



# Selectarc Al112

Aluminium Electrode with 12% Si

## Classification

AWS A5.3 : E4047  
UNS : A94047

DIN 1732 : EL-AISi12  
Material N° : 3.2585

## Description & Applications

Aluminium electrode with 12%Si for welding and repairing aluminium or aluminium alloy pieces (AlSi, AlCuSiMn, AlSiMg). Specially designed for welding cast or extruded aluminium alloys with Si-levels higher than 7%. Dissimilar joints between aluminium and aluminium alloys.

**Main applications:** Engine blocks, cylinder heads, tanks, containers, frames, lorry tipper.

### Base materials

DIN	Material N°
G-AISi9Mg	3.2373
G-AISi10Mg	3.2381
G-AISi10MgCu	3.2383
G-AISi12	3.2581
G-AISi12Cu	3.2583

## Typical Weld Metal Composition ( % )

Si	Mn	Fe	Al
12	<0.5	<0.5	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0,2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Hardness
80	180	>5	~50 HB

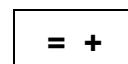
## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x350
Current	( A )	60	90	120

Clean the weld zone; preheat massive pieces (more than 6mm of thickness) to 150-250°C. In order to avoid all risks of porosity, weld with a short arc and guide the electrode at 90° to the piece to be welded. Use a fast travel speed, remove slag between passes and when finished.

**Warning!** Aluminium electrodes are very sensitive to humidity pick-up; therefore keep the opened tins in a dry place. In case of humidity pick-up dry the electrodes 3h/100°C.

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