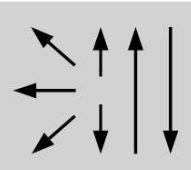


Classifications									
EN ISO 18273-A			AWS A5.10						
S Al 4047A (AlSi12(A))			ER4047						
Characteristics and typical fields of application									
Is used for aluminium-silicium casting alloy with a Si-content up to 12 %. Good mechanical characteristics, an excellent corrosion resistance and 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 $R_{p0.2}$		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			ø (mm) 1.6 2.0 2.4 3.2		
Base material should be cleaned near the seam. Pre-heating 150 °C for plates > 15 mm									
Approvals									
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