

Classifications

EN ISO 18273	AWS A5.10
S Al 4043A (AlSi5(A))	ER4043

Characteristics and typical fields of application

Solid wires for GMAW welding of aluminium alloys. The weld metal is not suitable for anodizing for decorative purposes. Very fluid weld pool. Thicker plate materials and castings require preheating to 150 - 200°C (302 - 392°F). Do not use for welding hardenable alloys in high stressed zones.

Base materials

AlMgSi 0.5	3.3206	EN AW-6060 [AlMgSi]
AlMgSi 0.7	3.3210	EN AW-6005A [AlSiMg(A)]
AlMgSi 1	3.2315	EN AW-6082 [AlSi 1 MgMn]
AlMg 1 SiCu	3.3211	EN AW-6061 [AlMg 1 SiCu]
G-AlSi 6 Cu 4	3.2151	EN AC-45000

Typical analysis of solid wire (wt.-%)

	Al	Si	Fe	Cu	Mg
wt.-%	bal.	4.5 – 6.0	< 0.6	< 0.3	< 0.2

Mechanical properties of all-weld metal

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)
	MPa	MPa	%
u	≥ 40	≥ 120	≥ 8
u	untreated, as welded		

Operating data

	Stromart: DC (+)	Schutzgas: (EN ISO 14175) I1, I3	ø (mm) 1.0 1.2

Approvals

DB (61.014.04/09), CE