

## 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

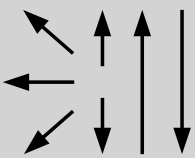
## Typical analysis of welding rod (wt.-%)

|       | 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<br>$R_{p0.2}$ | Tensile strength<br>$R_m$ | Elongation A ( $L_0=5d_0$ ) | Melting range |
|------------------------------|---------------------------|-----------------------------|---------------|
| MPa                          | MPa                       | %                           | °C            |
| 60                           | 130                       | ≥ 5                         | 573 – 585     |

## Operating data

|                                                                                     |                              |                                               |                                           |
|-------------------------------------------------------------------------------------|------------------------------|-----------------------------------------------|-------------------------------------------|
|  | <b>Polarity:</b><br>DC ( + ) | <b>Shielding gas:</b><br>(EN ISO 14175)<br>I1 | <b>ø (mm)</b><br>1.6<br>2.0<br>2.4<br>3.2 |
|-------------------------------------------------------------------------------------|------------------------------|-----------------------------------------------|-------------------------------------------|

Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm

## Approvals

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