



# CEWELD E AISi 12

**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.

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

**CLASSIFICATION**

AWS	A 5.3: E 4047
EN ISO	18273: E AISi12(A)
W.Nr.	3.2585
FM	23

**CONVIENT POUR** **Al 4047A (AlSi12)**  
 Cast Aluminium with more than 7% Silicium,  
**Mat.n:** 3.2211, 3.2315, 3.2371, 3.2373, 3.2381, 3.2383, 3.2581, 3.2583, 3.3206,  
 G-AlSi12, G-AlSi12(Cu), G-AlSi10Mg, G-AlSi10Mg(Cu), G-AlSi9Mg, AlMg1SiCu, AlMg0,5Si, AlMgSi1,  
 G-AlSi5Mg  
**Iso. n:** 6061, 6063, 6082  
 EN AC-42100 [AlSi7Mg0.3], EN AC-43000 [AlSi10Mg(A)], EN AC-43200 [AlSi10Mg(Cu)], EN AC-43300 [AlSi9Mg], EN AC-44000 [AlSi11], EN AC-44200 [AlSi12(A)], EN AC-47000 [AlSi12(Cu)]

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

Si	Mn	Ti	Fe	Cu	Zn	Al
12	0.05	0.08	0.15	0.3	0.2	Rem.

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	150	250	14	HRc

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**



# CEWELD E ALSi 12

E ALSI 12 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2	8720663406743

E ALSI 12 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2	8720663406750

E ALSI 12 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2	8720663406767