

AlSi 5 Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Tig aluminium welding wire alloyed with silicon

APPLICATIONS Tig filler metal for welding Aluminium alloys with maximum 2% alloying elements and for aluminium alloys containing up to 7% Si.(after anodizing welding will be of a dark grey colour)

PROPERTIES Thanks to its excellent Weldability and good penetration this alloy is used mainly in construction and automotive industry. The silicon addition results in improved fluidity (wetting action), making the alloy the preferred choice of welders. The alloy is not sensitive to weld cracking and produces bright, almost smut-free welds. Not recommended for anodising. Non-heat treatable. Thicker sections should be preheated (150°C) prior to welding.

CLASSIFICATION

AWS	A 5.10: ER 4043
EN ISO	18273: S Al 4043A (Al Si 5(A))
DIN: W.Nr.	3.2245
DIN	1732: SG-AlSi5

SUITABLE FOR AlMgSi 0, AlSiMg (A), AlSi 1 MgMn, AlMg1SiCu, 3.3206, 3.3210, 3.2315, 3.3211, EN AW 6060, EN AW 6005A, EN AW 6082, EN AW 6061, EN AC 45000,

APPROVALS CE approved

WELDING POSITIONS:



CHEMICAL COMPOSITION

Al	Mn	Si	Other	Be	Ti	Fe	Cu	Mg	Zn
rem	<0.5	4.5-6.0	<0.15	<0.0005	<0.15	<0.4	<0.5	<0.5	<0.10

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			T (°C)
				-20°C	-40°C	-60°C	
AW	>70	>130	>17				573-625

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters	Packing (kg)	
		single	master
1,6 x 1000	Current (A) AC	5	20
2.0 x 1000	25-50	5	20
2.4 x 1000	40-75	5	20
3.2 x 1000	90-130	5	20
	160-240	5	20

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1