



Alumig Si5

GMAW - MIG MAG

Aluminium alloys

Date:	2007-10-08
Revision:	8

Description:

Aluminium MIG wire containing 5% Silicon for welding Al / Si and Al / Mg / Si material. The medium strength weld metal has excellent resistance to hot cracking. Not suitable where good colour match is required after anodising. Melting range 570-630°C.

Welding current:

DC+

Wire composition, wt.%

	Si	Mn	Cu	Al	Ti	Zn	Mg
Min	4,5						
Typical	5,0	0,01	0,03	bal.	0,01	0,01	0,01
Max	5,5	0,05	0,05	bal.	0,15	0,10	0,05

	Fe
Min	
Typical	0,2
Max	0,4

Shielding gas:

I1, Argon 16-20 l/min.

I2, Helium 16-20 l/min.

I3, Argon/Helium 16-20 l/min.

Chemical composition, wt.%

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 40 MPa	55 Mpa
Tensile Strength, Rm:	≥ 120 MPa	140 MPa
Elongation, A5	≥ 8%	10%

Classification:

EN ISO 18273

AWS A5.10

S Al 4043A (AlSi5)

ER 4043

Approvals:

TÜV

DB

CE

Kennblatt Nr 61.042.05

Product data

Diam.mm	Product code	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	9505-2008			70-110	18-22
1,0	9505-2010			100-150	18-22
1,2	9505-2012			140-210	19-25
1,6	9505-2016			170-320	20-26
0,8	9505-3008				
1,0	9505-3010				
1,2	9505-3012				