

## Brand Name & Classification

DIN 1732: EL-AISi 12

### Properties

Electrode with special covering for the welding of aluminium silicon cast alloys . Electrode should be held perpendicular to the work piece and a short arc length maintained. Plates thicker than 10mm and larger work pieces require preheating in the range of 150 – 250<sup>o</sup> c. Since slag residues are corrosive, they must be completely removed from the weld bead. Electrode serves well as consumable in oxyacetylene welding. The covering being hygroscopic, the electrodes must be stored in an absolutely dry location, or re-dried as required.

### Application

AlSi cast alloys up to 12% Si  
Such as G-AISi 12, G-AISi 12 (Cu), G- AISi 10 Mg (Cu), G- AISi 6 Cu 4

### Weld Metal Analysis Typical values

Aluminum: Base

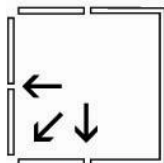
Silicon: 12.00

Iron: 0.40

### Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation
>80 N/MM <sup>2</sup>	180 N/mm <sup>2</sup>	>5 %

### Welding Current & Positions



### Current

Dia	Length	Amperes
2.5	300	60-90
3.2	350	80-110
4.0	350	110-150