



HILCO Aluminil Si12

Stick electrodes - aluminium

AWS A5.3: E 4047

EN ISO 18273: E Al 4047 (AlSi12)

DIN 1732: EL-Al Si 12

Werkstoffnr. 3.2585

Coating type:

Special

Arc voltage: 65V

Current:**Tip colour:**

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Welding positions:**Printing:**

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Aluminil Si 12 is our special coated electrode developed for welding all types of aluminium castings and applications where good colour matching with base materials is important. Typical applications include repair welding, surfacing and construction welding: window frames, aluminium tubes, furniture, aluminium castings, engine blocks, automotive parts. The electrode has a pure white coating specifically designed to reduce moisture pick-up. For thicker plate materials (≥ 15 mm.) it is recommended to preheat at 150°C to 250°C before welding.

Base materials to be welded:

- Aluminium-Si cast alloys up to 12% Si content:
G-AlSi 12 (Cu), G-AlSi 10 Mg (Cu), G-AlSi 6 Cu 4

Applications:

- General fabrication & construction
- Repair & Maintenance

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	AL Si 12	-	AL Si 12	-	AL Si 12

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
	0,10	12,0						0,05			Bal.

Note: Zn 0,10 - Fe 0,40

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Hardness
As welded	≥ 80	≥ 180	≥ 5	50 HB

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	8,8	60-90
3,2	350	13,2	80-110
4,0	350	19,6	110-150