

ALU Si5

CLASSIFICATION:

EN ISO 18273-A: AISi5 (4032A)

DIN 1732: EL-AISi5

AWS A-5.3: E 4043

W.Nr.: 3.2245

DESCRIPTION:

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

BASE MATERIAL:

EN	W.Nr.	DIN
6060	3.3206	AlMgSi0,5
6005A	3.3210	AlMgSi0,7
6082	3.2315	AlMgSi1
6061	3.3211	AlMg1SiCu
4210	3.2371	AlSi7Mg0,3
3XXX	3.2341	G-AlSi5Mg
4500	3.2151	G-AlSi6Cu4
6060	3.2305	AlMgSi
7072	3.4335	AlZn4,5Mg1

TYPICAL CHEMICAL COMPOSITION (%):

Si 0,50 Fe 0,50 Al 94,50

TYPICAL MECHANICAL PROPERTIES:**Re:** >70 N/mm²**Rm:** 140 N/mm²**A5:** >12%**Hardness:** 60 HB**Coating:** special alkaline**Redrying:** 100-150°C / 1-2 h

To avoid weld porosity, parent material > 5 mm thick should be heated to 200-250°C. Due to the high hygroscopicity of the coating, the product should be stored in clean and dry places.

φ	Welding parameters		Packing		
	Length [mm]	Current [A]	Weight of packet [kg]	Weight of carton[kg]	Pcs/1 kg
2,5	300	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