

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)) |
| W.Nr. | 3.2585 |
| F-nr | 23 |

SUITABLE FOR 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,

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

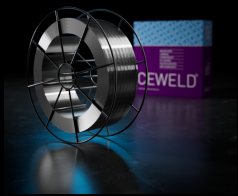
| Si | Mn | Ti | Fe | Cu | Zn | Al |
|----|-----|-----|-----|-----|-----|------|
| 12 | 0.1 | 0.1 | 0.3 | 0.1 | 0.1 | Rem. |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded | 95 | 190 | 6 | HRc |

REDRYING 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 |