

OK AISi5



Covered electrode suitable for welding of AlMgSi-alloys e.g. EN AW 6060/6063, 6005, 6201 etc. Also suitable for welding of AISi5Cu- and AISi7Mg-castings.

Classifications:	EN ISO 18273:AISi5
Welding Current:	DC+
Alloy Type:	Aluminium-silicon alloy, AISi5
Coating Type:	Chloride and Fluoride Salt

Typical Weld Metal Analysis %

Si	Al	Fe
4.9	94.9	0.2

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.4 x 350 mm	50-90 A	25 V	0.37	333	24 s	0.45 kg/h
3.2 x 350 mm	70-120 A	23 V	0.47	166	27 s	0.80 kg/h