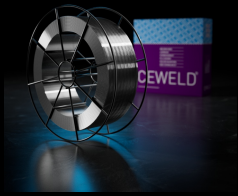


CEWELD AlSi 12

TYPE	Aluminium silicon alloy for welding cast aluminum parts, also suitable as brazing alloy with suitable flux.														
TOEPASSINGEN	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)														
EIGENSCHAPPEN	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.														
CLASSIFICATIE	<table border="0"> <tr> <td>AWS</td> <td>A 5.10: ER4047A</td> </tr> <tr> <td>EN ISO</td> <td>18273: S Al 4047A (AlSi12(A))</td> </tr> <tr> <td>W.Nr.</td> <td>3.2585</td> </tr> <tr> <td>F-nr</td> <td>23</td> </tr> </table>	AWS	A 5.10: ER4047A	EN ISO	18273: S Al 4047A (AlSi12(A))	W.Nr.	3.2585	F-nr	23						
AWS	A 5.10: ER4047A														
EN ISO	18273: S Al 4047A (AlSi12(A))														
W.Nr.	3.2585														
F-nr	23														
GESCHIKT VOOR	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,														
GOEDKEURINGEN	CE														
LASPOSITIES															
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>Si</th> <th>Mn</th> <th>Ti</th> <th>Fe</th> <th>Cu</th> <th>Zn</th> <th>Al</th> </tr> </thead> <tbody> <tr> <td>12</td> <td>0.1</td> <td>0.1</td> <td>0.3</td> <td>0.1</td> <td>0.1</td> <td>Rem.</td> </tr> </tbody> </table>	Si	Mn	Ti	Fe	Cu	Zn	Al	12	0.1	0.1	0.3	0.1	0.1	Rem.
Si	Mn	Ti	Fe	Cu	Zn	Al									
12	0.1	0.1	0.3	0.1	0.1	Rem.									
MECHANISCHE WAARDEN	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{P0.2} (MPa)</th> <th>R_m (MPa)</th> <th>A₅ (%)</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>95</td> <td>190</td> <td>6</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded	95	190	6	HRc				
Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness											
As Welded	95	190	6	HRc											
HERDROGEN	Not required														
GAS ACC. EN ISO 14175	11, 13														



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