

Standards :

TS 6204 EN ISO 18273 : S Al 4047(AISI12)
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AWS A5.10 : ER-4047

Chemical Composition of Welding Wire
% (Typical) :

Si	Mn	Al	Fe
12.0	<0.15	rest	<0.8

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (Le=5d ₀)(%)	Working Temperature (°C)
80	160	8	573-585

Typical Base Material Grades :

G-AISI 10 Mg, G-AISI 10 Mg(Cu), G-AISI 11, G-AISI 12, G-AISI 6 Cu 4, G-AISI 12(Cu), G-AISI 7 Mg,
G-AISI 9 Mg, G-AMg 3 Si.

Features and Applications :

- * It is used for joining and surfacing of aluminum cast alloys and aluminum alloys includes up to 12 % silicon.
- * Especially in welding of motor blocks, carters, cylinder heads, cast failures, motor valves, pistons, ventilators, pumps, compressors, gear boxes.
- * Required use of Ar, He or Ar+He gas as shielding gas.

Welding Positions :



Current Type :

MIG D.C.(+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Package Weight (Kg)
0.80	0.030"	5
1.00	0.040"	7
1.20	0.047"	7

Approvals :

GOST-R, SEPRO