



CEWELD AlSi 12

TYPE Aluminium silicon alloy for welding cast aluminum parts, also suitable as brazing alloy with suitable flux.

ANWENDUNGEN Aluminium alloy for welding and brazing. This material is generally used for brazing aluminium sheets, for extrusions and castings. (After anodizing the welding will be of a different color)

EIGENSCHAFTEN AlSi12 was originally developed as a brazing alloy to take advantage of its low melting point and narrow freezing range. In addition, it has a higher silicon content than AlSi5, which provides increased fluidity and reduced shrinkage. Hot cracking is significantly reduced when using AlSi12 as a filler alloy. The alloy may be used in applications at sustained elevated temperatures. Non-heat treatable. Thicker sections should be preheated (150°C) prior to welding.

KLASSIFIKATION

AWS	A 5.10: ER4047A
EN ISO	18273: S Al 4047A (AlSi12(A))
W.Nr.	3.2585
F-nr	23

GEEIGNET FÜR Cast aluminium up to 12% Si:
G-AlSi10Mg, G-AlSi11, G-AlSi12 (Cu), G-AlSi7Mg, G-AlSi6Cu4, G-AlSi9Mg, G-AlSi9Cu3, 4145, 3.2581, 3.2583, 3.2381, 3.2383, 3.2373, 3.2163, 3.2371, 3.2151, B 413.0, 361.0, 359.0, 356.0, 319.0,

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

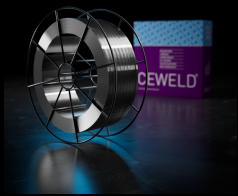
Si	Mn	Ti	Fe	Cu	Zn	Al
12	0.1	0.1	0.3	0.1	0.1	Rem.

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	95	190	6	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 11, 13



CEWELD ALSi 12

ALSI 12 0,8MM

Packaging	KG/unit	EanCode
D-100	0,5	8720663407719
D-200	2	8720663407726
D-300	7	8720663407764

ALSI 12 1,0MM

Packaging	KG/unit	EanCode
BS-300	7	8720663407771
D-100	0,5	8720663407733
D-200	2	8720663407740

ALSI 12 1,2MM

Packaging	KG/unit	EanCode
D-200	2	8720663407757
D-300	7	8720663407788

ALSI 12 1,6MM

Packaging	KG/unit	EanCode
D-300	7	8720663407795

ALSI 12 2,4MM

Packaging	KG/unit	EanCode
D-300	7	8720663407801