



HILCO AISi12

TIG rods - aluminium

AWS A5.10: ER 4047

EN ISO 18273: S Al 4047A / AISi12(A)

Wire type:

TIG Solid wire

Current:



Shielding gas:

I1-I3

Welding positions:



AISi12 is our aluminium wire for TIG 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. To be used in combination with tungsten electrodes type WP.

Base materials to be welded:

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

Applications:

- General fabrication & construction (aluminium base metals)
- Repair & Maintenance

Chemical composition, wt.% weld metal – typical:

Mn	Si	Fe	Cu	Al
≤ 0,15	12,0	≤ 0,60	≤ 0,30	Bal.

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Physical properties	
As welded	≥ 60	≥ 130	≥ 5	Melting range 573-585°C	Density 2,65 g/cm ³

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5
2,0	1000	5
2,4	1000	5
3,2	1000	5