



Selectarc Al112

Aluminium Electrode with 12% Si

Classification

AWS A5.3 : E4047

DIN 1732 : EL-AlSi12

Description & Applications

Aluminium electrode with 12%Si for welding and repairing aluminium or aluminium alloy pieces (AlSi, AlCuSiMn, AlSiMg). Specially designed for welding cast or extruded aluminium alloys with Si-levels higher than 7%. Dissimilar joints between aluminium and aluminium alloys.

Main applications: Engine blocks, cylinder heads, tanks, containers, frames, lorry tipper.

Base materials

DIN	Material N°
G-AlSi9Mg	3.2373
G-AlSi10Mg	3.2381
G-AlSi10MgCu	3.2383
G-AlSi12	3.2581
G-AlSi12Cu	3.2583

Typical Weld Metal Composition (%)

Si	Cu	Fe	Mg	Mn	Zn	Ti	Be	Al	A/C	A/T
12.1	0.001	0.2	0.01	0.003	0.001	0.008	0.0001	Bal.	<0.05	<0.15

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
150	250	14	~50 HB

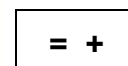
Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	60	90	120

Clean the weld zone; preheat massive pieces (more than 6mm of thickness) to 150-250°C. In order to avoid all risks of porosity, weld with a short arc and guide the electrode at 90° to the piece to be welded. Use a fast travel speed, remove slag between passes and when finished.

Warning! Aluminium electrodes are very sensitive to humidity pick-up. Therefore, keep the opened tins in a dry place. In case of humidity pick-up, dry the electrodes 2h/100°C.

FT En-306-181008



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