



# CEWELD AlSi 12 Tig

|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                               |                         |                      |        |          |      |      |
|------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|-------------------------|----------------------|--------|----------|------|------|
| TYPE                                           | Aluminium silicon alloy for welding cast aluminum parts, also suitable as brazing alloy with suitable flux.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                               |                         |                      |        |          |      |      |
| ANWENDUNGEN                                    | 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)                                                                                                                                                                                                                                                                                                                                                                                                          |                               |                         |                      |        |          |      |      |
| EIGENSCHAFTEN                                  | 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.                                                                                                       |                               |                         |                      |        |          |      |      |
| KLASSIFIKATION                                 | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | A 5.10: ER4047A               |                         |                      |        |          |      |      |
|                                                | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 18273: S Al 4047A (AlSi12(A)) |                         |                      |        |          |      |      |
|                                                | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 3.2885                        |                         |                      |        |          |      |      |
|                                                | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 23                            |                         |                      |        |          |      |      |
| GEEIGNET FÜR                                   | 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                                                                                                                                                                                                                                                                                                                                                                                         |                               |                         |                      |        |          |      |      |
| ZULASSUNGEN                                    | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                               |                         |                      |        |          |      |      |
| SCHWEISSPOSITIONEN                             |        |                               |                         |                      |        |          |      |      |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | Si                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Mn                            | Ti                      | Fe                   | Cu     | Zn       | Al   | Mg   |
|                                                | 12                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.08                          | 0.05                    | 0.15                 | 0.01   | 0.01     | Rem. | 0.01 |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                               | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |      |      |
|                                                | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                               | 75                      | 140                  | 12     | HRc      |      |      |
| RÜCKTROCKNUNG                                  | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                               |                         |                      |        |          |      |      |
| GAS ACC. EN ISO 14175                          | I1, I3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                               |                         |                      |        |          |      |      |



# 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 |