

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))
F-nr	23
W.Nr.	3.2585

SUITABLE FOR 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, Cast aluminium

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

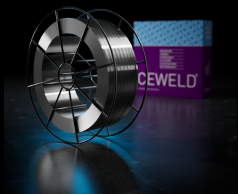
Si	Mn	Ti	Fe	Cu	Zn	Al
12	0.1	0.1	0.3	0.1	0.1	Rem.

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	
As Welded /	75	170	6	

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 I1, I3



CEWELD ALSi 12

ALSI 12 0,8MM

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

ALSI 12 1,0MM

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

ALSI 12 1,2MM

Type	KG/unit	EANCode
D-200	2	8720663407757
D-300	7	8720663407788

ALSI 12 1,6MM

Type	KG/unit	EANCode
D-300	7	8720663407795

ALSI 12 2,4MM

Type	KG/unit	EANCode
D-300	7	8720663407801