



# CEWELD AlSi 12

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

**APPLICATIONS** 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)

**PROPERTIES** 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.

**CLASSIFICATION**

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

**SUITABLE FOR** 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,

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

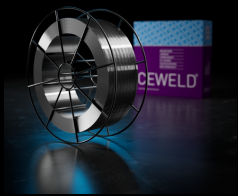
Si	Mn	Ti	Fe	Cu	Zn	Al
12	0.1	0.1	0.3	0.1	0.1	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	95	190	6	HRc

**REDRYING** 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