

DIN EL - AISi 12

MALUMINUM

For welding Aluminum

Applications

MALUMINUM is recommended for joining and building up aluminum and cast aluminum alloys with silicon content up to 12%. It can also be applied for welding dissimilar aluminum alloys.

Characteristics

It is an electrode with special covering for welding aluminum-silicon forged and cast alloys. It is also applicable as a surfacing electrode. It offers good weldability and has no porosity.

Materials of application

It is widely applied in aluminum-silicon cast alloys with silicon content up to 12%, such as G-AISI 12, G-AISI 12 (Cu), G-AISI 10 Mg, G-AISI 10 Mg (Cu) and G-AISI 6 Cu 4.

Typical chemical composition of weld metal (%)

Si	Mn	Al
12	0.2	Balance

Typical mechanical properties of all weld metal: (Single values are typical values)

Tensile Strength (N/mm ²)	0.2 % Proof stress (N/mm ²)	Elongation A ₅ (%)
180	80	5

Size & recommended current range: (=+)

Product name	Order number	Diameter (mm)	Length (mm)	Amp.
MALUMINUM	332555	3.25	350	80-110

Welding Positions



IMPORTANT NOTICE: Redrying is required for 2 hours at 110-120 °C.