



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	0.08	0.05	0.15	0.01	0.01	Rem.	0.01			
MECHANICAL PROPERTIES	Heat Treatment		$R_{P0.2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness					
	As Welded		75	140	12	HRc					
REDRYING	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