

EL-AISi5

CATEGORY SMAW Stick Electrodes

TYPE Coated electrode for rapidly joining aluminum alloys and aluminium cast alloys..

APPLICATIONS Stick electrode for welding Aluminium alloys with maximum 2% alloying elements and for aluminium alloys containing up to 7% Si.

PROPERTIES Very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up. (after anodizing the welding will appear as a dark grey color)

CLASSIFICATION

AWS	5.3: E 4043
EN ISO	EN 573-3: E AISi5
DIN: W.Nr.	3.2245
DIN	1732: EL-AISi5

SUITABLE FOR AlSi alloys with max. 7% Silicium, AlMg alloys with max. 3% Magnesium, 3.3206, 3.3210, 3.2315, 3.3211, 3.2371, 3.2341, 3.2151, AlMgSi 0.5, AlMgSi 0.7, AlMgSi 1, AlMg 1SiCu, G.AISI 7 Mg, G.AISI 5 Mg, G.AISI 6 CU 4,

WELDING POSITIONS:



TYPICAL WELD DEPOSIT ANALYSIS (WEIGHT %)

Si	Cu	Fe	Mg	Mn	Zn	Ti	Be	Al
5.25	0.23	0.80	0.04	0.04	0.08	0.20	0.0008	Rem

MECHANICAL PROPERTIES (MAX)

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	150	230	18				

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (DC+)	kg / can	kg / 6pack	type
2.0	250	20-60	2	12	Hermetically closed
2.5	350	50-80	2	12	Hermetically closed
3.2	350	70-120	2	12	Hermetically closed
4.0	350	110-150	2	12	Hermetically closed