

Alufil AISi 12 is a solid wire for the welding of aluminium-silicon alloys with a silicon content >7%.

### Classification

AWS A5.10: ER 4047

### Approvals

### Grades

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

C	Mn	Si	P	S	Cr	Zn	Ti	Mg	Fe	Cu	Al
-	0.20	12	-	-	-	-	≤ 0.15	0.35	≤ 0.50	≤ 0.03	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	≥ 60	≥ 130	≥ 5	-	-

Gas test: Acc. To EN 439: I1(Arcal1)

**Shielding Gas:** Acc. To EN 439: I1(Arcal1)

### Materials

3.2211; 3.2373; 3.2585

G-Al Si 12

### Storage

Keep dry and avoid condensation.

### Current condition and welding position

**DC+**



**Packaging data:** BS300 Kg. 7

Diameters	1,0	1,2	1,6	2,0	2,4	3,2