



# 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

|                       |        |                   |
|-----------------------|--------|-------------------|
| <b>CLASSIFICATION</b> | 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 |