



# AMERIARC

## Ameri Alu-12

<b>INTERNATIONAL CLASSIFICATIONS</b>	AWS/ASME A 5.3 E 1100	EN 573-3: E Al
	DIN: 1732: EL-Al	

### DESCRIPTION & APPLICATION:

**Ameri Alu-12** is our special 12% silicon aluminum arc welding electrode with exclusive self lifting slag. It contains rapid deposition rate, good penetration characteristics, excellent stability welding and slag control.

Application for arc welding aluminums alloyed with copper, silicon & magnesium. And also suitable for joining dissimilar grades of aluminum.

### WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

Si	Cu	Fe	Ti	Mn	Zn	Be	Al
.091	.05	.45	.01	.005	.002	.0002	Bal.

**Flux Color :** White or Custom Colors

### TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	34,000 psi (250 N/MPa)
Yield Strength	20,000 psi (150 N/MPa)
Elongation	5%

### WELDING CURRENT & INSTRUCTIONS:

**Recommended Current :** DC Reverse (+)

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	50	70	110
Maximum Amperage	80	120	150

### PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
	Length (mm)	14" (350)	14" (350)	14" (350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0