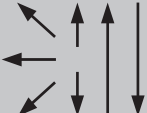


Solid wire, Aluminium

Classifications								
EN ISO 18273-A					AWS A5.10			
S Al 4047A (AlSi12(A))					ER4047			
Characteristics and typical fields of application								
Is used for aluminium-silicium casting alloy with a Si-content up to 12 %. Good mechanical characteristics, an excellent corrosion resistance and a low melting point ensure high quality welding results.								
Base materials								
G-AlSi12, G-AlSi10Mg(Cu), G-AlSi11, G-AlSi5Mg, G-AlSi7Mg, ,G-AlSi6Cu 4, AlMgSi0.8, 3.2581, 3.2383, 3.2373								
Typical analysis of solid wire (wt.-%)								
Al	Si	Fe	Cu	Mg	Ti	Mn	Zn	Be
bal.	11.0 - 13.0	< 0.6	< 0.3	< 0.1	< 0.15	< 0.15	< 0.2	< 0.0003
Mechanical properties of all-weld metal								
Yield strength R _{p0.2}		Tensile strength R _m		Elongation A (L ₀ =5d ₀)		Melting range		
MPa		MPa		%		°C		
60		130		≥ 5		573 - 585		
Operating data								
		Ø (mm) 1.2 1.6		Shielding gas: (EN ISO 14175) I1, I3		Polarity: DC (+)		
Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm								
Approvals								
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