

ALBOND 12 Si

CLASSIFICATIONS

DIN 1732 EL AlSi 12

IDENTIFICATION: Name Printed

CHARACTERISTICS

It has a very special coating and high melting rate. To avoid burn-through and excessive spattering, keep the arc as short as possible. To obtain light welds without pore formation, section thickness above 8mm should be pre-heated to minimum 200°C. Electrode dia should roughly be equivalent to plate thickness. Slag residues on the weld as well as on the base plate should be removed to obtain non-corrosive weld bead.

TYPICAL APPLICATIONS

Welding and repair of cast aluminium alloys containing more than 7% silicon, • Engine blocks, gear box units, aluminium alloys such as G-AlSi 12, G-AlSi 12 (Cu), G-AlSi 10Mg, G-AlSi 10Mg (Cu)

WELD METAL CHEMISTRY, (%)

Si - 9.0 - 12.0 Al - Remainder
Fe - 0.50 max.

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS MPa	% Elong. (L= 4Xd)
As-welded	180 min	4-8

CURRENT CONDITIONS: DC (+)

4.0	3.2	2.5
110-150	80-110	60-90

WELDING POSITIONS

F & H Fillet

REDRYING CONDITIONS

KEEP DRY - NORMAL

PACKING DATA

Dia., mm	4.0	3.2	2.5
Length, mm	350	350	350
Wt. per carton, kg	1	1	1
Cartons / box	5	5	5
Net wt per box, kg	5	5	5



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

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