



CEWELD AlSi 12

TYPE	Aluminium silicon alloy for welding cast aluminum parts, also suitable as brazing alloy with suitable flux.						
ANWENDUNGEN	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)						
EIGENSCHAFTEN	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.						
KLASSIFIKATION	AWS	A 5.10: ER4047A					
	EN ISO	18273: S Al 4047A (AlSi12(A))					
	W.Nr.	3.2585					
	F-nr	23					
GEEIGNET FÜR	Cast aluminium up to 12% Si: 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,						
ZULASSUNGEN	CE						
SCHWEISSPOSITIONEN							
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	Si	Mn	Ti	Fe	Cu	Zn	Al
	12	0.1	0.1	0.3	0.1	0.1	Rem.
MECHANISCHE GÜTEWERTE	Heat Treatment		R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness	
	As Welded		95	190	6	HRc	
RÜCKTROCKNUNG	Not required						
GAS ACC. EN ISO 14175	I1, I3						



CEWELD ALSi 12

ALSI 12 0,8MM

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

ALSI 12 1,0MM

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

ALSI 12 1,2MM

Packaging	KG/unit	EanCode
D-200	2	8720663407757
D-300	7	8720663407788

ALSI 12 1,6MM

Packaging	KG/unit	EanCode
D-300	7	8720663407795

ALSI 12 2,4MM

Packaging	KG/unit	EanCode
D-300	7	8720663407801