ALUFIL Al Si 5

Drôt pre zváranie TIG/MIG
Welding rod/wire electrode for TIG/MIG-welding process
Pręty/druty do spawania metodami TIG/MIG

OERLIKON

Standards:

EM ISO 18273	S Al 4043
AWS/ASME SFA-5.10	ER 4043
Comparable No. of Materials:	3.2245

SK Vlastnosti a použitie:
Prídavný materiál pre zváranie hliníka a jeho zliatin s podielom legujúcich prvkov <2 %, odliatkov z hliníka s obsahom <7 % Si. Veľmi dobré vlastnosti zvárania.

GB Application and properties:
Weld consumable for TIG/MIG-welding of aluminium and aluminium alloys having <2 % alloying elements, as well as cast aluminium alloys having <7 % silicon. Outstanding operating characteristics.

POL Zastosowania i własności:
Materiał spawalniczy do spawania TIG/MIG aluminium i stopów aluminium o zawartości <2% dodatków stopowych, jak również aluminium odlewniczego o zawartości <7% krzemu. Świetne własności robocze.

Materials for instance:

Joint welding of aluminium and aluminium alloys			
No. of Materials	**DIN-Designation**	**No. of Materials**	**DIN-Designation**
3.2315	Al Mg Si 1	3.2341	G-Al Si 5 Mg

Approvals: DB, ÖBB

Rod and wire analysis correspond to all-weld metal analysis (typical values in%):

Si	Al
5,00	Remainder

Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	0,2 % Proof strees [N/mm²]	Tensile strength [N/mm²]	Elongation A_5 [%]
AW	≥40	≥120	≥8

AW = as-welded

Analysis and mechanical properties apply to the use of shielding gas:
DIN EN 439 - I1 in TIG – welding
DIN EN 439 - I1 in MIG – welding

Shielding gas acc. to DIN EN 439:

Welding rod for TIG-welding:	I1 (ARCAL 1)
Wire electrode for MIG-welding:	I1 (ARCAL1), I2 (Helium R), I3 (ARCAL 31)
Consumption:	TIG = 10 l/min, MIG = 12 l/min

Form of delivery:

Welding rods				
Dia. [mm]	2,0	2,4	3,2	4,0
Length [mm]	1000			
Approx. weight of packet [kgs]	10			

Wire electrodes				
Dia. [mm]	0,8	1,0	1,2	1,6
Wire cage reel K300 [kgs]	7			

Further forms of delivery on request.

Type of current/Polarity/Welding positions:

TIG 

MIG