magmaweld

EAL 4047

Coated Electrode for Alüminium Alloys -

Standards

TS 9604	EL-AlSi12

Properties and Applications

Electrode with special covering for welding aluminium-silicon cast alloys. In welding, hold electrode perpendicularly to workpiece, with a short arc. Wall thickness greater than 10 mm and larger workpieces will require preheating from 150°C to 250°C. Since slag residues are corrosive, they must be completely removed from the weld bead. Electrode serves well as consumable, in oxyacetylene welding. The covering being hygroscopic, electrodes must be stored in an absolutely dry location, or redried if required.

Materials

DIN	Material
G-AlSi 12	3.2581
G-AlSi 12 (Cu)	3.2583
G-AlSi 10 Mg	3.2381
G-AlSi 10 Mg (Cu)	3.2383
G-AlSi 6 Cu 4	3.2151

Typical Applications

Typical Chemical Values of Weld Metal

Type of Analysis	Si	Al	Cu	Fe
Weld Deposit	12.00	87.00	0.20	0.80

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Elongation A5 (%)
As welded	165	283	7

Application Information

Welding Positions

PA   PB

Polarity:

=+

Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x350	50-80
3.25x350	70-120
4.00x350	110-150

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
14002HYEM2	2.50x350	216 AD	2.12	3	6.50	Tin Box
14002NYEM2	3.25x350	146 AD	2.12	3	6.50	Tin Box
14002QYEM2	4.00x350	102 AD	2.12	3	6.50	Tin Box

Storage & Re-Drying Information

It has to be dried at 120°C for 2 hour.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.

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At Lascentrum, you can nd everything you need regarding products for welding and safety. Lascentrum has been established in 1988 and now imports a complete range of welding consumables, gouging electrodes, gas welding & cutting equipment, welding blankets, safety products and accessories.

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