

**Standards**

TS EN ISO 18273	: S Al 4047 (AISI 12)
EN ISO 18273	: S Al 4047 (AISI 12)
TS EN ISO 17672	: Al 112
EN ISO 17672	: Al 112
AWS A5.10	: ER 4047

**Chemical Composition of  
Welding Wire % (Typical)**

Al	Si	Fe	Mn
rest	12.0	<0.5	<0.3

**Mechanical Properties**

Density (kg/dm <sup>3</sup> )	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)	Melting Range (°C)	Hardness (HB)
2.6	80	170	8	575 - 585	45

**Features and Applications**

- AISI 12 is aluminum TIG rod with high content of Silicon
- It is used for joining and filling of aluminum silicon cast alloys including more than 7% silicon
- It has a good fluidity. Oxyacetylene welding and brazing is possible with GeKaTec F-LH1
- It is recommended that preheating to 150°C before welding of plates thicker than 15mm
- Shielding gas: Ar

**Welding Method**

TIG Welding - Gas Welding

Current Type	Electrode
TIG A.C.	GeKaTec Aluweld 12 Si

**Welding Positions**

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6011100288	2,00 x 1000	5/64 x 39"	5
6011100289	2,40 x 1000	3/32 x 39"	5
6011100290	3,20 x 1000	1/8 x 39"	5

**Approvals:** GOST-R, SEPRO