



## PRODUCT INFORMATION

### SIFTRODE ALU

DIN 1732 EL-AISI12

### DESCRIPTION

Electrode for rapidly joining cast aluminium alloys. Recommended for joining aluminium alloys such as broken gear parts or other casting parts. Ideal for classing or rebuilding parts. Very good weldability with good penetration and porosity free deposit. Unique self-lifting slag and improved coating to protect against moisture pick up.

### WELDING POSITIONS



Welding current: DC+

Suitable welding positions: PA, PB, PC, PE, PF ,PG

### TYPICAL WELD METAL COMPOSITION

Si	12.0 %
Fe	0.50 %
Al	87.5 %

### TYPICAL MECHANICAL PROPERTIES

0.2% Yield Strength	$\geq 80$ N/mm <sup>2</sup>
Ult Tensile Strength	$\geq 170$ N/mm <sup>2</sup>
Elongation	~ 13%
Redrying	110° / 2h

### MATERIAL TO BE WELDED

Suggested base materials: Aluminium alloys with copper, silicon and magnesium - AISi12, AISi12(Cu), AISi11, AISi8Cu3, AlMg3Si

### AVAILABLE FORMATS

ELECTRODE RODS (MMA / SMAW)			
Dia	1.0kg Pkt		Approx Pcs/KG
3.2mm	RE1003201		74

CURRENT RANGE	
Dia (mm)	Amps
3.2	70 – 110

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@wholeweld.co.uk**

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