

International standards	Material No.	3.2585
	DIN 1732	EL-AISi12

Approvals ---

Characteristics Special coated electrode for AISi cast alloy welding.

Welding instructions The welding area has to be thoroughly cleaned, the seam flanks should shine metallic bright. CARBO AISi 12 is easy-to-weld and to de-slag. In order to obtain a dense, non-porous weld, the electrode should be preferably welded in horizontal position, with a short arc and at high speed.
Preheat the welding area of massive work-pieces to 150 – 250° C.
A single layer, without layering, is recommended.

Storage WARNING: Aluminium electrodes are very sensitive to humidity pick-up, since their coating contains hygroscopic salts. Therefore, storage in a dry place is very important. Electrodes which have picked-up humidity must be dried (see „Rebaking“).

Operating temperature ---

Base materials	3.2161 G-AISi8Cu3	3.2383 G-AISi10Mg(Cu)
	3.2211 G-AISi11	3.2581 G-AISi12
	3.2381 G-AISi10Mg	3.2583 G-AISi12(Cu)

Mechanical properties of all-weld metal	Tensile strength	Yield strength	Elongation
	R_m N/mm²	R_{p0,2} N/mm²	A₅ %
(typical values)	200	80	14

Weld metal analysis	Al	Si	Mn	Fe
(typical, wt. %)	Bal.	12	< 0,5	0,5

Current = +

Welding positions PA, PB, PC, PF

Rebaking 1 h, 120 °C +/- 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 350	50 - 80	222	889	9,0	2,0	8,0
3,2 x 350	70 - 100	143	571	14,0	2,0	8,0
4,0 x 350	100 - 130	87	348	23,0	2,0	8,0
5,0 x 350	120 - 150	56	223	35,9	2,0	8,0