

OK AISi12



Covered electrode suitable for welding of aluminium castings of AlSi-, AlSiMg- and AlSiCu-types. Also possible to use as filler material in gas welding.

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| Classifications | EN ISO 18273: AISi12 |
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| Welding Current | DC+ |
| Alloy Type | Aluminium-silicon alloy, AISi12 |
| Coating Type | Chloride and Fluoride Salt |

Typical Wire Composition %

| Si | Al | Fe |
|------|------|-----|
| 12.4 | 87.4 | 0.2 |

Deposition Data

| Diameter | Current | Voltage | kg weld metal/kg electrodes | Number of electrodes/kg weld metal | Fusion time per electrode at 90% I max | Deposition Rate |
|--------------|----------|---------|-----------------------------|------------------------------------|--|-----------------|
| 2.4 x 350 mm | 50-90 A | 23 V | 0.42 | 294 | 23 sec | 0.54 kg/h |
| 3.2 x 350 mm | 70-120 A | 23 V | 0.45 | 176 | 30 sec | 0.69 kg/h |