ALU Si12

Electrodes MMA [SMAW]

Aluminium alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 18273-A : Al 4047A (AlSi12) DIN 1732 : EL-AlSi12 AWS A-5.3 : E 4047 W.Nr. : 3.2585		Hardfacing and repairing Metallurgy (Steelworks)

- 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 %

Si	Fe	Al
12,0	0,50	87,5

Typical mechanical properties

Yield strength Re [N/mm2]	>80
Tensile strength Rm [N/mm2]	170
Elongation A5 [%]	>13
Hardness	60[HB] /
Coating type	special alkaline
Welding current	
Welding positions	
Redrying	100-150°C / 1-2 h
Additional description	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

⌀	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
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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