



# CEWELD E AlSi 12

**TYPE** Coated electrode for fast joining of cast aluminum alloys with more than 7% Si (AlSi12, 4047A).

**APPLICATIONS** CEWELD® E AlSi 12 is for joining aluminum alloyed with copper, silicon, and magnesium. Also excellent for joining dissimilar grades of aluminum. For welding broken gear parts and other casting parts, also ideal for cladding or rebuilding wornout parts, Engine blocks, cylinder heads, tanks, containers, frames, lorry tipper.

**PROPERTIES** CEWELD® E AlSi 12 have a very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up. Start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

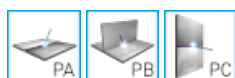
**CLASSIFICATION**

AWS	A 5.3: E 4047
EN ISO	18273: E AlSi12(A)
W.Nr.	3.2585
FM	23

**SUITABLE FOR** **Al 4047A (AlSi12)**  
 Cast Aluminium with more than 7% Silicium,  
**Mat.n:** 3.2211, 3.2315, 3.2371, 3.2373, 3.2381, 3.2383, 3.2581, 3.2583, 3.3206,  
 G-AlSi12, G-AlSi12(Cu), G-AlSi10Mg, G-AlSi10Mg(Cu), G-AlSi9Mg, AlMg1SiCu, AlMg0,5Si, AlMgSi1,  
 G-AlSi5Mg  
**Iso. n:** 6061, 6063, 6082  
 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)]

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

Si	Mn	Ti	Fe	Cu	Zn	Al
12	0.05	0.08	0.15	0.3	0.2	Rem.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	150	250	14	HRc

**REDRYING** 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