



# CEWELD AlSi 12 Tig

**TYPE** Aluminium silicon alloy for welding cast aluminum parts, also suitable as brazing alloy with suitable flux.

**APPLICATIONS** Aluminium alloy for welding and brazing. This material is generally used for brazing aluminium sheets, for extrusions and castings. (After anodizing the weld will be of a different color)

**PROPERTIES** CEWELD® AlSi12 Tig was originally developed as a brazing alloy to take advantage of its low melting point and narrow freezing range. In addition, it has a higher silicon content than AlSi5, which provides increased fluidity and reduced shrinkage. Hot cracking is significantly reduced when using AlSi12 as a filler alloy. The alloy may be used in applications at sustained elevated temperatures. Non-heat treatable. Thicker sections should be preheated (150°C) prior to welding.

**CLASSIFICATION**

AWS	A 5.10: ER4047A
EN ISO	18273: S Al 4047A (AlSi12(A))
W.Nr.	3.2885
F-nr	23

**SUITABLE FOR** G-AlSi10Mg, G-AlSi11 G-AlSi12 (Cu), G-AlSi7Mg, G-AlSi6Cu4 , G-AlSi9Mg, G-AlSi9Cu3, 4145, 3.2581, 3.2583, 3.2381, 3.2383, 3.2373, 3.2163, 3.2371, 3.2151, B 413.0, 361.0, 359.0, 356.0, 319.0, Cast aluminium

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

Si	Mn	Ti	Fe	Cu	Zn	Al	Mg
12	0.1	0.1	0.3	0.2	0.1	Rem.	0.05

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness
As Welded	75	170	12	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** 11, 13



# CEWELD ALSi 12 Tig

ALSI 12 TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663407665
ALSI 12 TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663407658
ALSI 12 TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663407672
ALSI 12 TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663407689
ALSI 12 TIG 4,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663407696
ALSI 12 TIG 5,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663407702