



Manufacturers of Custom Welding Lines for Resale
www.selectrode.com

SELECTRODE
7090
4043 Aluminum MIG

INTERNATIONAL CLASSIFICATIONS

AWS A5.10: ER4043
ISO 18273: AlSi5

DIN 1732: SG-ALSi5

FEATURES & APPLICATIONS

APPLICATIONS:

For welding aluminums alloyed with copper, silicon, and magnesium. It is also excellent for joining dissimilar grades of aluminum. The higher silicon content reduces the melting point and increases the fluidity.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Si	Cu	Fe	Mg	Mn	Zn	Al
5.25	.23	.80	.04	.04	.08	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	34,000 PSI (250 N/mm ²)
Yield Strength	20,000 PSI (150 N/mm ²)
Elongation	18%

WELDING CURRENT & INSTRUCTIONS

Welding Current: DC Reverse (+)

Shielding Gas: Argon shielding gas is suggested for plate thickness of ½” or less. For plate thickness of greater than 1”, argon/helium mixtures should be considered.

Recommended Settings:

Wire Size	Welding Current (Amps)	Arc Voltage	Wire Feed Speed (ipm)
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3/32"	190-450	24-32	100-210
1/16"	160-360	24-30	180-300
3/64"	130-290	22-28	235-375
.035"	110-220	22-28	350-475
.030"	95-200	22-28	470-680
.025"	85-180	20-26	520-750