

# ALLOY 4047 | AISi12

## KEY FEATURES

- Lower melting point and narrower freezing range than 4043 wires
- Increased fluidity and reduced shrinkage
- Can be used as a substitute for 4043 wires to increase silicon in the weld metal, minimize hot cracking and produce higher fillet weld shear strength

## ADVANTAGES

- All-position aluminum MIG wire
- Superior wire surface finish for the best feedability and arc performance
- Optimal manufacturing process to precisely control chemical composition
- State-of-the-art testing equipment to ensure trouble-free performance of the weld wire
- Manufactured under a quality system certified to ISO 9001 standard

## TYPICAL APPLICATIONS

- Automotive components
- Body panels
- Brazing of aluminum sheets, extrusions, and castings

## CONFORMS TO

- AWS/ASTM A5.10/A5.10M: 2012
- EN ISO 18273:2004

## SHIELDING GAS

- 100% Argon
- Argon/Helium Mixtures
- Flow Rate: 30 - 50 CFH (14.2 - 23.6 L/min)

## CHEMICAL COMPOSITION

ALUMINUM ASSOCIATION	4047
AWS/ASTM A5.10 /A5.10M: 2012	ER4047 R4047
ISO 18273:2004 Numeral	S Al 4047
ISO 18273:2004 Chemical	AISi12
EN 573-3	EN AW-AISi12(A)

CHEMICAL COMPOSITION (%)		TYPICAL RESULTS
Al	Remainder	Remainder
Si	11.0-13.0	12.0
Fe	≤0.8	0.15
Cu	≤0.30	0.005
Mn	≤0.15	<0.001
Mg	≤0.10	>0.02
Cr	-	≤0.001
Zn	≤0.20	0.005
V	-	-
Ti	-	0.01
Be	≤0.0003	0.0000
Zr	-	-

## PACKAGING

WIRE DIAMETER inches (mm)	PLASTIC SPOOL				BASKET SPOOL	ACCUPAK	ROD DIAMETER inches (mm)	TIG BOX	
	1 LB (0.45 KG)	5 LB (2.26 KG)	16 LB (7.26 KG)	20 LB (9 KG)	15.43 LB (7 KG)	275 LB (125 KG)		10 LB (4.54 KG)	22.05 LB (10 KG)
0.030" (0.8 mm)	✓	✓	✓	✓	✓	✓	1/16" (1.6 mm)	✓	✓
0.035" (0.9 mm)	✓	✓	✓	✓	✓	✓	5/64" (2.0 mm)	✓	✓
0.040" (1.0 mm)	✓	✓	✓	✓	✓	✓	3/32" (2.4 mm)	✓	✓
3/64" (1.2 mm)	✓	✓	✓	✓	✓	✓	1/8" (3.2 mm)	✓	✓
1/16" (1.6 mm)	✓	✓	✓	✓	✓	✓	5/32" (4.0 mm)	✓	✓
							3/16" (4.8mm)	✓	✓

See AccuPak Payoff Accessories Pg.25