

BÖHLER S-AI Si 12

Solid wire, Aluminium

Classifications			
EN ISO 18273	AWS A5.10		
S AI 4047A (AISi12(A))	ER4047		

Characteristics and typical fields of application

Is used for aluminium-silicon casting alloy with a Si-content up to 12 %. Good flowing Al-alloy. Not suited for eloxal materials because of discoloration of the weld metal.

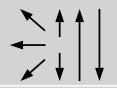
Base materials

G-AlSi12 3.2581 G-AlSi10Mg(Cu) 3.2383 G-AlSi5Mg 3.2373

Typical analysis of solid wire (wt%)					
	Al	Si	Mn	Fe	Cu
wt%	hal.	12.0	< 0.15	< 0.6	< 0.3

Mechanical properties of all-weld metal					
Condition		Yield strength Tensile strength R _m		Elongation A (L ₀ =5d ₀)	
		MPa	MPa	%	
u		≥ 60	≥ 130	≥ 5	
u	untreated, as welded				

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Pol	arity:
DC	(+)

Shielding gases: (EN ISO 14175) I1, I3 **ø (mm)** 1.2

Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm

Approvals

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