



CEWELD E AlSi 12

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 EN ISO W.Nr. FM	A 5.3: E 4047 18273: E AlSi12(A) 3.2585 23				
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						
WELDING POSITIONS	 PA  PB  PC					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	Si 12	Mn 0.05	Ti 0.08	Fe 0.15	Cu 0.3	Zn 0.2 Al Rem.
MECHANICAL PROPERTIES	Heat Treatment As Welded		R _{P0,2} (MPa) 150	R _m (MPa) 250	A5 (%) 14	Hardness HRc
REDRYING	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