

Standards

TS 9604	: EL-AISI 5
AWS A5.3	: E 4043

**Chemical Composition of
Weld Metal % (Typical)**

Si	Al
4.5 - 5.5	Rest

Mechanical Properties

Tensile Strength (N/mm ²)	Elongation ($L_0=5d_0$) (%)	Hardness (HB)
160 - 190	min. 10	50

Features and Applications

- Include also engine blocks, gear cases, engine gear box unit, miscellaneous components in light alloys, stroge tanks, containers, vessels, repair works on various kind of aluminium materials
- Manuel welding electrode recommended for production and maintenance applications including repair of cracks, casting defects and building up sections also broken parts
- Suitable for made of aluminium applications
- Before welding on thick section preheat at about 200°C is recommended

Welding Positions

MIG Wire

GeKa AISi 5

TIG Wire

GeKa AISi 5 TIG

Current Type

D.C.(+) / AC

Operating Data

Product Code	Diameter x Length (mm) / (inch)	Welding Current (A)	Package Weight (Kg)
6031200019	2.50 x 350 / 3/32 x 14"	50 - 80	2
6031200020	3.20 x 350 / 1/8 x 14"	70 - 100	2
6031200021	4.00 x 350 / 5/32 x 14"	90 - 130	2

Approvals: SEPRO