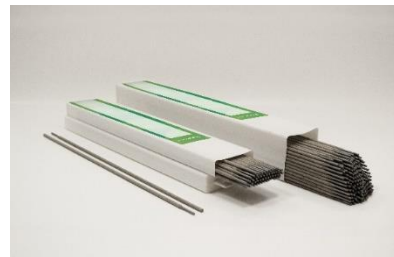


Mise à jour : 16/11/2021

ALUMINIUM ELECTRODE

#Item	EAN	MDM	Dimensions
884441	3660338378546	12036270	2.5 x 350 / 18 UNITS
884442	3660338378553	12036271	3.2 x 350 / 10 UNITS



Description

Aluminium electrode with 5%Si for welding and repairing aluminium or aluminium alloy pieces (AlSi, AlCuSiMn, AlSiMg, AlZnMg...). For joints between aluminium and aluminium-alloys, as well as for aluminium castings.

Applications

Engine blocks, cylinder heads, tanks, containers, frames, lorry tipper

Base materials

DIN	Material N°
G-AlSi6Cu4	3.2151
AlMgSi1	3.2315
G-AlSi5Mg	3.2341
G-AlSi7Mg	3.2371
AlMgSi0,5	3.3206
AlMgSi0,7	3.3210
AlMg1SiCu	3.3211

Typical Weld Metal Composition (%)

Si	Mn	Fe	Al
5.0	<0.5	<0.5	Base

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
70-100	110-160	>15	~50HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350
Current	(A)	60	90

Clean the weld zone; preheat massive pieces (more than 6mm of thickness) to 150-250°C. In order to avoid all risks of porosity, weld with a short arc and guide the electrode at 90° to the piece to be welded. Use a fast travel speed, remove slag between passes and when finished. Warning! Aluminium electrodes are very sensitive to humidity pick-up. Therefore, keep the opened tins in a dry place. In case of humidity pick-up, dry the electrodes 2h/100°C.

Classification

AWS A5.3 : E4043
UNS : A94043

DIN 1732 : EL-AISi5
N de Mat. 3.2245