

OK AISi12

Covered electrode suitable for welding of aluminium castings of AISi-, AISiMg- and AISiCu-types. Also possible to use as filler material in gas welding.

Specifications	
Classifications	EN ISO 18273 : AISi12

Welding Current	DC+
Alloy Type	Aluminium-silicon alloy, AISi12
Coating Type	Chloride and Fluoride Salt

Typical Weld Metal Analysis %		
Si	Al	Fe
12.4	87.4	0.2

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.4 x 350.0 mm	50-90 A	23 V	42 %	23 sec	0.54 kg/h
3.2 x 350.0 mm	70-120 A	23 V	45 %	30 sec	0.69 kg/h