

ALUFIL AISi12 is a 4047 type aluminum solid MIG welding wire, supplied precision layer wound, depositing Al-12Si weld metal. Suitable for use with Ar, or Ar+He mixed shielding gases.

ALUFIL AISi12 is used for welding of aluminium-silicon alloys with a silicon content higher than 7%. Suitable for long term high temperature applications.

Due to the Si-alloying the weld pool is readily controllable. The weld metal is not sensitive to cracking and the surface is bright.

Classification

EN ISO	18273: S Al 4047 (AISi12)
AWS	A5.10: ER 4047

Chemical analysis (Typical values in %)

Al	Si	Mn	Mg	Ti	Fe
Rem	12	0.2	0.35	≤ 0.15	≤ 0.5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)
As Welded	≥60	≥130	≥5

Gas test: 70% Ar+30% He

Shielding Gas - EN ISO 14175 : I1, I3

Materials

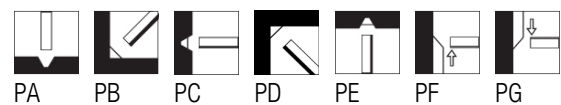
G-AISi11, G-AISi12, G-AISi10Mg(Cu), G-AISi12(Cu), Al-Si-alloys with Si>7%

Storage

Keep dry and avoid condensation.

Current condition and welding position

DC+



Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	7
1.0	W000283189
1.6	W000283191