

MT-AISI 5

3.2245

Aluminium-silicon-alloyed MIG/TIG wire welding AISi-Alloys.

Standard designation

Material No.	3.2245
AWS/ASME SFA-5.10	ER 4043
EN ISO 18273	S Al 4043A (AISi 5(A))

Main base metals

Aluminium-silicon alloys as well as joining dissimilar aluminium alloys to each other. Conditionally suitable for age-hardenable alloys like AlCuMg 1 (3.1325), AlMgSi 1 (3.2315), AlZn 4,5 Mg 1 (3.4335)

Physical properties

El. conductivity at 20°C [S · m/mm ²]	Thermal conductivity at 20°C [W/(m · K)]	Linear thermal expansion coefficient (20 - 100°C) [1/K]
24 - 32	170	22,1 · 10 ⁻⁶

Mechanical properties of all-weld-metal (typical values)

Welding process			TIG AISi 5	MIG AlMgSi1
Base metal			6	6
Material thickness	(mm)		6	6
Gas shield			I1	I1
Thermal treatment			untreated	untreated
Test temperature	[°C]		+20°C	+20°C
0,2%-yield strength	R _{p0,2} MPa		100	100
Tensile strength	R _m MPa		160	160
Elongation	g A ₅ [%]		15	15

Average chemical composition of all-weld-metal (%)

Al	Si
Basis	4,50-6,0

Gas types applicable TIG Gas types applicable MIG

I1
I1

Approvals

TÜV, DB , CE

TIG rod diameters available, unit weights

Diameter [mm]	Length [mm]	kgs per box
1,60	1000	10,0
2,00	1000	10,0
2,40	1000	10,0
3,20	1000	10,0
4,00	1000	10,0
5,00	1000	10,0

MIG welding wire

Diameter 0,8mm 1,0mm 1,2mm 1,6mm

Welding positions MIG acc.to EN ISO 6947

PA, PB, PF, PC

Welding positions TIG acc.to EN ISO 6947

PA, PB, PF

Current/Polarity TIG

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Current/Polarity MIG

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