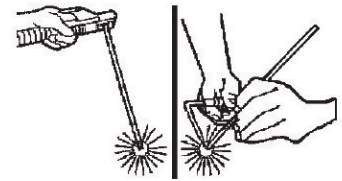


5% Silicon aluminum arc welding electrode with exclusive self lifting slag.



- ❑ Unique self lifting slag.
- ❑ The only aluminum electrode manufactured in a "Low Temperature" 5/64 (2.0mm) x 10" (250mm) size.
- ❑ Pure white long shelf life extruded flux coating outlasts conventional products in moisture resistance.

INTERNATIONAL SPECIFICATIONS	AWS/ASME SFA 5.3 E 4043 DIN 1732 EL - AlSi5

APPLICATIONS:

For arc welding aluminums alloyed with copper, silicon, and magnesium. Also excellent for joining dissimilar grades of aluminum.

ALL WELD METAL ANALYSIS (Typical Weight %):

Si	Cu	Fe	Mg	Mn	Zn	Al
5.25	.23	.8	.04	.04	.08	Bal.

FLUX COLOR: White

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	36,000 Psi
Yield Strength	20,000 Psi
Elongation	18%

RECOMMENDED CURRENT: DC Reverse (+)

RECOMMENDED AMPERAGE SETTINGS:

Diameter (mm)	5/64 (2.0)	3/32(2.5)	1/8(3.25)	5/32 (4.0)
Minimum Amperage	20	50	70	110
Maximum Amperage	60	80	120	150

WELDING POSITIONS: Flat, Horizontal

DEPOSITION RATES:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Setting	Recovery Rate
5/64 (2.0)	10" (250)	.08 oz. (2.6g)	184 (404)	176 (387)	40	90%
3/32 (2.5)	14" (350)	.14oz (4.3g)	114 (251)	110 (242)	70	90%
1/8 (3.25)	14" (350)	.23oz (6.5g)	70 (153)	62 (136)	110	90%
5/32 (4.0)	14" (350)	.33oz (9.6g)	48 (107)	47 (103)	135	90%

WELDING TECHNIQUES:

Start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.