



CEWELD AlSi 12 Tig

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 weld will be of a different color)																
PROPERTIES	CEWELD® AlSi12 Tig 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. 3.2885																
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 (%)	<table><tr><td>Si</td><td>Mn</td><td>Ti</td><td>Fe</td><td>Cu</td><td>Zn</td><td>Al</td><td>Mg</td></tr><tr><td>12</td><td>0.08</td><td>0.05</td><td>0.15</td><td>0.01</td><td>0.01</td><td>Rem.</td><td>0.01</td></tr></table>	Si	Mn	Ti	Fe	Cu	Zn	Al	Mg	12	0.08	0.05	0.15	0.01	0.01	Rem.	0.01
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ALL WELD MECHANICAL PROPERTIES	<table><tr><td>Heat Treatment</td><td>$R_{P0,2}$ MPa</td><td>Rm MPa</td><td>A5 (%)</td></tr><tr><td>As Welded /1h</td><td>75</td><td>140</td><td>12</td></tr></table>	Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	As Welded /1h	75	140	12								
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As Welded /1h	75	140	12														
REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175	I1, I3																



CEWELD AlSi 12 Tig

ALSI 12 TIG 1,6 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663407665
ALSI 12 TIG 2,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663407658
ALSI 12 TIG 2,4 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663407672
ALSI 12 TIG 3,2 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663407689
ALSI 12 TIG 4,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663407696
ALSI 12 TIG 5,0 X 1000MM	Type	KG/unit	EANCode
	Tube	5	8720663407702