

Alcord 12 Si has a special covering for welding aluminium-silicon cast alloys. When welding, hold the electrode at a right angle to the workpiece, with a short arc. Wall thicknesses greater than 10 mm and larger workpieces will require preheating from 150°C to 250°C. Since slag residues are corrosive, they must be completely removed from the weld bead.

Alcord 12Si may be used for oxyacetylene welding. The covering being hygroscopic, electrodes must be stored in an absolutely dry location, or redried if required.

Classification	
DIN	1732: EI-AISI 12

Approvals	Grades

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Zn	Ti	Mg	Fe	Cu	Al
-	-	12	-	-	-	-	-	-	0.40	-	Rem

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	≥ 80	≥ 180	≥ 5	-	-

### Materials

Cast AISi 12 - AISi 12(Cu) - AISi 10 Mg - AISi 10 Mg(Cu) - AISi 6 Cu 4

### Storage and redrying

Keep dry and avoid condensation.

Once opened, store at 90-120 °C until used.

If necessary, Re-dry at 110-120 °C for 2 hours, 5 times max.

### Current condition and welding position

**DC+**



PA PB

### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	60-90	9,1	5,0
3,2	350	80-110	13,3	8,0