



MAC ALUM E97

■ **Description & Applications:**

Aluminium 10/12% silicon type electrode suitable for the 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, H2, 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.

■ **Related Specification:**

Type 4047
Al Si 12

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

Al	Si	Fe
88.5	11.0	0.5

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

As Welded

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

■ **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.