

**Coating type:**  
Special

**Current:**



**Welding positions:**



Aluminil Si5 is our special coated aluminium electrode for welding, repairing and surfacing forged and cast aluminium-silicon alloys and joining dissimilar aluminium alloys with max. 7% Si content. The easy flowing characteristics make the electrode suitable for welding all aluminium castings (except AlMg castings). The electrode has a pure white coating specifically designed to reduce moisture pick-up. For thicker plate materials ( $\geq 15$  mm) it is recommended to preheat at 150°C to 250°C before welding.

**Base materials to be welded:**

- Aluminium-MgSi alloys
- Aluminium-Mg alloys up to 2,5% Mg
- Aluminium-MnCu alloys
- Aluminium-Si cast alloys
- Joining dissimilar aluminium alloys

**Applications:**

- General fabrication & construction (aluminium base metals)
- Shipbuilding & Offshore
- Repair & Maintenance

**Chemical composition, wt. % weld metal – typical:**

Mn	Si	Cu	Zn	Fe	Al
0,05	5	0,05	0,10	0,20	Bal.

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %
As welded	90	160	15

**Packaging and welding data:**

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	9,2	50-80
3,2	350	13,7	70-120
4,0	350	19,6	110-150