

# ALBOND 12 Si

NON FERROUS (Al Alloys)

## KEY FEATURES:

- Aluminium alloy with typical 12% Si
- Special coating to reduce moisture pickup
- Electrode dia. should roughly be equivalent to plate thickness
- Provide high melting rate
- Slag residues should be thoroughly removed to obtain non corrosive weld
- Section thickness above 8 mm should be preheated to min. 200°C

## TYPICAL APPLICATIONS:

- Welding and repair of cast Al alloys containing more than 7% Si
- Engine blocks, Gear box units, Automotive parts
- Window frames, Tubes, Furniture
- Al alloys such as G-ALSi 12, G-ALSi 12 (Cu), G-ALSi 10Mg, G-ALSi 10Mg (Cu)



## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

Si	Fe	Al
11.2	0.2	Bal

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	195	5.5
Specification		180 min	4-8

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.5 x 350 3.15 x 350 4.0 x 350	<b>Amperage, A</b> 60-90 80-110 110-150	 <b>DCEP</b>  <b>REDRYING CONDITION:</b> Keep electrodes dry.	All Positions, except vertical Downwards 
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Available in Ivory packing of 10 kg box containing 10 cartons of 1 kg each.