

# OK 96.40

Type Chloride and fluoride salt

SMAW  
EL-AISi5

## Description

A coated electrode suitable for welding AlMnSi alloys such as EN - AW 6060/6063, 6005, 6201. Also suitable for welding AlSi5Cu and AlSi7 type castings.

## Welding current

DC+



## Classifications

DIN 1732

EL-AISi5

## Typical all weld metal composition, %

Si	Al	Fe
5.0	94.0	<0.4

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	50-90	22
3.2	350	70-110	22
4.0	350	90-130	22