



MIG ALS5

Old reference: MIG AlSi5

Classification

AWS A5.10 : ER4043
AMS : 4190

ISO 18273 : S Al 4043 (AlSi5)

Description & Applications

Solid wire for GMAW of Aluminium-Silicium alloys with Silicium content up to 7%. Applicable for a wide variety of Aluminium alloys like: 6060, 6061, 6063, **6070, 6071, and 6351**. Mainly used in foundry reparations.

Main applications: Space industries, nuclear plant and armament.

Base materials:

DIN	Alloy	Material N°
AlMgSi0,5	3004	3.3206
AlMgSi1	3005	3.3210
AlSi7Mg	3303	3.2371
AlSi5Mg	5005	3.2341
	6060	
	6061	
	6063	
	6070	
	6071	
	6351	

Typical Chemical Composition (%)

	Si	Fe	Cu	Mn	Mg	Zn	Ti	Be	O/E	O/T	Al
Min	4.5										
Max	6.0	0.8	0.30	0.05	0.05	0.10	0.20	0.0003	0.05	0.15	Rem.
Type	5.0	0.15	0.001	0.03	0.02	0.003	0.006	0.0001	<0.05	<0.15	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max	-	-	-
Type	80	120	20

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = + / Pulsed	1.0	100-150	18-22	ISO 14175: I1 (100% Ar) I3 (Ar+ 5-30%He) 15-20L/min
	1.2	130-200	18-25	
	1.6	170-260	20-27	

FT En-ML10-200210

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Fumes: Consult information on MSDS, available upon request.

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