

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	Mn	Mg	Zn	Ti	Be
wt.-%	bal.	11.0 – 13.0	< 0.6	< 0.3	< 0.15	< 0.1	< 0.2	< 0.15	< 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

	Polarity: DC (+)	Shielding gas: (EN ISO 14175) I1, I3	ø (mm) 1.2 1.6
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Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm

Approvals

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