

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.

Specifications

Classifications	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
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	55 MPa (8 ksi)	124 MPa (18 ksi)	12 %

Typical Wire Composition %

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

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.)	85-120 A	20-23 V
0.9 mm (0.035 in.)	125-150 A	20-24 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.)	180-210 A	22-26 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.)	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.)	240-300 A	22-27 V
1.6 mm (1/16 in.)	260-310 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