



ALBOND 5 Si

NON FERROUS (Al Alloys)



Aluminum Welding Electrode for joining wrought and cast 4043 type alloy.

CLASSIFICATION : AWS A/SFA 5.3

DIN 1732

E 4043

EL Al Si 5

KEY FEATURES :

- Special coated electrode
- Keep short arc to avoid burn through and excessive spattering
- Electrode dia. should roughly be equivalent to plate thickness
- Provide high melting rate
- Slag residues should be thoroughly removed to obtain non corrosive weld
- Section thickness above 8 mm should be preheated to min. 200°C

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Fabrication and repair of wrought and cast Al alloys with Si upto 7%
- Welding of similar grade Al alloys in the form of pipe, plate, forging & casting

REDRYING CONDITION : Keep electrodes dry.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	Si	Fe	Zn	Cu	Ti	Al
Typical	5.0	0.2	0.05	0.2	0.1	Bal.
Specification	4.5-6.0	0.80 max	0.10 max	0.30 max	0.20 max	Bal.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	145	6
Specification		100-175	4-8

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
2.5 x 350	60-90	1	5	5
3.15 x 350	80-110	1	5	5
4.0 x 350	110-150	1	5	5

EQUIVALENT : GMAW wire: Automig-4043

GTAW filler: Tigfil-4043