

Standards

TS 9604	: EL-AISi 12
AWS A5.3	: E 4047

**Chemical Composition of
Weld Metal % (Typical)**

Si	Al
11.0-13.5	Rest

Mechanical Properties

Tensile Strength (N/mm ²)	Elongation ($L_0=5d_0$) (%)	Hardness (HB)
160 - 200	5 - 10	55 - 60

Features and Applications

- Low-heat-input manual electrode for joining cast aluminium alloys, plus repair and maintenance of sheet aluminium and aluminium casting, including rebuilding, filling cracks, breaks, shrink holes and missing bits
- Excellent welding properties, good arc striking, clean flat flow, dense poreless seams
- Thanks to these characteristics it enables perfect joining on plates up to 2 mm thick

Welding Positions

MIG Wire

GeKa AISi 12

TIG Wire

GeKa AISi 12 TIG

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)	Welding Current (A)	Package Weight kg
6031200025	2.50 x 350 / 3/32 x 14"	70 - 80	2
6031200026	3.20 x 350 / 1/8 x 14"	90 - 100	2
6031200027	4.00 x 350 / 5/32 x 14"	110 - 130	2

Approvals: SEPRO