



# HILCO ALUMINIL Si12

Stick electrodes – aluminium

EN ISO 18273: E Al 4047 (AlSi12)

Werkstoffnr. 3.2585

## Coating type:

Special

## Current:



## Welding positions:



Aluminil Si12 is our special coated electrode developed for welding all types of aluminium castings and applications where good colour matching with base materials is important. Typical applications include repair welding, surfacing and construction welding: window frames, aluminium tubes, furniture, aluminium castings, engine blocks, and automotive parts. The electrode has a pure white coating specifically designed to reduce moisture pick-up. For thicker plate materials ( $\geq 15$  mm) it is recommended to preheat at 150°C to 250°C before welding.

## Base materials to be welded:

- Aluminium-Si cast alloys up to 12% Si content:  
G-AlSi 12 (Cu), G-AlSi 10 Mg (Cu), G-AlSi 6 Cu 4

## Applications:

- General fabrication & construction
- Repair & Maintenance

## Chemical composition, wt. % weld metal – typical:

Mn	Si	Cu	Zn	Fe	Al
0,10	12	0,05	0,10	0,40	Bal.

## Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %
As welded	80	180	5

## Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	9,2	50-80
3,2	350	13,7	70-120
4,0	350	19,6	110-150