

## ELECTRODE WITH EXTRUDED COVERING FOR ALUMINIUM AND ALUMINIUM ALLOYS. FILLER METAL IS DEPOSITED FASTER.

CLASSIFICATION A.W.S: E-4043

IDENTIFICATION: WHITE COATING

**APPLICATIONS:** This welding rod is recommended for metal sheets, plates, for aluminium cast parts which are 1/8" thick or over. It is widely used in the production and maintenance of tanks, pipelines, heavy and light aluminium cast parts, structural parts, foundry moulds, car parts and protection handrails. This is a very useful welding rod to repair cracks, to restore defective areas and to provide surfacing and reinforcement. It has also been used successfully to build structures, refrigeration equipment, in the chemical industry, in pipelines, in tanks, monoblocks, pulleys, fans, etc.

**CHARACTERISTICS AND PROCEDURE:** This is a special electrode with a silicon aluminium core and extruded covering. This combination of the wire core and the covering allows 34 welding rod to produce a very stable arc. The resulting filler metal deposit will be full, smooth, splatter free and the colour will match that of the base metal well. Clean the joint area well. Whenever the base metal thickness exceeds 1/8" it should be chamfered at an angle of 75°. With thin material, preheating is unnecessary but in heavier sections, it is recommended to preheat up to 200°C. As a rule, you should lay rows of stringer beads since weave beads have been found to produce some cavities. Keep the arc short and the welding rod slightly tilted in the same direction you are welding. Let the part cool down slowly. Remove the slag. For deeper cleaning, use a wire brush and a solution of 5 to 10 % sulphuric acid in hot water. Rinse with clean hot water.

<b>TENSILE RESISTANCE:</b>	1,600 KG./CM2 (22,752 PSI)
<b>POSITIONS:</b>	ALL
<b>CURRENT:</b>	DC REVERSE POLARITY
<b>COLOUR MATCH:</b>	GOOD

FILLER METAL CHEMICAL ANALYSIS %		SIZES	AMPERAGE
Al	Si	2.38 mm - 3/32"	50-70
88.0	4.0 a 6.0	3.25 MM - 1/8"	80-100
		4.0 mm - 5/32"	100-140