Typical chemical composition %		
Si 5,0	Fe 0,50	Al 94,5
Typical mechanical properties		
Yield strength Re [N/mm2]	>70	
Tensile strength Rm [N/mm2]	140	
Elongation A5 [%]	>12	
Hardness	60[HB] /	
Coating type	special alkaline	
Heat treatment	To avoid weld porosity, base material > 5 mm thick should be heated to 200-250°C.	
Welding current		
Welding positions		
Redrying	100-150°C / 1-2 h	

approximately 130% of standard current (Hot Start). Hold the electrode at right angles to the material to be welded. Weld on a very short arc, they move forward quickly. Materials thicker than 5 [mm] should be preheated to about 100-200 [°C]. A high bead indicates too cold base material or too low welding parameters. The remains of the slag formed should be very well cleaned from the face of the weld.

#### Welding parameters and packing

Due to the high hygroscopicity of the coating, the product should be stored in clean and dry places. Welding instruction: Start welding at

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350 /	50-80	2,0	8,0	106
3,2	350 /	80-110	2,0	8,0	74
4,0	350 /	110-150	2,0	8,0	51

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