

Standards:

~DIN EN ISO 18273: E Al 4043 (AlSi 5)
 (DIN 1732): EL-AISI 5
 AWS A 5.3: E-4043
 Mat.-No.: 3.2245

capilla® 60/5**Product description:**

Special flux coated stick electrode.

In case of welding of heat treatable Al-alloys such as AlCuMg 1, AlMgSi1 and AlZn4,5Mg1 the mechanical properties of the base metals have to be taken into account.

Applications:

Fusion and overlay welding of AlSi-alloys with a maximum amount of 7 % Si.
 Dissimilar joints of several different Al-alloys.

Typical weld metal composition:

[wt. - %]

| | Si | Al |
|------|-----|------|
| Min. | 4,5 | |
| Max. | 5,5 | Bal. |

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

| | | |
|-----------------------------|-----|-------|
| Tensile strength R_m : | 120 | [MPa] |
| Yield strength $R_{p0,2}$: | 60 | [MPa] |
| Yield strength $R_{p1,0}$: | - | [MPa] |
| Elongation (L=5d): | 15 | [%] |
| Impact strength (ISO-V): | - | [J] |

Positions: all except PG

Redrying: 120°C/2h (store dry)

Dimension:

| Ø [mm] | Length [mm] | Welding current [A] |
|--------|-------------|---------------------|
| 2,5 | 300 | 40 – 70 |
| 3,25 | 350 | 60 – 90 |
| 4,0 | 350 | 80 – 120 |

Polarity
 =(+)~

also available:
 find in table of content

Capilla Al Si 5 MIG
 Capilla Al Si 5 WIG