



Alutig Si5

GTAW - TIG
Aluminium alloys

Date: 2007-10-08
Revision: 8

Description:

Aluminium TIG 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:

AC

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		0,15	0,10	0,05

	Fe
Min	
Typical	0,2
Max	0,4

Shielding gas:

I1, Argon 5-10 l/min.

I2, Helium 8-16 l/min.

I3, Argon/Helium 5-10 l/min.

Stamping

Si5

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:

DB

CE

Kennblatt Nr 61.042.06

Product data

Diam.mm	Length mm	Product code
1,6	1000	9505-1016
2,0	1000	9505-1020
2,4	1000	9505-1024
3,2	1000	9505-1032
4,0	1000	9505-1040