CEWELD® AlSi 5

CATEGORY	GMAW-GTAW Solid wires
TYPE	Mig aluminium welding wire alloyed with silicon
APPLICATIONS	He is a MIG filler metal for welding Aluminium alloys with maximum 2% alloying elements and for Aluminium alloys containing up to 7% Si.(after anodizing welding will be of a dark grey colour)
PROPERTIES	Thanks to its excellent weldability and good penetration this alloy is used mainly in construction and automotive industry. The silicon addition results in improved fluidity (wetting action), making the alloy the preferred choice of welders. The alloy is not sensitive to weld cracking and produces bright, almost smut-free welds. Not recommended for anodizing. Non-heat treatable. Thicker sections should be preheated (150°C) prior to welding.

CLASSIFICATION		
	AWS	A 5.10: ER4043
	EN ISO	18273: S Al 4043A (AlSi5(A))
	F-nr	23
	W.Nr.	3.2245

SUITABLE FOR	AlMgSi 0, AlSiMg (A), AlSi 1 MgMn, AlMg1SiCu, 3.3206, 3.3210, 3.2315, 3.3211, EN AW 6060, EN AW 6005A, EN AW 6082, EN AW 6061, EN AC 45000,
APPROVALS	CE
WELDING POSITIONS:	

TYPICAL WELD DEPOSIT WEIGHT %

Si	Mn	Ti	Fe	Cu	Mg
5	0.1	0.1	0.3	0.1	0.1

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)
As Welded /	70	130	17

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOL TYPE	KG / SPOOL / DRUM	KG / PALLET
0.8	13-24	60-170	D-200 / KD-300 / DRUM	2 / 7 / 80	400 / 504 / 320
1.0	15-26	90-210	D-200 / KD-300 / DRUM	2 / 7 / 80	400 / 504 / 320
1.2	20-29	140-260	D-200 / KD-300 / DRUM	2 / 7 / 80	400 / 504 / 320
1.6	25-30	190-350	KD-300 / DRUM	7 / 80	504 / 320

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1, I3