

OK AISi12



Covered electrode suitable for welding of aluminium castings of AlSi-, AlSiMg- and AlSiCu-types. Also possible to use as filler material in gas welding.

Classifications:	EN ISO 18273:AlSi12
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Welding Current:	DC+
Alloy Type:	Aluminium-silicon alloy, AlSi12
Coating Type:	Chloride and Fluoride Salt

Typical Weld Metal Analysis %

Si	Al	Fe
12.4	87.4	0.2

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.4 x 350 mm	50-90 A	23 V	0.42	294	23 s	0.54 kg/h
3.2 x 350 mm	70-120 A	23 V	0.45	176	30 s	0.69 kg/h