



MAC ALUM E95

■ **Description & Applications:**

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 H30. The electrodes are unsuitable for welding alloys with high magnesium such as the 5% Mg type.

■ **Related Specification:**

Type 4043
Al Si 4

■ **Typical All Weld Metal Chemical Analysis %:**

Al	Si	Fe
94.5	4.5	0.3

■ **Typical All Weld Metal Mechanical Properties:**

As Welded

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

■ **Current:**

DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
60-90	80-110	110-150	150-180

■ **Storage:**

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