

### CLASSIFICATION

ISO 18273 : AI 4043A (AISi5(A))    AWS A5.3 : E4043  
DIN 1732 : EL-AISi 5

### GENERAL DESCRIPTION

LSi-5 is an aluminium electrode with 5 % Si. It is used for joining and repair welding of 5 % Si containing rolled aluminium and cast aluminium parts. It is used on DC positive pole.

### APPROVALS

GOST, SEPRO

### CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Si	Mn	Fe	Mg	Al
4.7 - 5.3	max 0.05	max 0.2	max 0.05	balance

### MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 80-90 N/mm <sup>2</sup>
Tensile Strength	: 150-160 N/mm <sup>2</sup>
Elongation (L=5d)	: 15 %

### APPLICATIONS AND MATERIALS TO BE WELDED

It is an ideal electrode particularly used for the welding of 5 % Si containing rolled aluminium parts and for aluminium pipes and plates. It should not be used in the welding of aluminium alloys having high magnesium, copper or zinc content. As the weld pool metal is very fluid, parts should be welded in horizontal position. During welding, electrode should be vertical to the work piece and it should not be oscillated. Arc length should be short.

Preheating to 100-300°C should be applied with respect to the thickness of the part to be welded. The slag should be removed completely after welding, since it is corrosive (the slag might be removed with water as the piece cools).

#### Rolled Aluminium Alloy

DIN 1725-1	W. Nr.	Alloy Nr.
AlMgSi 0.5	3.3206	6060
AlMgSi 0.7	3.3210	6005A
AlMgSi 0.8	3.2316	6181
AlMgSi 1	3.2315	-
AlZn4.5Mg 1	3.4335	-
AlCuMg 1	3.1325	-

#### Cast Aluminium Alloy

DIN 1725-2	W. Nr.	Alloy Nr.
G-AISi 5	3.2341	443.0
G-AISi 6 Cu 4	3.2151	319.0

### WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+)

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]
2.50	350	60 - 90	900	2.0 / 222
3.25	350	80 - 110	1320	2.0 / 152
4.00	350	100 - 140	2040	2.0 / 98



**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.  
**Fumes** : Consult information on Welding Safety Sheet, available upon request.

#### Lion International U.K (M.E.) Limited

Monomark House, 27 Old Gloucester Street, London WC1N 3XX, United Kingdom.  
T: +44 20 74198760 F: +44 20 78319489 E: info@lionintweld.co.uk

#### Lion International Middle East FZC

P.O. Box 41654, W/H No. 1K-01/4, Hamriyah Free Zone, Sharjah, UAE.  
T: +971 6 5260461 F: +971 6 5260561 E: info.me@lionintweld.co.uk