

Classifications

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

Characteristics and typical fields of application

Is used for aluminium-silicon casting alloy with a Si-content up to 12 %. Good flowing Al-alloy. Not suited for eloxal materials because of discoloration of the weld metal.

Base materials

G-AlSi12	3.2581
G-AlSi10Mg(Cu)	3.2383
G-AlSi5Mg	3.2373

Typical analysis of solid wire (wt.-%)

	Al	Si	Mn	Fe	Cu
wt.-%	bal.	12.0	< 0.15	< 0.6	< 0.3

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)
	MPa	MPa	%
u	≥ 60	≥ 130	≥ 5
u	untreated, as welded		

Operating data

	Polarity: DC (+)	Shielding gases: (EN ISO 14175) I1, I3	ø (mm) 1.2
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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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