

Standards :

**Chemical Composition of Welding Rod
% (Typical) :**

TS 6204 EN ISO 18273	: S Al 4047 (AISI 12)
EN ISO 18273	: S Al 4047 (AISI 12)
TS EN ISO 17672	: AI 112
EN ISO 17672	: AI 112
AWS A5.10	: ER 4047

Al	Si	Fe	Mn
rest	12.0	max. 0.5	max. 0.3

Mechanical Properties :

Density (kg/dm ³)	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (L ₀ =5d ₀)(%)	Melting Range (°C)	Hardness (HB)
2.6	80	170	8	575 - 585	45

Features and Applications :

- * AISi12 is aluminum TIG rod with high content of silicon.
- * It is used for joining and filling of aluminum silicon cast alloys including more than 7% silicon.
- * It has a good fluidity. Oxyacetylene welding and brazing is possible with Gekatec F-LH1.
- * It is recommended that preheating to 150°C before welding of plates thicker than 15mm.
- * Shielding gas : Ar

Welding Method :

TIG Welding - Gas Welding

Current Type	Electrode
TIG D.C.(-)	GeKaTec Aluweld 12Si

Welding Positions :



Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Package Weight (Kg)
2.0 x 1000	5/64 x 39"	5
2.4 x 1000	3/32 x 39"	5
3.2 x 1000	1/8 x 39"	5

Approvals :

GOST-R, SEPRO