

## ALU Si12

Electrodes MMA [SMAW]

Aluminium alloys

<b>CLASSIFICATION:</b> EN ISO 18273-A : Al 4047A (AlSi12) DIN 1732 : EL-AlSi12 AWS A-5.3 : E 4047 W.Nr. : 3.2585	<b>APPROVALS:</b>	<b>APPLICATION:</b> Hardfacing and repairing Metallurgy (Steelworks)
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- Aluminum electrode for welding aluminum castings and silicon-aluminium alloys.



### Base material

EN/DIN	W.Nr.	PN	ISO/EN
G-AlSi10Mg	3.2381		
G-AlSi12	3.2581		
G-AlSi10Mg(Cu)	3.2383		
G-AlSi12(Cu)	3.2583		
AlMg1SiCu	3.3211	PA45	6061
AlMg0,5Si	3.3206	PA38	6063
AlMgSi1	3.2315	PA4	6082
G-AlSi5Mg	3.2373		

### Typical chemical composition %

<b>Si</b>	<b>Fe</b>	<b>Al</b>
12,0	0,50	87,5

### Typical mechanical properties

<b>Yield strength Re [N/mm<sup>2</sup>]</b>	>80
<b>Tensile strength Rm [N/mm<sup>2</sup>]</b>	170
<b>Elongation A5 [%]</b>	>13
<b>Hardness</b>	60[HB] /
<b>Coating type</b>	special alkaline
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Redrying</b>	100-150°C / 1-2 h
<b>Additional description</b>	Due to the high hygroscopicity of the coating, the product should be stored in clean and dry places. Welding instruction: Start welding at approximately 130% of standard current (Hot Start). Hold the electrode at right angles to the material to be welded. Weld on a very short arc, they move forward quickly. Materials thicker than 5 [mm] should be preheated to about 100-200 [°C]. A high bead indicates too cold base material or too low welding parameters. The remains of the slag formed should be very well cleaned from the face of the weld.

**Welding parameters and packing**

<b>∅</b>	<b>Length [mm]</b>	<b>Welding current [A]</b>	<b>Weight of packet [kg]</b>	<b>Weight of carton [kg]</b>	<b>Pcs/1 kg</b>
2,5	350 /	50-90	2,0	8,0	106
3,2	350 /	70-110	2,0	8,0	74
4,0	350 /	90-130	2,0	8,0	51

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