ALCORD 5Si

MMA Electrodes
Aluminum alloys

ALCORD 5Si is an electrode with a special coating for welding low-alloy Al-Mg-(Si) aluminium alloys and for joining dissimilar aluminium alloys.
When welding, hold the electrode at a right angle to the work piece surface and welding direction and keep the arc as short as possible. Wall thicknesses greater than 10 mm and larger work pieces will require preheating from 150°C to 250°C. 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: E4043
DIN	1732: El-AlSi 5

Chemical analysis (Typical values in %)

Al	Si	Fe
Rem	5	0.1

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation
As Welded	≥ 90	≥ 160	≥ 15

Materials

Al-Mg-Si si Al-Mg cu max. 2.5% Mg; Al-Mn-Cu, aliaje de Al-Si

Storage

Keep dry and avoid condensation.
Once opened, store at 90-120°C until used.
If necessary, Re-dry at 110-120°C for 2 hours, 5 times max.

Current condition and welding position

DC+

PA PB PC

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	TUBM	
				PC	Code
2.5	350	60-90	9.0	222	W000288128
3.2	350	80-110	13.2	152	W000288129

ALCORD 12Si

MMA Electrodes
Aluminum alloys

ALCORD 12Si is an electrode with a special coating for welding Al-Si cast alloy, with high silicon content.
When welding, hold the electrode at a right angle to the work piece surface and welding direction and keep the arc as short as possible. Wall thicknesses greater than 10 mm and larger work pieces will require preheating from 150°C to 250°C. 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.

Classification	
DIN	1732: El-AlSi 12

Chemical analysis (Typical values in %)

Al	Si	Fe
Rem	12	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
As Welded	≥ 80	≥ 180	≥ 5

Materials

G-AlSi11, G-AlSi12, G-AlSi10Mg(Cu), G-AlSi12(Cu), Al-Si-aliaje cu Si >7%

Storage

Keep dry and avoid condensation.

Once opened, store at 90-120°C until used.

If necessary, Re-dry at 110-120°C for 2 hours, 5 times max.

Current condition and welding position

DC+

PA PB PC

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	TUBM	
				PC	Code
2.5	350	60-90	8.81	227	W000288130
3.2	350	80-110	13.16	152	W000288131

CITOCUT

MMA Electrodes
Cutting

CITOCUT is used for cutting, gouging or chamfering of mild and low-alloy steels, cast iron, nickel base alloys, etc. Applications include the removal of defects in castings, risers and gates, gouging out defective welds, back-gouging root runs and removing rivets.
Shall be used in DC- or AC current.

Electrode suitable for cutting, chamfering and gouging of mild and low-alloy steels, cast iron, Nickel-based alloys etc. Used to removing defects in castings or risers and gates.

Storage
Keep dry and avoid condensation.
Re-drying not generally required.
If necessary: 100-150°C for 1 hour, 5 times max.

Current condition and welding position
AC; DC-

PA PB PC

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX	
				PC	Code
3.2	350	130-150	35.3	95	W000287396
4.0	350	200-230	56.1	60	W000287397
5.0	350	220-280	82.5	40	W000287398

SUPERCUT

MMA Electrodes
Cutting

SUPERCUT is a MMA electrode for gouging, piercing, chamfering and cutting of unalloyed, low-alloy and high-alloy steels, cast irons and nickel-based alloys.
Typical applications are the removal of defects from castings and the repair of defective welds.
Shall be used in DC- or AC current.

Storage

Keep dry and avoid condensation. Re-drying not generally required. If necessary: 100-150°C for 1 hour, 5 times max.

Current condition and welding position

AC; DC-

PA PB PC

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX	
				PC	Code
3.2	450	130-170	55.7	70	W000258293
4.0	450	200-260	74.9	55	W000258294