



# Alutig Si12

GTAW - TIG  
Aluminium alloys

Date: 2006-10-03  
Revision: 3

## Description:

Aluminium TIG wire containing 12% Si for welding Al/Si and Al7Si/Mg material.  
Melting range 570-585°C.

## Welding current:

AC

## Wire composition, wt.%

	Si	Mn	Cu	Al	Ti	Zn	Mg
Min	11,0						
Typical	12,0	0,01	<0,01	bal.	0,01	0,01	<0,01
Max	13,0	0,30	0,05	bal.	0,05	0,10	0,05

	Fe	Other
Min		
Typical	0,30	0,001
Max	0,50	0,15

## Shielding gas:

I1, Argon 5-10 l/min.

I2, Helium 8-16 l/min.

I3, Argon/Helium 5-10 l/min.

## Stamping

Si12

## Chemical composition, wt.%

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥60 N/mm <sup>2</sup>	80 N/mm <sup>2</sup>
Tensile Strength, Rm:	≥130 N/mm <sup>2</sup>	170 N/mm <sup>2</sup>
Elongation, A5	≥5%	6%

## Classification:

EN ISO 18273

AWS A5.10

S Al 4047 (AlSi12(A))

ER 4047

## Approvals:

## Product data

Diam.mm	Length mm	Product code
1,6	1000	9508-1016
2,0	1000	9508-1020
2,4	1000	9508-1024
3,2	1000	9508-1032
4,0	1000	9508-1040
5,0	1000	9508-1050