

Coating type:

Special

Arc voltage: 65V

Current:



Tip colour:

-

Welding positions:



Printing:

-

Aluminil Si 5 is our special coated aluminium electrode for welding, repairing and surfacing forged and cast aluminium-silicon alloys and joining dissimilar aluminium alloys with max. 7%Si content. The easy flowing characteristics make the electrode suitable for welding all aluminium castings (except AlMg castings). The electrode has a pure white coating specifically designed to reduce moisture pick-up. For thicker plate materials (≥ 15 mm.) it is recommended to preheat at 150°C to 250°C before welding.

Base materials to be welded:

- Aluminium-MgSi alloys
- Aluminium-Mg alloys up to 2,5% Mg
- Aluminium-MnCu alloys
- Aluminium-Si cast alloys
- Joining dissimilar aluminium alloys

Applications:

- General fabrication & construction (aluminium base metals)
- Shipbuilding & Offshore
- Repair & Maintenance

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	AL Si 5	-	AL Si 5	-	Fluxcored AL Si5

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
	0,05	5,0						0,05			Bal.

Note: Zn 0,10 - Fe 0,20

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Hardness
As welded	≥ 90	≥ 160	≥ 15	40-55 HB

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	9,0	60-90
3,2	350	13,2	80-110
4,0	350	20,4	110-150