



ALBOND 12 Si

NON FERROUS (Al Alloys)

KEY FEATURES:

- Aluminium alloy with typical 12% Si
- Special coating to reduce moisture pickup
- Electrode dia. should roughly be equivalent to plate thickness
- Provide high melting rate
- Slag residues should be thoroughly removed to obtain non corrosive weld
- Section thickness above 8 mm should be preheated to min. 200°C
- Deposit of 4047 type alloys

TYPICAL APPLICATIONS:

- Welding and repair of cast Al alloys containing more than 7% Si
- Engine blocks, Gear box units, Automotive parts
- Window frames, Tubes, Furniture
- Al alloys such as G-ALSi 12, G-ALSi 12 (Cu), G-ALSi 10Mg, G-ALSi 10Mg (Cu)


TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

Si	Fe	Al
11.2	0.2	Bal

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	195	5.5
Specification		180 min	4-8

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-90	 DCEP REDRYING CONDITION: Keep electrodes dry.
3.15 x 350	80-110	
4.0 x 350	110-150	

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.