

GOLD 610 -E

ELECTRODE FOR ALUMINIUM

Description and Applications:

**For welding aluminum and aluminum alloys.
(AL-Si; AL-Si-Mg; AL-Si-Mg-Cu)**

Use for repairs and joining of Al Plates, sheets, pipes, extrusions etc.
Applications include al. engine blocks, cylinder heads, boats construction, housings, pumps, tanks, moulds, frames, truck bodies, bus bars etc.

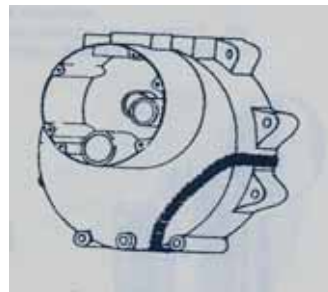
High strength versatile alloy which can be used for production and maintenance.
Fast deposition, good weld ability.



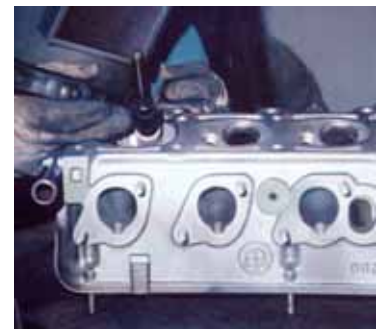
**For repair and fabrication of
aluminum boats**



**Weld Cast aluminum
Frames**



**Repair
broken housings**



Repair al engine blocks/cylinder heads

Mechanical properties Up to :

Rm (MP60a)	Rp0,2 (MPa)	A5 (%)
180	80	6

Hardness ~ 50 HB

Packaging

Data

Sizes	2.5x350	3.2x350	4.0x350
Kgs/Package	2	2	2
Packages/carton	4	4	4
Kgs/carton	8	8	8

Welding instructions

Current (A)	60	90	120
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Welding positions



1G/PA



2F/PB



2G/PC

= +

Clean weld area. Bevel thickness 3 mm or heavier to a 75° vee. Preheat heavy sections to approx 200°C
Use DC reverse polarity. Strike Arc by drawing electrode lightly on workpiece or on copper starting block. Maintain very short arc with electrode almost perpendicular.
Chip of slag between passes. Allow to cool slowly.