

ALCORD 5Si

TOP FEATURES

- This MMA electrode is also well suited for oxy-acetylene welding.
- Slag residues are corrosive and must be completely removed from the weld bead.
- The coating is highly hygroscopic, consequently electrodes must be stored in an absolutely dry location, or redried if required.
- Shall be used in DC+ current.

CLASSIFICATION

AWS A5.3	EI-AI 99.8
DIN 1732	EI-AISi 5

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Si	Fe	Cu	Mn	Mg	Zn	Al
4.5	≤0.8	≤0.3	≤0.05	≤0.05	≤0.1	bal.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation
AWS A5.3	AW	not specified	≥95	not specified
EN ISO 18273	AW	not specified	not specified	not specified
Typical values	AW	≥90	≥160	≥15

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-90
3.2 x 350	80-110

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	PE Tube	TBD	2.0	W000289025
3.2 x 350	PE Tube	TBD	2.0	W000289026

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.