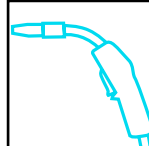


WELDING CONSUMABLES GAS METAL ARC WELDING (MIG) WIRES



AUTOCRAFT AL4043



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

| | | |
|---|------------|-------------------------------|
| Single-vee butt weld with 6061-T6 Aluminium (reduced section tensile specimen) using welding grade Argon: | | |
| | As welded: | Postweld heat treated & aged: |
| 0.2% Proof Stress | 124 MPa | 276 MPa |
| Tensile Strength | 186 MPa | 303 MPa |
| Elongation (in 2 inches) | 8% | 5% |

WIRE ANALYSIS LIMITS:

Single values are maximum allowable, unless otherwise stated.

| | | |
|--------------|---------------------|-----------|
| Si: 4.5–6.0% | Fe: 0.80% | Cu: 0.30% |
| Mn: 0.05% | Mg: 0.05% | Zn: 0.10% |
| Ti: 0.20% | Total others: 0.15% | |
| Al: Balance | | |

RECOMMENDED SHIELDING GAS:

- Welding Grade Argon
- Argon + 25% He
- Helium + 25% Ar

COMPARABLE CIGWELD PRODUCTS:

Comweld AL4043
AWS R4043

- ▲ An Aluminium -5% Silicon Wire for GMA Welding of Selected Wrought and Cast Aluminium Alloys.
- ▲ For the Repair Welding of Aluminium Alloy Castings (mainly 4XX and 6XX series).
- ▲ For Welding Selected Wrought (1XXX, 5XXX and 6XXX series) Aluminium Alloys.

Classifications:

AS/NZS 2717.2: E4043.
AWS/ASME-SFA A5.10: ER4043.

Packaging and Operating Data:

These machine settings are a guide only. Actual voltage and welding current used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc. For 5XXX type welding wires use welding current settings on the higher side of the range specified below and arc voltages on the lower side of the range. For 1XXX, 2XXX and 4XXX type welding wires use welding current settings on the lower side of the specified range and arc voltages on the higher side.

| Wire Dia mm | Voltage Range (volts) | Wire Feed Speed (metres/min) | Current Range (amps) | Pack Type* | Pack Weight | Part No |
|-------------|-----------------------|------------------------------|----------------------|------------|-------------|---------|
| 1.2 | 20 – 25 | 5.5 – 12.0 | 150-250 | Spool | 7kg | 720237 |
| 1.2 | 20 – 25 | 5.5 – 12.0 | 150-250 | Autopak | 70kg | 723237 |
| 1.6 | 23 – 28 | 5.0 – 9.5 | 200-350 | Spool | 7kg | 720238 |

* Spool (ø300mm).

AUTOCRAFT AL5356



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

| | |
|--|---------|
| Single-vee butt weld with 5086 Aluminium (reduced section tensile specimen): | |
| Welding grade Argon: | |
| 0.2% Proof Stress | 130 MPa |
| Tensile Strength | 269 MPa |
| Elongation (in 2 inches) | 17% |

WIRE ANALYSIS LIMITS:

Single values are maximum allowable, unless otherwise stated.

| | | |
|---------------------|----------------|----------------|
| Si: 0.25% | Fe: 0.40% | Cu: 0.10% |
| Mn: 0.05–0.2% | Mg: 4.5–5.5% | Cr: 0.05–0.20% |
| Zn: 0.10% | Ti: 0.06–0.20% | |
| Total others: 0.15% | | Al: Balance |

RECOMMENDED SHIELDING GAS:

- Welding Grade Argon
- Argon + 25% He
- Helium + 25% Ar

COMPARABLE CIGWELD PRODUCTS:

Comweld AL5356
AWS R5356

- ▲ An Aluminium -5% Magnesium Wire for the GMA Welding of a Wide Range of Wrought and Cast Aluminium Alloys containing Magnesium.

Classifications:

AS/NZS 2717.2: E5356.
AWS/ASME-SFA A5.10: ER5356.

Packaging and Operating Data:

These machine settings are a guide only. Actual voltage and welding current used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc. For 5XXX type welding wires use welding current settings on the higher side of the range specified below and arc voltages on the lower side of the range. For 1XXX, 2XXX and 4XXX type welding wires use welding current settings on the lower side of the specified range and arc voltages on the higher side.

| Wire Dia mm | Voltage Range (volts) | Wire Feed Speed (metres/min) | Current Range (amps) | Pack Type* | Pack Weight | Part No |
|-------------|-----------------------|------------------------------|----------------------|-------------------------|-------------|---------|
| 0.8 | 14 – 21 | 6.0 – 20.0 | 50 – 150 | Mini Spool (4 per pack) | 4 x 0.5kg | 721221 |
| 0.9 | 16 – 22 | 6.0 – 17.5 | 80 – 180 | Spool | 7kg | 722226 |
| 1.0 | 17 – 23 | 6.0 – 16.5 | 110 – 220 | Spool | 7kg | 722224 |
| 1.0 | 17 – 23 | 6.0 – 16.5 | 110 – 220 | Handi Spool | 2.0kg | 723224 |
| 1.2 | 20 – 25 | 5.5 – 12.0 | 150 – 250 | Spool | 7kg | 722227 |
| 1.2 | 20 – 25 | 5.5 – 12.0 | 150 – 250 | Autopak | 70kg | 723227 |

* Mini Spool (ø100mm); Handi Spool (ø200mm); Spool (ø300mm).