



**MWA
Product Guide
2nd Edition**

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MAC ALUM E95

Aluminium 4/5% silicon type electrode suitable for the welding of commercially pure aluminium and similar alloys except those which contain magnesium or zinc as main alloying elements. Rapid deposition rate, good penetration, excellent weldability and slag control. The special chemically active mineral coating enables easy removal of surface oxides during welding, ensuring results of high quality. Welding commercially pure aluminium where a slightly higher tensile is required and for higher strength alloys of similar composition. Suitable for welding the wrought alloys H9, H20 and 30. The electrodes are unsuitable for welding alloys with high magnesium such as the 5% Mg type.

Typical All Weld Metal Chemical Analysis (%)

Al	Fe	Si
94.5	0.3	4.0

Typical All Weld Metal Mechanical Properties**As Welded**

Tensile Strength	100 N/mm ²
0.2% Proof Stress	50 N/mm ²
Elongation	20%

Sizes Available and Recommended Amperages

2.5mm	3.2mm	4.0mm	5.0mm
60-90	80-110	110-150	150-180

Related Specification:

AWS E4043

Current:

DC (+)

Storage:

If allowed to become damp, the electrodes should be re-dried for two hours at 110°C before use.

MAC ALUM E97

Aluminium 10/12% silicon type electrode for welding wrought and cast aluminium alloys of similar composition. Rapid deposition rate, good penetration characteristics, excellent stability, weldability and slag control. The special chemically active mineral coating enables easy removal of surface oxides during welding ensuring results of high quality. Suitable for slag over slag welding. Welding wrought alloys N4, H9, H10, H20, H30 and cast alloys LM6, LM8, LM9, LM13 and LM20. Used extensively for repair of casting defects such as surface voids where slag over slag techniques may be employed.

Typical All Weld Metal Chemical Analysis (%)

Al	Fe	Si
88.5	0.5	11.0

Typical All Weld Metal Mechanical Properties**As Welded**

Tensile Strength	180 N/mm ²
0.2% Proof Stress	80 N/mm ²
Elongation	5%

Sizes Available and Recommended Amperages

2.5mm	3.2mm	4.0mm	5.0mm
60-90	80-110	110-150	150-180

Related Specification:

AWS E4047

Current:

DC (+)

Storage:

If allowed to become damp, the electrodes should be re-dried for two hours at 110°C before use.