

# Алюминиевые легированные провода для дуговой сварки в среде защитного газа

## Технические характеристики

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**Standards**

TS EN ISO 18273	: S Al 4043 (AlSi5)
EN ISO 18273	: S Al 4043 (AlSi5)
TS EN ISO 17672	: Al 105
EN ISO 17672	: Al 105
AWS A5.10	: ER 4043

**Chemical Composition of  
Welding Wire % (Typical)**

Al	Si	Mn	Fe
rest	5.0	0.03	0.5

**Mechanical Properties**

Density (kg/dm <sup>3</sup> )	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Melting Range (N/mm <sup>2</sup> )
2.7	100	160	15	573-625

**Features and Applications**

- AISi5 is aluminum TIG rod with high content of silicon
- It is used for joining and filling of aluminum silicon cast alloys including up to 7% silicon
- It is recommended that preheating to 150°C before welding of plates thicker than 15 mm
- For gas welding, GeKaTec F-LH1 is recommended

**Welding Method**

TIG Welding - Gas Welding

Current Type	MIG Wire	Electrode
TIG A.C.	GeKa AISi5 / GeKaTec 4043 MIG	GeKaTec Aluweld Si

**Welding Positions****Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6011100296	1.6 x 1000	1/16 x 39"	5
6011100249	2.0 x 1000	5/64 x 39"	5
6011100250	2.4 x 1000	3/32 x 39"	5
6011100251	3.2 x 1000	1/8 x 39"	5
6011100297	4.0 x 1000	5/32 x 39"	5

# Aluminium TIG & Gas Welding Rod

## AISI 12 TIG

### Standards

TS EN ISO 18273	: S Al 4047 (AISI 12)
EN ISO 18273	: S Al 4047 (AISI 12)
TS EN ISO 17672	: Al 112
EN ISO 17672	: Al 112
AWS A5.10	: ER 4047

### Chemical Composition of Welding Wire % (Typical)

Al	Si	Fe	Mn
rest	12.0	<0.5	<0.3

### Mechanical Properties

Density (kg/dm <sup>3</sup> )	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Melting Range (°C)	Hardness (HB)
2.6	80	170	8	575 - 585	45

### Features and Applications

- AISi 12 is aluminum TIG rod with high content of Silicon
- It is used for joining and filling of aluminum silicon cast alloys including more than 7% silicon
- It has a good fluidity. Oxyacetylene welding and brazing is possible with GeKaTec F-LH1
- It is recommended that preheating to 150°C before welding of plates thicker than 15mm
- Shielding gas: Ar

### Welding Method

TIG Welding - Gas Welding

Current Type	Electrode
TIG A.C.	GeKaTec Aluweld 12 Si

### Welding Positions



### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6011100288	2,00 x 1000	5/64 x 39"	5
6011100289	2,40 x 1000	3/32 x 39"	5
6011100290	3,20 x 1000	1/8 x 39"	5

Approvals: SEPRO, CE

**Al 99.5 TIG****Standards**

TS EN ISO 18273	: ~S Al 1100 (Al 99.0 Cu)
EN ISO 18273	: ~S Al 1100 (Al 99.0 Cu)
AWS A5.10	: ~ER1100

**Chemical Composition of  
Welding Wire % (Typical)**

Al
min. 99

**Mechanical Properties**

Density (kg/dm <sup>3</sup> )	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Melting Range (°C)	Electrical Conductivity (Sm/mm <sup>2</sup> )
2.7	min. 40	min. 70	30	658 - 674	35

**Features and Applications**

- Al99.5 TIG is pure aluminum welding TIG rod
- It is used for joining of aluminum alloys required high electrical conductivity
- It is recommended that preheating to 200°C before welding of plates thicker than 15mm
- For gas welding, GeKaTec F-LH1 is recommended
- Shielding gas: Ar

**Welding Method**

TIG Welding - Gas Welding

Current Type	MIG Wire	Electrode
TIG A.C.	GeKa Al99.5	GeKaTec Aluweld 99Al

**Welding Positions****Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6011100036	2.0 x 1000	5/64 x 39"	5
6011100392	2.4 x 1000	3/32 x 39"	5
6011100038	3.2 x 1000	1/8 x 39"	5
6011100039	4.0 x 1000	5/32 X 39"	5

**Approvals:** SEPRO

# Aluminium TIG & Gas Welding Rod

## AlMg 5 TIG

### Standards

TS EN ISO 18273	: S Al 5356 (AlMg5Cr(A))
EN ISO 18273	: S Al 5356 (AlMg5Cr(A))
DIN 1732	: SG-AlMg5
AWS A5.10	: ER 5356

### Chemical Composition of Welding Wire % (Typical)

Al	Mg	Si	Mn
rest	5.0	0.5	0.5

### Mechanical Properties

Densitt (kg/dm <sup>3</sup> )	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Melting Range (°C)	Hardness (HB)
2.6	120	250	25	560 - 630	70

### Features and Applications

- AlMg5 is magnesium alloyed aluminum TIG rod
- It is used for joining of aluminum alloys required high mechanical properties
- The weld deposit has a good resistance to atmospheric influences and sea water
- And the weld metal is proper for surface treatment such as anodizing and polishing
- it is recommended that preheating to 150°C before welding of plates thicker than 15mm
- For gas welding, GeKaTec F-LH1 is recommended
- Shielding gas: Ar

### Welding Method

TIG Welding - Gas Welding

Current Type	MIG Wire
TIG A.C.	GeKa AlMg 5

### Welding Positions



### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6011100062	1,60 x 1000	1/16 x 39"	5
6011100281	2,00 x 1000	5/64 x 39"	5
6011100282	2,40 x 1000	3/32 x 39"	5

Approvals: SEPRO

# Aluminium TIG & Gas Welding Rod

## AlMg 4.5 Mn TIG

### Standards

TS EN ISO 18273	: SAI 5183(AlMg4.5Mn0.7A)
EN ISO18273	: SAI 5183(AlMg4.5Mn0.7A)
AWS A5.10	: ER 5183

### Chemical Composition of Welding Wire % (Typical)

Al	Si	Fe	Mn	Mg	Cr
rest	<0.4	<0.4	0.8	5.0	0.2

### Mechanical Properties

Densitt (kg/dm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))	Melting Range (°C)	Hardness (HB)
2.6	170	250	20	575 - 585	45

### Features and Applications

- AlMg4.5Mn is Magnesium alloyed Aluminum TIG rod
- It is used for joining of Aluminum alloys including more than 3% Mg
- The weld deposit has a good resistance to atmospheric influences and sea water
- It is recommended that preheating to 150 °C before welding of plates thicker than 15mm
- For gas welding, GeKaTec F-LH1 is recommended
- Shielding gas: Ar

### Welding Method

TIG Welding - Gas Welding

### Welding Positions



### Current Type

TIG A.C.

### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6011100284	2.0 x 1000	5/64 x 39"	5
6011100393	2.4 x 1000	3/32 x 39"	5
6011100285	3.2 x 1000	1/8 x 39"	5

Approvals: SEPRO, CE

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