OK Autrod 4047

OK Autrod 4047 was originally developed as a brazing alloy to take advantage of its low melting point and narrow freezing range. In addition, it has higher silicon content than OK Autrod 4043, which provides an increased fluidity and reduced shrinkage. The alloy produces bright and almost smut free welds. Hot cracking is significantly reduced when using OK Autrod 4047 as a filler alloy. The alloy may be used in applications of sustained elevated temperatures.
Non-heat treatable.

Classifications Wire Electrode:	SFA/AWS A5.10:ER4047, EN ISO 18273:S Al 4047 (AlSi12)
Approvals:	CWB AWS A5.10

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type:	AlSi

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	55 MPa	124 MPa	12 %

Typical Wire Composition %

Mn	Si	Al	Cu	Fe	Zn
0.01	11.5	Rem	0.01	0.18	0.01

Deposition Data

Diameter	Current	Voltage
0.8 mm	60-170 A	13-24 V
0.9 mm	60-170 A	13-24 V
1.0 mm	90-210 A	15-26 V
1.2 mm	140-260 A	20-29 V
1.6 mm	190-350 A	25-30 V