

OK 96.50

Type Chloride and fluoride salt

SMAW

EL-AISi12

Description

An electrode for welding cast aluminium alloys. Also suitable for welding rolled aluminium alloys or joining them to cast items.

Welding current

DC+



Classifications

DIN 1732

EL-AISi12

Typical all weld metal composition, %

Si	Al	Fe
12.3	87.5	<0.5

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	50-90	22
3.2	350	70-110	22
4.0	350	90-130	22