

Alumi Glide[®] ALUMINUM WELDING WIRES

TYPICAL WELD METAL COMPOSITION (Weight %)

	Al (Aluminum)	Mn (Manganese)	Fe (Iron)	Cu (Copper)	Be (Beryllium)	Si (Silicon)	Mg (Magnesium)	Cr (Chromium)	Ti (Titanium)	Zn (Zinc)	Other Elements
4043	Remainder	0.05 Max	0.80 Max	0.30 Max	0.0003 Max	4.5-6.0	0.05 Max		0.20 Max	0.10 Max	0.05 Max & Total 0.15 Max
4943	Remainder	0.05 (max.)	0.40 (max.)	0.10 (max.)	0.0003 (max.)	5.0 – 6.0	0.30 – 0.50		0.15 (max.)	0.10 (max.)	0.05 Max & Total 0.15 Max
5356	Remainder	0.05-0.20	0.40 (max.)	0.10 (max.)	0.0003 (max.)	0.25 (max.)	4.5-5.5	0.05-0.20	0.06-0.20	0.10 (max.)	0.05 Max & Total 0.15 Max

MIG WELDING PROCEDURES: DCEP

DIA.	WFS (in/min.)	AMPERAGE	VOLTAGE	CONSUMPTION LB/100FT	ARGON (cfh)
0.030	480-625	60-175	15-24	0.65-1.25	25-30
0.035	450-750	70-185	15-27	1.00-4.25	30-35
3/64"	330-500	125-260	20-29	1.00-4.25	35-45
1/16"	250-450	170-300	24-30	3.8-66	45-75
3/32"	160-200	275-400	26-31	35-66	60-85