

Classifications

EN ISO 18273	AWS A5.10
S Al 4047A (AlSi12(A))	ER4047

Characteristics and typical fields of application

Rod for GTAW of AlSi cast alloys containing 7-12% Si. The weld metal is not suitable for anodizing for decorative purposes. Very fluid weld pool. Good mechanical properties, excellent corrosion resistance and a low melting point ensure high quality welding results. Thorough cleaning of the work-piece bevels is necessary prior to welding.

Base materials

EN AC-42100 [AlSi7Mg0.3]	G-AlSi7Mg0.3	3.2371
EN AC-43000 [AlSi10Mg(A)]	G-AlSi10Mg	3.2381
EN AC-43200 [AlSi10Mg(Cu)]	G-AlSi10Mg(Cu)	3.2383
EN AC-43300 [AlSi9Mg]	G-AlSi9Mg	3.2373
EN AC-44000 [AlSi11]	G-AlSi11	3.2211
EN AC-44200 [AlSi12(A)]	G-AlSi12	3.2581
EN AC-47000 [AlSi12(Cu)]	G-AlSi12(Cu)	3.2583

and similar.

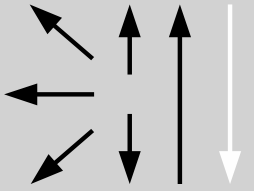
Typical analysis of TIG rod (wt.-%)

Al	Si	Fe	Cu	Mn	Mg	Zn
Bal.	11.0 – 13.0	< 0.6	< 0.3	< 0.15	< 0.1	< 0.2

Mechanical properties of all-weld metal

Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)
MPa	MPa	%
60	130	5

Operating data

	Polarity: AC	Shielding gases: (EN ISO 14175) I1, I3	ø mm
			1.6
			2.0
			2.4
			3.2
4.0			

Approvals

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