

# ALCORD 5Si

## MMA Electrodes

Aluminum alloys

SAF-FRO

ALCORD 5Si is an electrode with a special coating for welding low-alloy Al-Mg-(Si) aluminium alloys and for joining dissimilar aluminium alloys.

When welding, hold the electrode at a right angle to the work piece surface and welding direction and keep the arc as short as possible. Wall thicknesses greater than 10 mm and larger work pieces will require preheating from 150°C to 250°C. This MMA electrode is also well suited for oxy-acetylene welding. Slag residues are corrosive and must be completely removed from the weld bead. The coating is highly hygroscopic, consequently electrodes must be stored in an absolutely dry location, or redried if required. Shall be used in DC+ current.

### Classification

AWS	A5.3: E4043
DIN	1732: EI-AISI 5

### Chemical analysis (Typical values in %)

	Al	Si	Fe
All weld metal	Rem	5	0.1

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation
As Welded	≥ 90	≥ 160	≥ 15

### Materials

Al-Mg-Si and Al-Mg with max. 2.5% Mg; Al-Mn-Cu, Al-Si alloys

### Storage

Keep dry and avoid condensation.

Once opened, store at 90-120 °C until used.

If necessary, Re-dry at 110-120°C for 2 hours, 5 times max.

### Current condition and welding position

DC+



### Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	TUBM	
				PC	Code
2.5	350	60-90	9.0	222	W000289025
3.2	350	80-110	13.2	152	W000289026