

CARBO AISi 5

International standards	Material No.	3.2245
	DIN 1732	EL-AISi5
	AWS A 5.3	E 4043

Approvals ---

Characteristics Special coated electrode for joining wrought aluminium and cast aluminium alloys.

Welding instructions The welding area has to be thoroughly cleaned, the seam flanks should shine metallic bright CARBO AISi 5 is easy-to-weld and to de-slag. In order to obtain a dense, non-porous weld, the electrode should be preferably welded in horizontal position, with a short arc and at high speed. Preheat the welding area of massive work-pieces to 150 – 250° C. A single layer, without layering, is recommended.

Storage WARNING: Aluminium electrodes are very sensitive to humidity pick-up, since their coating contains hygroscopic salts, therefore, storage in a dry place is very important. Electrodes which have picked-up humidity must be dried (see „Rebaking“).

Operating temperature ---

Base materials	3.2151	G-AISi6Cu4	3.2341	G-AISi5Mg
	3.2305	AlMgSi	3.3206	AlMgSi0,5
	3.2315	AlMgSi1	3.3210	AlMgSi0,7

Mechanical properties of all-weld metal	Tensile strength R _m N/mm ²	Yield strength R _{p0,2} N/mm ²	Elongation A ₅ %
	(typical values)	120	90

Weld metal analysis (typical, wt. %)	Al	Si	Mn	Fe	Zn
	Bal.	5	0,2	< 0,4	< 0,1

Current = +

Welding positions PA, PB, PC, PF

Rebaking 1 h, 120 °C +/- 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 350	50 - 80	222	889	9,0	2,0	8,0
3,2 x 350	70 - 100	143	571	14,0	2,0	8,0
4,0 x 350	100 - 130	87	348	23,0	2,0	8,0
5,0 x 350	120 - 150	56	223	35,9	2,0	8,0