

# Lehami 7505

**5 % Silicon Aluminum Arc Welding  
Electrode with exclusive self-lifting slag.**



## SPECIAL FEATURES

- Unique self lifting slag.
- Pure white long shelf life extruded flux coating outlasts conventional products in moisture resistance.

## APPLICATIONS

For arc welding aluminums alloyed with copper, silicon, and magnesium. Also excellent for joining dissimilar grades of aluminum.

## AVAILABLE SIZES

INCHES	METRIC	GAUGE	RECOMMENDED AMPERAGE
5/64"	2.0 mm	14	20 - 60
3/32"	2.5 mm	12	50 - 80
1/8"	3.2 mm	10	70 - 120
5/32"	4.0 mm	8	110 - 150

**RECOMMENDED CURRENT:** DC Reverse polarity (Electrode +)

**WELDING POSITIONS:** Flat, Horizontal

## WELDING TECHNIQUES:

Start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

## TYPICAL MECHANICAL PROPERTIES

### Undiluted Weld Metal

Tensile Strength as welded

Yield Strength

Elongation

### Maximum Value Up to:

34,000 psi (250 N / mm<sup>2</sup>)

20,000 psi (150 N / mm<sup>2</sup>)

18%

**DEPOSITION RATES**

<i>Diameter</i>	<i>Length</i>	<i>Weldmetal / Electrode</i>	<i>Electrodes per lb (kg) of Weldmetal</i>	<i>Arc Time of Deposition in Minutes per lb (kg) of Weldmetal</i>	<i>Recovery Rate</i>
5/64" (2.0 mm)	10" (250 mm)	0.08 oz (2.6 g)	184 (404)	176 (387)	90 %
3/32" (2.5 mm)	14" (350 mm)	0.14 oz (4.3 g)	114 (251)	110 (242)	90 %
1/8" (3.2 mm)	14" (350 mm)	0.23 oz (6.5 g)	70 (153)	62 (136)	90 %
5/32" (4.0 mm)	14" (350 mm)	0.33 oz (9.6 g)	48 (107)	47 (103)	90 %

**WELD METAL ANALYSIS (Typical Weight)**

Al	Cu	Fe	Mg	Mn	Si	Zn
Bal.	0.23	0.80	0.04	0.04	5.25	0.08

<b>INTERNATIONAL SPECIFICATIONS</b>	<b>AWS/ASME SFA 5.3 E4043</b>
	<b>DIN 1732 EL- AISi5</b>