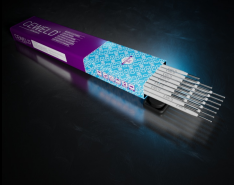




# CEWELD E AlSi 12

|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                    |                            |                         |           |          |      |
|--------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|----------------------------|-------------------------|-----------|----------|------|
| 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.                                                                                                                                                                                                                                                                                                                                                                  |                    |                            |                         |           |          |      |
| PROPRIÉTÉS                                             | Very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up.                                                                                                                                                                                                                                                                                                                                                      |                    |                            |                         |           |          |      |
| CLASSIFICATION                                         | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | A 5.3: E 4047      |                            |                         |           |          |      |
|                                                        | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 18273: E AlSi12(A) |                            |                         |           |          |      |
|                                                        | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 3.2585             |                            |                         |           |          |      |
|                                                        | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 23                 |                            |                         |           |          |      |
| CONVIENT POUR                                          | <b>Al 4047A (AlSi12)</b><br>Cast Aluminium with more than 7% Silicium,<br><b>Mat.n:</b> 3.2211, 3.2315, 3.2371, 3.2373, 3.2381, 3.2383, 3.2581, 3.2583, 3.3206,<br>G-AlSi12, G-AlSi12(Cu), G-AlSi10Mg, G-AlSi10Mg(Cu), G-AlSi9Mg, AlMg1SiCu, AlMg0,5Si, AlMgSi1,<br>G-AlSi5Mg<br><b>Iso. n:</b> 6061, 6063, 6082<br>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)] |                    |                            |                         |           |          |      |
| AGRÉMENTS                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                    |                            |                         |           |          |      |
| POSITIONS DE SOUDAGE                                   | <div>PAPBPC</div>                                                                                                                                                                                                                             |                    |                            |                         |           |          |      |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | Si                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Mn                 | Ti                         | Fe                      | Cu        | Zn       | Al   |
|                                                        | 12                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 0.05               | 0.08                       | 0.15                    | 0.3       | 0.2      | Rem. |
| PROPRIÉTÉS MÉCANIQUES                                  | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                    | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |      |
|                                                        | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                    | 150                        | 250                     | 14        | HRc      |      |
| ETUVAGE                                                | 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 |