

EL-AISi12

CATEGORY	SMAW Stick Electrodes
TYPE	Coated electrode for rapidly joining cast aluminum alloys.
APPLICATIONS	Joining aluminum alloys such as broken gear parts and or other casting parts, also ideal for cladding or rebuilding wornout parts.
PROPERTIES	Very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up.

CLASSIFICATION	AWS	5.3: E 4047
	EN ISO	EN 573-3: E AISi12
	DIN: W.Nr.	3.2585
	DIN	1732: EL-AISi12

SUITABLE FOR	cast aluminium with more than 7% silicium, 3.2581, 3.2583, 3.2381, 3.2383, 3.2373, G-AISi 12, G-AISi 12 (Cu), G-AISi 10 Mg, G-AISi 10 Mg (Cu), G-AISi 9 Mg,
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WELDING POSITIONS:	
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WELD METAL ANALYSIS %						
Si	Cu	Fe	Mg	Mn	Zn	Al
11.80	0.23	0.80	0.04	0.04	0.08	bal

MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	150	250	14				

AW: as welded

WELDING PARAMETERS / PACKING						
Welding Parameters			Packing			
D (mm)	Length (mm)	Current (A) (DC+)	kg / can	kg / 6 pack	Type	
2.0	250	40	2	12	Hermetically closed	
2.5	350	70	2	12	Hermetically closed	
3.2	350	110	2	12	Hermetically closed	
4.0	350	135	2	12	Hermetically closed	