

Key Features

- Extruded electrode for MMAW aluminium
- Low cost setup for small jobs
- Versatile
- DC + only

Description

A coated electrode providing high-speed deposition of a dense, machine able weld metal for use on most cast & wrought aluminum alloys. Preheat electrodes prior to use, to 80°C to enable smoother starting and running.

Clean and remove all dirt, oil and grease from the welding area, by using cleaning-chemicals or white spirits and then by wire brushing with a clean stainless steel brush or by mechanical sanding. Chamfer edges of plates to be joined and open up cracks. Make holes to be filled, wider at the top edge. Preheat heavy sections prior to welding. When joining thick-to-thin, preheat the heavier member. Set the welding current at the upper end of the recommended range, feed the electrode quickly and move fast, and if possible reduce amperage as welding progresses and the base metal absorbs the heat.

Classification, Approvals & Conformances

AWS A5.3: E4043
 ISO 9001 (Certificate # 31598)

Welding Positions

Flat, horizontal and vertical up. All positional, DC+ current only.

Applications

Use for fabrication, repair and maintenance of cast & wrought aluminum such as; loading ramps, pipe railings, banisters, stairs, checker plate, window and door frames, irrigation pipe, transmission housings and gear boxes, engine blocks, machine bases, bus-bars and electrical mounts, foundry defects, machining errors and salvage work. This electrode must be used on DC output welders (DC+ current) only.

Typical Analysis/Composition

Mg - Magnesium	Mn - Manganese	Si - Silicon
< 0.05	< 0.05	1.0 – 11.0
Cu - Copper	Zn - Zinc	Fe - Iron
< 0.4	< 0.1	< 0.8

Typical Weld Mechanical Properties

Tensile Strength	Tensile Strength
> 235 MPa	34,000 PSi

Sizes Available

Diameter (mm)	3.2	Current range
Electrodes	✓	70 – 120 amps

Packaging & Ordering Information

Size	Weight	Part Number
3.2mm	0.454kg	100103