

PRODUCT INFORMATION

SIFALUMIN No 15

EN ISO 18273 S Al 4043A (AlSi5),
BS: 2901 4043A, (NG21)

DESCRIPTION

An aluminium alloy with 5% silicon, offering excellent flow characteristics and penetration. Suitable for welding duralumin cast (LM25) and wrought alloys 6063 (H9), 6061 (H20) and 6082 (H30). Weld will discolour if anodised. Can be used TIG or in Oxy Acetylene. If used in Oxy Acetylene, use our Sif No. 36 Aluminium brazing and welding flux.

WELDING POSITIONS



Ensure that the parent metal surface is cleaned and fully degreased prior to welding. Clean joints with a stainless steel brush.

TYPICAL WELD METAL COMPOSITION

Si	5 %
Al	Bal

TYPICAL MECHANICAL PROPERTIES

Melting Point	635°C
Ult Tensile Strength	120 N/mm ²
Hardness	40

MATERIAL TO BE WELDED

Suitable for welding duralumin, cast and wrought alloys 6063 (H9), 6061 (H20) and 6082(H30), as well as other '4 series' aluminums. The resulting weld will discolour if anodised. Pre-heating up to 120°C may be necessary, subject to material size and thickness. Wire brushing between passes is recommended, to remove build up of surface oxides.

AVAILABLE FORMATS

1M ROD (TIG / GTAW)			
Dia		1kgPkt	2.5kgCarton
1.6mm		RO151601	RO151625
2.4mm		RO152401	RO152425
3.2mm		RO153201	RO153225
5.0mm			RO155025

TIG WELDING	
Current :	DC =+
Shielding Gas :	Argon, Argon/Helium
Oxy Acetylene brazing and welding	

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@wholeweld.co.uk**



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