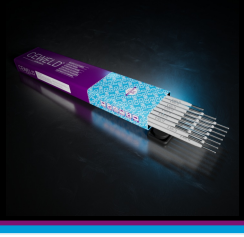


CEWELD E AlSi 12

certilas® THE FILLER METAL SPECIALIST

TYPE

Coated electrode for fast joining of cast aluminum alloys with more than 7% Si (AlSi12, 4047A).

APPLICATIONS

CEWELD® E AlSi 12 is for joining aluminum alloyed with copper, silicon, and magnesium.
Also excellent for joining dissimilar grades of aluminum.
For welding broken gear parts and or other casting parts, also ideal for cladding or rebuilding wornout parts, Engine blocks, cylinder heads, tanks, containers, frames, lorry tipper.

PROPERTIES

CEWELD® E AlSi 12 have a very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up. Start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

CLASSIFICATION

AWS	A 5.3: E 4047
EN ISO	18273: E AlSi12(A)
FM	23
W.Nr.	3.2585

SUITABLE FOR

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)]

APPROVALS

No Approvals Found

WELDING POSITIONS

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.

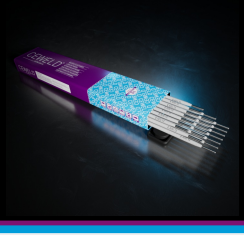
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)
As Welded /	150	250	14

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175



CEWELD E AlSi 12

certilas® THE FILLER METAL SPECIALIST

E ALSI 12 2,5 X 350MM

Type	KG/unit	EANCode
Can	2	8720663406743

E ALSI 12 3,2 X 350MM

Type	KG/unit	EANCode
Can	2	8720663406750

E ALSI 12 4,0 X 350MM

Type	KG/unit	EANCode
Can	2	8720663406767