

ALCORD 12Si

MMA Electrodes

Aluminum alloys

SAF-FRO

ALCORD 12Si is an electrode with a special coating for welding Al-Si cast alloy, with high silicon content. When welding, hold the electrode at a right angle to the work piece surface and welding direction and keep the arc as short as possible. Wall thicknesses greater than 10 mm and larger work pieces will require preheating from 150°C to 250°C. This MMA electrode is also well suited for oxy-acetylene welding. Slag residues are corrosive and must be completely removed from the weld bead. The coating is highly hygroscopic, consequently electrodes must be stored in an absolutely dry location, or redried if required.

Classification

DIN 1732: EI-AISi 12

Chemical analysis (Typical values in %)

	Al	Si	Fe
All weld metal	Rem	12	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)
As Welded	≥ 80	≥ 180	≥ 5

Materials

G-AISi11, G-AISi12, G-AISi10Mg(Cu), G-AISi12(Cu), Al-Si-Guss mit Si>7%

Storage

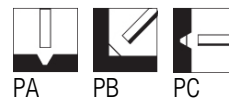
Keep dry and avoid condensation.

Once opened, store at 90-120 °C until used.

If necessary, Re-dry at 110-120°C for 2 hours, 5 times max.

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	TUBM	
				PC	Code
2.5	350	60-90	8.8	227	W000289027
3.2	350	80-110	13.2	152	W000289028