



# CEWELD E AlSi 5

**TYPE** Stick welding electrode for SMAW welding of aluminum alloys.(E AlSi5, E 4043)

**APPLICATIONS** CEWELD® E AlSi 5 is for welding Aluminium alloys with maximum 2% alloying elements and for aluminium alloys containing up to 7% Si.Also excellent for joining dissimilar grades of aluminum. General applications: engine blocks, cylinder heads, tanks, containers, frames, lorry tipper.

**PROPERTIES** CEWELD® E AlSi 5 have a very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up. (after anodizing the welding will appear as a dark grey color)  
Start by using the upper portion of the amperage range. Feed the Electrode quickly and move fast maintaining a very close arc gap

**CLASSIFICATION**

AWS	A 5.3: E 4043
EN ISO	18273: E AlSi5(A)
W.Nr.	3.2245
F-nr	23
FM	23

**SUITABLE FOR** AlSi alloys with max. 7% Silicium, AlMg Alloys with max. 3% Magnesium,  
**Mat.n:** 3.2151, 3.3206, 3.3210, 3.3211, 3.2305, 3.2315, 3.2341, 3.2371, 3.4335  
AlMgSi 0.5, AlMgSi 0.7, AlMgSi 1, AlMg1SiCu, AlSi7Mg0,3, G.AlSi5Mg, G.AlSi6Cu4, AlMgSi, AlZn4,5Mg1  
**Iso.n:** 6060, 6005A, 6082, 6061, 4210, 4500, 6060, 7072

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

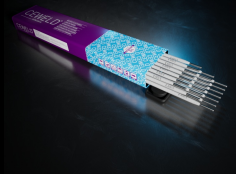
Si	Mn	Ti	Fe	Cu	Mg	Al
5	0.02	0.2	0.2	0.3	0.05	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	100	150	14	60 HB

**REDRYING** 140°C / 1 hr

**GAS ACC.** EN ISO 14175



# CEWELD E ALSi 5

E ALSI 5 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2	8720663406712

E ALSI 5 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2	8720663406729

E ALSI 5 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2	8720663406736