

Al Si 12 W/R

EN ISO 18273 - S Al 4047A (AlSi12(A))
AWS A5.10: ER/R 4047A

Characteristics: wrought aluminium alloy for filler metals purposes

Description: Al Si 12 is a high silicon alloyed aluminium welding wire for welding Al-Si alloys with more than 7% silicon content. Thanks to its low melting temperature, that minimize parent metal distortions, Al Si 12 is very often used to braze cast aluminium components, wrought alloys, extrusions and sheets. When used with flame torch, it's recommended to use the alloy with our flux KIROBRASAL or KIROBRASAL NEUTRO. This alloy has excellent flow characteristics. Al Si 12 is not recommended when anodising is required.

Application: car industries, refrigeration, heat exchanger, conditioning.

Approvals: CE, VdTÜV, DB, CWB

Chemical composition according to EN ISO 18273 [%]:

	Si	Fe	Cu	Mn	Mg	Cr	Zn	V	Ga	Ti	Zr	Al	Be	other each	other total
min.	11.00	-	-	-	-	-	-	-	-	-	-	rem.	-	-	-
max.	13.00	0.60	0.30	0.15	0.10	-	0.20	-	-	0.15	-	-	0.0003	0.05	0.15

Remark: maximum value unless shown as a range or a minimum.,

Mechanical properties: (as-welded)

min R _m [N/mm ²]	130
R _p 0,2 [N/mm ²]	70
A [%]	13
Solidus [°C]	573
Liquidus [°C]	585

Gas: EN ISO 14175 – I1 (Ar), I3 (Ar-He)

Winding: precision layer wound wire

Polarity: MIG=+ TIG ~

Available sizes:

Wire: diam. 0.80-1.00-1.20-1.60-2.00-2.40-3.17 mm

D100	0,5 kg	plastic spool	
D200	2,0 kg	plastic spool	
D300	7,0 kg	plastic spool	6,0 kg @ d.0.8 mm
BS300	7,0 kg	basket spool	
K415	10 kg	basket ring	
D355	18 kg	plastic spool	
B400	40 kg	basket spool	

Round drum 80 kg – SQUARE173 173 kg

Rods: diam 1.60-2.00-2.40-3.20-4.00-5.00 mm x 1000 mm
10 kg – 5 kg cardboard box

Both wire and rods available in FIDAT boxes or neutral boxes