

OK 96.40

Type Chloride and fluoride salt

SMAW
EL-AISI5

Description

A coated electrode suitable for welding AlMnSi alloys such as EN - AW 6060/6063, 6005, 6201. Also suitable for welding AISi5Cu and AISi7 type castings.

Welding current

DC+



Classifications

DIN 1732

EL-AISI5

Typical all weld metal composition, %

Si	Al	Fe
5.0	94.0	<0.4

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	50-90	22
3.2	350	70-110	22
4.0	350	90-130	22

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