



# ALBOND 5 Si

NON FERROUS (Al Alloys)

AWS A/SFA 5.3 **E4043**

## KEY FEATURES:

- Special coated electrode
- Keep short arc to avoid burn through and excessive spattering
- Electrode dia. should roughly be equivalent to plate thickness
- Provide high melting rate
- Slag residues should be thoroughly removed to obtain non corrosive weld
- Section thickness above 8 mm should be preheated to min. 200°C

## TYPICAL APPLICATIONS:

- Fabrication and repair of wrought and cast Al alloys with Si upto 7%
- Welding of similar grade Al alloys in the form of pipe, plate, forging & casting


## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

Si	Fe	Al
5.0	0.35	Bal

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	145	6
Specification		100-175	4-8

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.5 x 350 3.15 x 350 4.0 x 350	<b>Amperage, A</b> 60-90 80-110 110-150	 <b>DCEP</b>  <b>REDRYING CONDITION:</b> Keep electrodes dry.
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Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.