

**Wire type:**  
TIG Solid wire

**Current:**



**Welding positions:**



**Shielding gas:**

I1 = Pure Ar

AL Si 12 is our aluminium wire for TIG welding all types of aluminium castings and applications where good colour matching with base materials is important. Typical applications include repair welding, surfacing and construction welding: window frames, aluminium tubes, furniture, aluminium castings, engine blocks, automotive parts. To be used in combination with tungsten electrodes type WP.

**Base materials to be welded:**

- Aluminium-Si cast alloys up to 12% Si content:  
G-AISi 12 (Cu), G-AISi 10 Mg (Cu), G-AISi 6 Cu 4

**Applications:**

- General fabrication & construction (aluminium base metals)
- Repair & Maintenance

**Equivalent product in alternative welding process:**

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
Aluminil Si 12	-	-	-	-	AL Si 12

**Chemical composition, wt.% weld metal – typical:**

C	Mn	Si	S	P	Cr	Mg	Fe	Cu	Ti	Zn	Al
	0,30	12,0									Bal.

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Physical properties	
As welded	≥ 80	≥ 170	≥ 5	Melting range 573-585°C	Density ~2650 kg/m <sup>3</sup>

Note: electrical conductivity 18-22 Sm/mm<sup>2</sup>

**Packaging data:**

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5
2,0	1000	5
2,4	1000	5
3,2	1000	5