

DESCRIPTION

Aluminium wires and rods for welding and brazing. Good mechanical characteristics: its excellent corrosion resistance and low melting point ensure a very low number of deformations in the parent metal. This material is generally used for brazing aluminium sheets, for extrusions and castings (after anodizing the welding will be of a different colour).

AWS A5.10/A5.10M
ER4047A,R4047A

EN ISO 18273
S Al 4047 A / AlSi12(A)

MATERIALS TO BE WELDED

G-Al Si 10 Mg / G-Al Si 11 / G-Al Si 12 (Cu) / G-Al Si 7 Mg / G-Al Si 6 Cu 4
Al Mg Si 0.8 / Al Mg Si 1

(use flux when brazing oxyacetylene)

SHIELDING GASES FOR GMAW/GTAW

I1, I2, I3

MINIMAL VALUES OF THE MECHANICAL PROPERTIES *(welded metal)*

Tensile strenght Rm: 130 N/mm²
Yeld strenght Rp 0,2: 60 N/mm²
Elongation L=5d: 5%

AVAILABLE SIZES*

MIG: 5-6-7 Kg D300 or K300/KS300 spools

Diameter of the wire
1,0 mm - 1,2 mm - 1,6 mm - 2,0 mm - 2,4 mm

TIG carton box of 10 Kg (x 1000 mm length)

Diameter of the rods
1,6 mm - 2,0 mm - 2,4 mm - 3,2 mm - 4,0 mm - 5,0 mm

MINI-MIG: 0,5 Kg D100 spools / 2 Kg D200 spools

Diameter of the wire
1,0 mm - 1,2 mm - 1,6 mm

CHEMICAL COMPOSITION

in%(m/m)^(a)

Al	remainder
Si	11,0 - 13,0
Fe	0,60
Cu	0,30
Mn	0,15
Mg	0,10
Zn	0,20
Ti	0,15
Be	0,0003
	others each 0,05
	others total 0,15

(a) Single values shown in the table are maximum values, unless otherwise noted.

* More diameters and packaging upon request