



Product Data Sheet

E 'Manual metal-arc welding'

OK AISi5

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REASON FOR ISSUE

Economy data added.

GENERAL

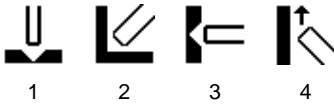
Covered electrode suitable for welding of AlMgSi-alloys e.g. EN AW 6060/6063, 6005, 6201 etc. Also suitable for welding of AISi5Cu- and AISi7Mg-castings.

Polarity: DC+

Alloy Type: Aluminium-silicon alloy, AISi5

Coating Type: Chloride and Fluoride Salt

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN ISO 18273 AISi5

APPROVALS

Not applicable

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
Si	4.5	6.0
Al	92.5	95.5
Fe		0.8

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.4 x 350	50	90	0.88	27	0.37	333	0.45	24	25	1,2,3,4
3.2 x 350	70	120	1.40	33	0.47	166	0.80	27	23	1,2,3,4

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

OTHER DATA

Redrying: 120 °C, 1h.