

Standards:

~DIN EN ISO 18273: E Al 4047 (AlSi 12)
 DIN 1732: EI-AlSi 12
 AWS: E 4047
 Mat.-No.: 3.2585

capilla® 60/12**Product description:**

Special flux coated stick electrode, particularly for welding of aluminium cast alloys.

Applications:

Joint and overlay welding of AlSi-alloys with a maximum amount of 12 % Si (with and without additions of Cu and/or Mg).

Typical weld metal composition:

[wt. - %]

	Si	Al
Min.	11	
Max.	12	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	180	[MPa]
Yield strength $R_{p0,2}$:	80	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	5	[%]
Impact strength (ISO-V):	-	[J]

Positions: all except PG

Redrying: 120°C/2h (store dry)

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	300	40 – 70
3,25	350	60 – 90
4,0	350	80 – 120

Polarity
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also available:
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Capilla Al Si 12 MIG
 Capilla Al Si 12 WIG