

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
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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	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
2.4 x 350.0 mm	50-90 A	25 V	333	24 sec	37 %	0.45 kg/h
3.2 x 350.0 mm	70-120 A	23 V	166	27 sec	47 %	0.8 kg/h