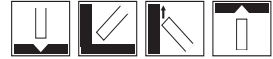


Solid Wires

Aluminium MIG Wire

Bostrand 281

AWS A/SFA 5.10-92 ER4043



Description and applications

Bostrand 281 is an aluminium/5% silicon solid MIG wire which is used to weld aluminium alloys of the AlMgSi type, and AlSi types with up to 7% Si. Bostrand 281 may also be used to join wrought to cast materials eg BS 1490 LM2 and LM6. The resistance of the weld metal to hot cracking is high.

Typical all-weld mechanical properties – as welded using Argon or Argon Helium

Yield Stress	50 min	MPa
Tensile Strength	150 min	MPa
Elongation	15 min	%

Chemical Composition (wire)

	Min	Max
Si	4.5	5.5
Mn		0.05
Cr		0.05
Ti		0.15
Al	Balance	

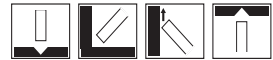
Welding Parameters

Size (mm)	1.2	1.6
Current (amps)	130-220	170-320

Group equivalent for 0.8mm and 1.0mm – OK Autrod 4043.

Bostrand 286

BS 2901: Part 4 1990 5356
AWS A/SFA 5.10-92 ER5356
DIN 1732 (1988) SG-AlMg5



Description and applications

Bostrand 286 is an aluminium/5% magnesium solid MIG wire for welding similar parent materials as shown in the above table. It may also be used to weld cast materials such as BS 1490 LM5.

Typical all-weld mechanical properties – as welded using Argon or Argon Helium

Yield Stress	110 min	MPa
Tensile Strength	235 min	MPa
Elongation	17 min	%

Chemical Composition (wire)

	Min	Max
Si		0.25
Mn	0.10	0.20
Cr	0.05	0.20
Mg	4.5	5.5
Fe		0.40
Ti	0.06	0.15
Al	Balance	

Welding Parameters

Size (mm)	0.8	1.0	1.2	1.6
Current (amps)	80-120	90-180	130-200	170-300