

Repair electrode

Classification

ISO 18273-01 : Al 4047A

General description

Coated aluminium electrode for welding cast aluminium-silicon alloys

Also applicable as surfacing electrode

Good weldability, no porosity

Welding positions



ISO/ASME PA/1G PB/2F PF/3G up

Current type

DC electr. +

Chemical composition (w%), typical, all weld metal

Al	Si	Mn
bal.	12	0.1

Mechanical properties, all weld metal

Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	
Typical values	AW	80	180	5

Packaging, available sizes and identification

	Diameter (mm)	2.5	3.2
	Length (mm)	350	350
Unit: Can	Pieces / unit (nominal)	227	152
	Net weight unit (kg)	2.0	2.0

Identification

Imprint:

Tip colour:

RepTec AlSi 12: rev. EN 15

RepTec AISi 12

Materials to be welded

Cast aluminium alloys with silicon up to 12%, such as:

- G-AISI 10 Mg (3.2381)
- G-AISI 12 (3.2581)

Calculation data

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at max. current - (s)*	Energy E(kJ)	Dep.rate H(kg/h)	Weight/ 1000 pcs. (kg)	Electrodes/ kg weldmetal B	kg Electrodes/ kg weldmetal 1/N
2.5 x 350	40 - 70	-	-	-	8.9	8.8	-	-
3.2 x 350	60 - 90	-	32	66	0.7	13.2	164	2.16

* stub end 35mm

Welding parameters, optimum fill passes

Welding positions Diameter (mm)	PA/1G Current (A)	PB/2F	PF/3G up
2.5	60	60	55
3.2	80	80	75

Remarks

Redrying generally speaking not necessary. If required max. 150°C

Application advice

Welding with short arc preferable

Electrode with 90° angle on material

At wall thickness >15 mm preheating 150 - 250°C