



**PRODUCT INFORMATION**

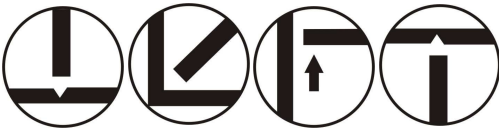
**SIFALUMIN No 15**

EN ISO 18273 S Al 4043A (AISI5),  
BS: 2901 4043A, (NG21)

**DESCRIPTION**

An aluminium alloy with 5% silicon, offering excellent flow characteristics and penetration. Suitable for welding duralumin cast (LM25) and wrought alloys 6063 (H9), 6061 (H20) and 6082 (H30). Weld will discolour if anodised. Can be used TIG or in Oxy Acetylene. If used in Oxy Acetylene, use our Sif No. 36 Aluminium brazing and welding flux.

**WELDING POSITIONS**



Ensure that the parent metal surface is cleaned and fully degreased prior to welding. Clean joints with a stainless steel brush.

**TYPICAL WELD METAL COMPOSITION**

|    |     |
|----|-----|
| Si | 5 % |
| Al | Bal |

**TYPICAL MECHANICAL PROPERTIES**

|                      |                       |
|----------------------|-----------------------|
| Melting Point        | 635°C                 |
| Ult Tensile Strength | 120 N/mm <sup>2</sup> |
| Hardness             | 40                    |

**MATERIAL TO BE WELDED**

Suitable for welding duralumin, cast and wrought alloys 6063 (H9), 6061 (H20) and 6082(H30), as well as other '4 series' aluminiums. The resulting weld will discolour if anodised. Pre-heating up to 120°C may be necessary, subject to material size and thickness. Wire brushing between passes is recommended, to remove build up of surface oxides.

**AVAILABLE FORMATS**

| 1M ROD (TIG / GTAW) |  |          |             |
|---------------------|--|----------|-------------|
| Dia                 |  | 1kgPkt   | 2.5kgCarton |
| 1.6mm               |  | RO151601 | RO151625    |
| 2.4mm               |  | RO152401 | RO152425    |
| 3.2mm               |  | RO153201 | RO153225    |
| 5.0mm               |  |          | RO155025    |

| TIG WELDING                       |                     |
|-----------------------------------|---------------------|
| Current :                         | DC =+               |
| Shielding Gas :                   | Argon, Argon/Helium |
| Oxy Acetylene brazing and welding |                     |

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@wholeweld.co.uk**



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