ALU Si5

Electrodes MMA [SMAW]

Aluminium alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
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)

- Very good weldability
- Good penetration and pore-free deposit.
- Unique easily removable slag.

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	Fe	Al
5,0	0,50	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

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl