

CLASSIFICATION

ISO 18273 : Al 4047A (AISi12(A)) AWS A5.3 : E4047
DIN 1732 : EL-AISi 12

GENERAL DESCRIPTION

Lsi 12 is an aluminium electrode with 12 % Si. It is particularly used for joining and repair welding of cast aluminium and Si-alloyed aluminium parts. It is also an ideal electrode for the removal of cast defects and for the fill up of cast cavities. It is used only on DC positive pole.

APPROVALS

GOST, SEPRO

APPLICATIONS AND MATERIALS TO BE WELDED

It is an ideal electrode for the welding of 12 % Si containing cast aluminium parts. It should not be used in the welding of aluminium alloys having high magnesium, copper or zinc content.

The special covering removes oxide layer on the surface during welding and enables a stable arc. As the weld pool metal is very fluid, parts should be welded in horizontal position. During welding, electrode should be vertical to the work piece and it should not be oscillated. Arc length should be short. Preheating to 100-300°C should be applied with respect to the thickness of the part to be welded. The slag should be removed completely after welding, since it is corrosive (the slag might be removed with water as the piece cools).

Rolled Aluminium Alloy

DIN 1725-1	W. Nr.	Alloy Nr.
G-AISi 11	3.2211	–
G-AISi 12	3.2581	A413.0
G-AISi 12 (Cu)	3.3583	–
G-AISi 6 Cu 4	3.2151	319.0
G-AISi 7 Mg	3.2371	356.0
G-AISi 9 Mg	3.2373	359.0

Cast Aluminium Alloy

DIN 1725-2	W. Nr.	Alloy Nr.
G-AISi 10 Mg	3.2381	361.0
G-AISi 10 Mg (Cu)	3.2383	–
G-AISi 9 Cu 3	3.2161	–

WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]
2.50	350	60 - 90	980	2.0 / 227
3.25	350	80 - 110	1320	2.0 / 152
4.00	350	100 - 140	1960	2.0 / 102



Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.

Lion International U.K (M.E.) Limited

Monomark House, 27 Old Gloucester Street, London WC1N 3XX, United Kingdom.
T: +44 20 74198760 F: +44 20 78319489 E: info@lionintweld.co.uk

Lion International Middle East FZC

P.O. Box 41654, W/H No. 1K-01/4, Hamriyah Free Zone, Sharjah, UAE.
T: +971 6 5260461 F: +971 6 5260561 E: info.me@lionintweld.co.uk