

Alufil AISi5 is a solid wire for welding of Aluminium and Aluminium alloys with a silicon content up to 7%. Suitable for Al-Mg-Si alloys series 6000 and for dissimilar welding such as 6000/1000 or 6000/3000.

Classification	
AWS	A5.10: ER 4043
EN ISO	18273: S Al 4043

Approvals	Grades
DB	

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Zn	Ti	Mg	Fe	Cu	Al
-	≤ 0.05	5	-	-	-	-	≤ 0.20	≤ 0.05	≤ 0.80	≤ 0.30	Rem

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	≥ 40	≥ 120	≥ 8	-	-

Gas test: Acc. To EN 439: I1(Arcal1)

**Shielding Gas:** Acc. To EN 439: I1(Arcal1)

### Materials

3.2245

Al-Mg-Si and Al-Mg alloys with 2.5% Mg max. Al-Mn-Cu - AlSi cast

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** BS300 Kg. 7

Diameters	0,8	1,0	1,2	1,6		