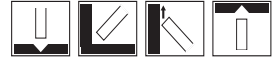


# Solid Wires

## 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	

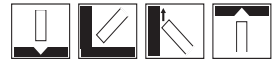
#### Welding Parameters

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