AMA 1075 SP

Standards: DIN 1732 EL - AlSi 5
No. of Material 3.2245
AWS/ASME SFA - 5.3 E - 4043

Application / Properties: Electrode with special covering for the welding of aluminum silicon alloys and for joining dissimilar aluminum alloys. The electrode should be held perpendicularly to the workpiece and a short arc length maintained. Plates thicker than 10 mm and larger workpieces require preheating in the range of 150 to 250 C. Since slag residues arc corrosive, the must be completely removed from the welded bead. Electrode serves well as consumable in oxyacetylene welding. The covering being hygroscopic, the electrode must be stored in an absolutely dry location, or redried if required.

Weld metal analysis in % (typical values):

Al	Si	Fe
Base	5	0.3

Mechanical Properties of all -weld metal:

(Single values are typical values)

Tensile Strength (N/mm^2)	0.2% Yield Strength (N/mm^2)	Elongation A5 (%)
160	90	15

= +

Welding Parameters			
Diameter (mm)	2.5	3.25	4.0
Length (mm)	300	350	350
Amperage(A)	60 - 90	80 - 110	110 - 150

Materials

AlMgSi and AlMg -alloys up to 2.5% Mg, AlMnCu, AlSi cast cast alloys.

Redrying: at 110°C to 120°C for 2hrs.