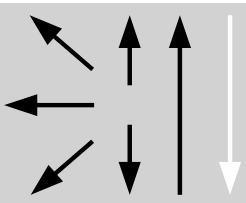


Classifications						
EN ISO 18273			AWS A5.10			
S Al 4043A (AlSi5(A))			ER4043			
Characteristics and typical fields of application						
Rod for GTAW of Al alloys containing up to 2% of alloying elements and for aluminium alloys containing up to 7% Si. The weld metal is not suitable for anodizing for decorative purposes. Very fluid weld pool. Not applicable for welding hardenable alloys in high stressed zones. Thorough cleaning of the workpiece bevels is necessary prior to welding.						
Base materials						
EN AW-6060 [AlMgSi]	AlMgSi0,5	3.3206				
EN AW-6005A [AlSiMg(A)]	AlMgSi0,7	3.3210				
EN AW-6082 [AlSi1MgMn]	AlMgSi1	3.2315				
EN AW-6061 [AlMg1SiCu]	AlMg1SiCu	3.3211				
EN AC-45000	G-AlSi6Cu4	3.2151				
and similar.						
Typical analysis of TIG rod (wt.-%)						
Al	Si	Fe	Cu	Mn	Mg	Zn
Bal.	4.5 – 6.0	< 0.6	< 0.3	< 0.15	< 0.2	< 0.10
Mechanical properties of all-weld metal						
Yield strength $R_{p0.2}$		Tensile strength R_m		Elongation A ($L_0=5d_0$)		
MPa		MPa		%		
70		130		16		
Operating data						
		Polarity: AC		Shielding gases: (EN ISO 14175) I1, I3		ø mm 1.6 2.0 2.4 3.2 4.0
Approvals						
DB (61.132.02), CE						