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ML-4043 AlSi5

Rod/Wire electrode for Aluminium

Typical composition in %	Si ..... 4,50-5,50 Fe ..... < 0,60 Cu ..... < 0,30 Mn ..... < 0,15 Mg ..... < 0,20 Zn ..... < 0,10 Be ..... < 0,0003 Ti ..... < 0,15 Others ..... < 0,05 Others total ..... < 0,15
Classification	EN ISO 18273 ..... S Al 4043A (AlSi5(A)) Material No. ..... 3.2245 AWS A 5-10 ..... ER 4043
Base materials	See page 15.
Remarks	This alloy is particularly used to prevent solidification cracks in connection with high dilution and clamp conditions. Anodizing gives dark gray colours and is not recommended. The weld pool is very fluid. Consider the technological application reference.
Physical properties of pure weld metal (Approx. values)	0,2 % yield strength $R_{p0,2}$ [MPa] ..... 40 Tensile strength R_m [MPa] ..... 120 Elongation A_5 (L_0=5d_0) [%] ..... 8 Test temperature [°C] 20
Welding position	PA, PB, PC, PF
Shielding gas	I1, I2, I3 (Argon, Helium or Argon/Helium-mixtures)
Polarity	MIG =+, TIG ~
Approvals	DB, VdTÜV
Dimensions Ø	MIG-wires [mm] ..... 0,8; 1,0; 1,2; 1,6; 2,0; 2,4 TIG-rods [mm] 1,6; 2,0; 2,4; 3,2; 4,0; 5,0
Wire packagings	Spools ..... Packaging units S 100 / 0,5 kg ..... 20 spools = 10 kg (box) S 200 / 2 kg ..... 4 spools = 8 kg (box) S 300 / 6 kg ..... 56 spools = 336 kg (pallet) B 300 / BS 300 / 7 kg ..... 56 spools = 392 kg (pallet) B 400 / 18 kg ..... 28 spools = 504 kg (pallet) B 400 / 40 kg ..... 15 spools = 600 kg (pallet) Eco-drum / 80 kg ..... 2 drums = 160 kg (pallet) Jumbo-drum / 140 kg ..... 2 drums = 280 kg (pallet)
Rod packagings	Box 10 kg ..... Length 1.000 mm

ML-5356 AlMg5Cr

Rod/Wire electrode for Aluminium

Typical composition in %	Si ..... < 0,25 Fe ..... < 0,40 Cu ..... < 0,10 Mn ..... 0,05-0,20 Mg ..... 4,50-5,50 Cr ..... 0,05-0,20 Zn ..... < 0,10 Be ..... < 0,0003 Ti ..... 0,06-0,20 Others ..... < 0,05 Others total ..... < 0,15
Classification	EN ISO 18273 ..... S Al 5356 (AlMg5Cr(A)) Material No. ..... 3.3556AWS A 5-10 ER 5356
Base materials	See page 15.
Remarks	The weld metal is sea water resistant. Suitable for anodizing when matching colours are required. Consider the technological application reference.
Physical properties of pure weld metal (Approx. values)	0,2 % yield strength $R_{p0,2}$ [MPa] ..... 110 Tensile strength R_m [MPa] ..... 240 Elongation A_5 (L_0=5d_0) [%] ..... 17 Test temperature [°C] 20
Welding position	PA, PB, PC, PF
Shielding gas	I1, I2, I3 (Argon, Helium or Argon/Helium-mixtures)
Polarity	MIG =+, TIG ~
Approvals	VdTÜV, DB, DNV-GL, Bureau Veritas, Lloyds Register
Dimensions Ø	MIG-wires [mm] ..... 0,8; 1,0; 1,2; 1,6; 2,0; 2,4 TIG-rods [mm] 1,6; 2,0; 2,4; 3,2; 4,0; 5,0
Wire packagings	Spools ..... Packaging units S 100 / 0,5 kg ..... 20 spools = 10 kg (box) S 200 / 2 kg ..... 4 spools = 8 kg (box) S 300 / 6 kg ..... 56 spools = 336 kg (pallet) B 300 / BS 300 / 7 kg ..... 56 spools = 392 kg (pallet) B 400 / 18 kg ..... 28 spools = 504 kg (pallet) B 400 / 40 kg ..... 15 spools = 600 kg (pallet) Eco-drum / 80 kg ..... 2 drums = 160 kg (pallet) Jumbo-drum / 140 kg ..... 2 drums = 280 kg (pallet)
Rod packagings	Box 10 kg ..... Length 1.000 mm

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ML-5754 AlMg3

Rod/Wire electrode for Aluminium

Typical composition in %	Si ..... < 0,40 Fe ..... < 0,40 Cu ..... < 0,10 Mn ..... < 0,50 Mg ..... 2,60-3,60 Cr ..... < 0,30 Zn ..... < 0,20 Be ..... < 0,0003 Ti ..... < 0,15 Others ..... < 0,05 Others total ..... < 0,15
Classification	EN ISO 18273 ..... S Al 5754 (AlMg3) Material No. 3.3536
Base materials	See page 15.
Remarks	The weld metal is sea water resistant. Suitable for anodizing when matching colours are required. Consider the technological application reference.
Physical properties of pure weld metal (Approx. values)	0,2 % yield strength $R_{p0,2}$ [MPa] ..... 80 Tensile strength R_m [MPa] ..... 190 Elongation A_5 (L_0=5d_0) [%] ..... 20 Test temperature [°C] 20
Welding position	PA, PB, PC, PF
Shielding gas	I1, I2, I3 (Argon, Helium or Argon/Helium-mixtures)
Polarity	MIG =+, TIG ~
Approvals	on request
Dimensions Ø	MIG-wires [mm] ..... 0,8; 1,0; 1,2; 1,6; 2,0; 2,4 TIG-rods [mm] 1,6; 2,0; 2,4; 3,2; 4,0; 5,0
Wire packagings	Spools ..... Packaging units S 100 / 0,5 kg ..... 20 spools = 10 kg (box) S 200 / 2 kg ..... 4 spools = 8 kg (box) S 300 / 6 kg ..... 56 spools = 336 kg (pallet) B 300 / BS 300 / 7 kg ..... 56 spools = 392 kg (pallet) B 400 / 18 kg ..... 28 spools = 504 kg (pallet) B 400 / 40 kg ..... 15 spools = 600 kg (pallet) Eco-drum / 80 kg ..... 2 drums = 160 kg (pallet) Jumbo-drum / 140 kg ..... 2 drums = 280 kg (pallet)
Rod packagings	Box 10 kg ..... Length 1.000 mm