OK Autrod 4043

OK Autrod 4043 is one of the most widely used welding and brazing alloys and can be classed as a general purpose filler alloy. The silicon additions result in improved fluidity (wetting action) to make the alloy a preferred choice by welders. The alloy is not sensitive to weld cracking and produces bright and almost smut free welds. Not recommended for anodizing. Non-Heat treatable.

Specifications	
Classifications	SFA/AWS A5.10 : ER4043 EN ISO 18273 : S Al 4043, AlSi5 EN ISO 18273 : S Al 4043A, AlSi5(A)
Approvals	CE : EN 13479 CWB : ER4043 DB : 61.039.05 UKCA : EN 13479 VdTÜV : 12187

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

Alloy Type	AlSi
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	85 MPa (12 ksi)	185 MPa (27 ksi)	18 %

Typical Wire Composition %						
Mn	**Si**	**Al**	**Cu**	**Ti**	**Zn**	**Fe**
0.01	5.00	Rem	0.02	0.01	0.01	0.14

Recommended Welding Parameters		
Wire Diameter	**Current**	**Voltage**
0.8 mm (0.030 in.)	60-170 A	13-24 V
0.8 mm (0.030 in.)	100-130 A	18-22 V
0.8 mm (0.030 in.)	125-150 A	20-24 V
0.9 mm (0.035 in.)	60-170 A	13-24 V
0.9 mm (0.035 in.)	125-150 A	20-24 V
0.9 mm (0.035 in.)	85-120 A	20-23 V
0.9 mm (0.035 in.)	170-190 A	21-26 V
1.0 mm (0.040 in.)	90-290 A	15-26 V
1.2 mm (0.047 in.)	140-260 A	20-29 V
1.2 mm (0.047 in.)	170-240 A	24-28 V
1.2 mm (0.047 in.)	125-150 A	20-24 V
1.2 mm (0.047 in.)	180-210 A	22-26 V
1.2 mm (0.047 in.)	140-300 A	20-29 V
1.6 mm (1/16 in.)	190-350 A	25-30 V
1.6 mm (1/16 in.)	190-260 A	21-26 V
1.6 mm (1/16 in.)	260-310 A	22-27 V
1.6 mm (1/16 in.)	240-300 A	22-27 V
1.6 mm (1/16 in.)	280-320 A	24-28 V
1.6 mm (1/16 in.)	290-340 A	26-30 V
2.0 mm (5/64 in.)	280-400 A	26-31 V
2.4 mm (3/32 in.)	280-400 A	26-31 V
2.4 mm (3/32 in.)	280-360 A	26-30 V

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Recommended Welding Parameters		
Wire Diameter	**Current**	**Voltage**
2.4 mm (3/32 in.)	300-400 A	26-30 V