



# Product Data Sheet

E 'Manual metal-arc welding'

# OK AISi12

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## REASON FOR ISSUE

Economy data added.

## GENERAL

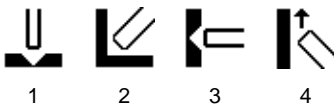
Covered electrode suitable for welding of aluminium castings of AISi-, AISiMg- and AISiCu-types.  
Also possible to use as filler material in gas welding.

**Polarity:** DC+

**Alloy Type:** Aluminium-silicon alloy, AISi12

**Coating Type:** Chloride and Fluoride Salt

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

EN ISO 18273      AISi12

## APPROVALS

Not applicable

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
Si	11.0	13.0
Al	85	89
Fe		0.8

## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.4 x 350	50	90	0.88	31	0.42	294	0.54	23	23	1,2,3,4
3.2 x 350	70	120	1.37	32	0.45	176	0.69	30	23	1,2,3,4

**W** = Weight (kg / 100 electrodes)

**η** = Efficiency (g weld metal x 100 / g core wire)

**N** = Effective value (kg weld metal / kg electrodes)

**B** = Changes (number of electrodes / kg weld metal)

**H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)

**T** = Fusion time at 90% of max current (s / electrode)

**U** = Arc voltage (V)

## OTHER DATA

Redrying: 120 °C, 1h.