

ALUROD AISi12 is a 4047 type aluminum solid TIG welding rod depositing Al-12Si weld metal. Suitable for use with Ar, or Ar+He mixed shielding gases.

ALUROD AISi12 is used for welding of aluminium-silicon alloys with a silicon content higher than 7%. Suitable for long term high temperature applications.

The higher Si-content results in higher fluidity and lower shrinkage in the weld. The hot cracking sensitivity also low and the weld deposit surface is bright.

### Classification

EN ISO	18273: S Al 4047 (AISi12)
AWS	A5.10: ER 4047

### Chemical analysis (Typical values in %)

Al	Si	Mn	Mg	Ti	Fe
Rem	12	0.2	0.35	≤ 0.15	≤ 0.5

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
As Welded	≥ 60	≥ 130	≥ 5

Gas test: 100% Ar

**Shielding Gas** - EN ISO 14175 : I1

### Materials

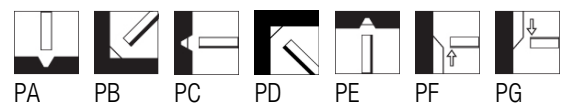
G-AISi11, G-AISi12, G-AISi10Mg(Cu), G-AISi12(Cu), Al-Si-alloys with Si>7%

### Storage

Keep dry and avoid condensation

### Current condition and welding position

AC



### Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
2.0	TUB	5	W000283566
2.4	TUB	5	W000283567
3.2	TUB	5	W000283568
4.0	TUB	5	W000283569