

## E AISi 5

**CATEGORY** SMAW Stick Electrodes

**TYPE** Coated electrode for rapidly joining aluminum alloys and aluminium cast alloys..

**APPLICATIONS** Stick electrode for welding Aluminium alloys with maximum 2% alloying elements and for aluminium alloys containing up to 7% Si.

**PROPERTIES** Very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up. (after anodizing the welding will appear as a dark grey color)

**CLASSIFICATION**

AWS	5.3: E 4043
EN ISO	EN 573-3: E AISi5
DIN: W.Nr.	3.2245
DIN	1732: EL-AISi5

**SUITABLE FOR** AISi alloys with max. 7% Silicium, AlMg alloys with max. 3% Magnesium, 3.3206, 3.3210, 3.2315, 3.3211, 3.2371, 3.2341, 3.2151, AlMgSi 0.5, AlMgSi 0.7, AlMgSi 1, AlMg 1SiCu, G.AISI 7 Mg, G.AISI 5 Mg, G.AISI 6 CU 4,

**WELDING POSITIONS:**



### TYPICAL WELD DEPOSIT ANALYSIS (WEIGHT %)

Si	Cu	Fe	Mg	Mn	Zn	Ti	Be	Al
5.25	0.23	0.80	0.04	0.04	0.08	0.20	0.0008	Rem

### MECHANICAL PROPERTIES (MAX)

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			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	150	230	18				

AW: as welded

### WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (DC+)	kg / can	kg / 6pack	type
2.0	250	20-60	2	12	Hermetically closed
2.5	350	50-80	2	12	Hermetically closed
3.2	350	70-120	2	12	Hermetically closed
4.0	350	110-150	2	12	Hermetically closed