

## AISI 5

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Mig aluminium welding wire alloyed with silicon

**APPLICATIONS** Mig 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 (AISI5(A))
DIN: W.Nr.	3.2245
DIN	1732: SG-AISI5

**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	4.5-5.5	<0.15	<0.0008	<0.15	<0.4	<0.5	<0.5	<0.10

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool / drum	kg / pallet
0.8	13-24	60-170	D-200 / KD-300 / Drum	2 / 7 / 80	400 / 504 / 320
1.0	15-26	90-210	D-200 / KD-300 / Drum	2 / 7 / 80	400 / 504 / 320
1.2	20-29	140-260	D-200 / KD-300 / Drum	2 / 7 / 80	400 / 504 / 320
1.6	25-30	190-350	KD-300 / Drum	7 / 80	504 / 320

**REDRYING TEMPERATURE** not required

**GAS ACC. EN ISO 14175:** I1, I3