

| Standard:<br>AWS A5.10<br>ER4047 | Chemical Composition %   |       |                 |                       |                         |         |           |                |             |
|----------------------------------|--|-------|-----------------|-----------------------|-------------------------|---------|-----------|----------------|-------------|
|                                  | Si   | Fe    | Cu              | Mn                    | Mg                      | Zn      | AL        | Other Each     | Other Total |
| Grade<br>ER4047                  | 11 – 13  | ≤ 0.8 | ≤ 0.3           | ≤ 0.15                | ≤ 0.1                   | ≤ 0.2   | Rest      | ≤ 0.05         | ≤ 0.15      |
| Type                             | Spool (MIG)  |       |                 |                       | Tube (TIG)              |         |           |                |             |
| Specification (MM)               | 0.8、0.9、1.0、1.2、1.6、2.0  |       |                 |                       | 1.6、2.0、2.4、3.2、4.0、5.0 |         |           |                |             |
| Package                          | S100/0.5kg<br>S270,S300/6kg-7kg  |       |                 | S200/2kg<br>S360/20kg |                         | 5kg/box | 10kg/box  | length :1000MM |             |
| Mechanical Properties            | Fusion Temperature °C  |       | Electrical IACS | Heat W/m.k            | Tensile Mpa             |         | Yield Mpa | Elongation %   |             |
|                                  | 532 – 571  |       | 40%             | 2.68                  | 130 – 160               |         | 70 – 85   | 6 – 12         |             |
|                                  | Diameter (MM)  |       | 1.2             |                       | 1.6                     |         | 2.0       |                |             |
| MIG Welding                      | Welding Current - A  |       | 180 – 300       |                       | 200 – 400               |         | 240 – 450 |                |             |
|                                  | Welding Voltage- V   |       | 18 – 26         |                       | 20 – 28                 |         | 22 – 32   |                |             |
| TIG Welding                      | Diameter (MM)  |       | 1.6 – 2.4       |                       | 2.4 – 4.0               |         | 4.0 – 5.0 |                |             |
|                                  | Welding Current - A  |       | 150 – 250       |                       | 200 – 320               |         | 220 – 400 |                |             |
| Performance characteristics      | <p>The eutectic Al-Si wire containing 12% Si,which has lower melting point and finer solidification range than ER4043;</p> <p>High silicon content, good fluidity, and reducing the hot cracking tendency to the minimum, increasing the shear strength of the weld;</p> <p>The color after anodizing is gray – black.</p>   |       |                 |                       |                         |         |           |                |             |
| Application                      | <p>It is used in argon arc welding of aluminum, magnesium, copper and cast aluminum (7%Si) ;</p> <p>More widely used in pure aluminum, aluminum manganese, aluminum-silicon magnesium alloy brazing.</p>   |       |                 |                       |                         |         |           |                |             |
| Notice                           | <p>1、The product can be kept for two years under the condition of factory packing and sealed, and the packing can be removed for three months under the usual atmospheric environment.</p> <p>2、Products should be stored in a ventilated, dry and place.</p> <p>3、After the wire is removed from the package, it is recommended that appropriate dust proof cover be applied over the wire.</p> |       |                 |                       |                         |         |           |                |             |