

## OK AISi5

Covered electrode suitable for welding of AlMgSi-alloys e.g. EN AW 6060/6063, 6005, 6201 etc. Also suitable for welding of AISi5Cu- and AISi7Mg-castings.

| Specifications  |                      |
|-----------------|----------------------|
| Classifications | EN ISO 18273 : AISi5 |

|                 |                                |
|-----------------|--------------------------------|
| Welding Current | DC+                            |
| Alloy Type      | Aluminium-silicon alloy, AISi5 |
| Coating Type    | Chloride and Fluoride Salt     |

| Typical Weld Metal Analysis % |      |     |
|-------------------------------|------|-----|
| Si                            | Al   | Fe  |
| 4.9                           | 94.9 | 0.2 |

| Deposition Data |          |         |                |                                        |                 |
|-----------------|----------|---------|----------------|----------------------------------------|-----------------|
| Diameter        | Current  | Voltage | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
| 2.4 x 350.0 mm  | 50-90 A  | 25 V    | 37 %           | 24 sec                                 | 0.45 kg/h       |
| 3.2 x 350.0 mm  | 70-120 A | 23 V    | 47 %           | 27 sec                                 | 0.8 kg/h        |