

## E AISi 12

**CATEGORY** SMAW Stick Electrodes

**TYPE** Coated electrode for rapidly joining cast aluminum alloys.

**APPLICATIONS** Joining aluminum alloys such as broken gear parts and or other casting parts, also ideal for cladding or rebuilding wornout parts.

**PROPERTIES** Very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up.

**CLASSIFICATION**

AWS	5.3: E 4047
EN ISO	EN 573-3: E AISi12
DIN: W.Nr.	3.2585
DIN	1732: EL-AISi12

**SUITABLE FOR** cast aluminium with more than 7% silicium, 3.2581, 3.2583, 3.2381, 3.2383, 3.2373, G-AISi 12, G-AISi 12 (Cu), G-AISi 10 Mg, G-AISi 10 Mg (Cu), G-AISi 9 Mg,

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

Si	Cu	Fe	Mg	Mn	Zn	Al
11.80	0.23	0.80	0.04	0.04	0.08	bal

**MECHANICAL PROPERTIES**

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	150	250	14				

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (DC+)	kg / can	kg / 6 pack	Type
2.0	250	40	2	12	Hermetically closed
2.5	350	70	2	12	Hermetically closed
3.2	350	110	2	12	Hermetically closed
4.0	350	135	2	12	Hermetically closed