



ALBOND 12 Si

NON FERROUS (Al Alloys)



Aluminium Welding Electrode for joining and repair of 4047 type alloy

CLASSIFICATION : DIN 1732

EL Al Si 12

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

WELDING POSITION :



DCEP

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)

REDRYING CONDITION : Keep electrodes dry.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	Si	Fe	Al
Typical	11.2	0.2	Bal.
Specification	9.0-12.0	0.50 max	Bal.

MECHANICAL PROPERTIES OF ALL WELD METAL :

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

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
2.5 x 350	60-90	1	5	5
3.15 x 350	80-110	1	5	5
4.0 x 350	110-150	1	5	5