

ALBOND 5 Si

CLASSIFICATIONS
AWS A/SFA 5.3 E4043

DIN 1732 EL AISi 5

IDENTIFICATION: Name Printed

CHARACTERISTICS

It has a very special coating and high melting rate. To avoid burn-through and excessive spattering, keep the arc as short as possible. To obtain light welds without pore formation, section thickness above 8mm should be pre-heated to minimum 200°C. Electrode dia should roughly be equivalent to plate thickness. Slag residues on the weld as well as on the base plate should be removed to obtain non-corrosive weld bead.

TYPICAL APPLICATIONS

Fabrication and repair of aluminium alloys, both in wrought and cast form including pipe, plate, forging and casting which use silicon addition of up to 7% as the main alloying element.

CURRENT CONDITIONS: DC (+)

4.0	3.2	2.5
110-150	80-110	60-90

WELDING POSITIONS

F & H Fillet

REDRYING CONDITIONS

KEEP DRY - NORMAL

WELD METAL CHEMISTRY, (%)

Si - 4.5-6.0 max.	Ti - 0.2 max.
Fe - 0.80 max.	Al - Remainder
Zn - 0.10 max.	Cu - 0.3 max.

PACKING DATA

Dia., mm	4.0	3.2	2.5
Length, mm	350	350	350
Wt. per carton, kg	1	1	1
Cartons / box	5	5	5
Net wt per box, kg	5	5	5

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS MPa	% Elong. (L=4xd)
As-welded	100-175	4-8



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