

TAL 4047

TIG Welding Wire - Aluminium Alloys

Standards

AWS/ASME SFA - 5.10	ER4047
EN ISO 18273	S Al 4047A (AlSi12(A))
TS 6204 EN ISO 18273	S Al 4047A (AlSi12(A))
DIN M. No.	3.2585

Materials

DIN	Material
G-AlSi 12	3.2581
G-AlSi 12 (Cu)	3.2583
G-AlSi 10 Mg	3.2381
G-AlSi 11	3.2211

Properties and Applications

Aluminium-Silicon alloy filler metal used both for brazing and GTA (TIG) welding of aluminium alloys. Suitable for welding Al-Si and Al-Si-Mg cast aluminium alloys, having silicon content of > 7%. Very good capillary flow in brazing and brazed joints are matching structure and colour of aluminium alloys. Suitable for brazing of rolled and cast aluminium alloys. Excess acetylene flame has to be used during brazing. Widely used in production of kettle, frier, solar heaters. Used in combination with BF14 flux in brazing applications.



Typical Applications



Typical Chemical Features of the Welding Wire

Type of Analysis	Si	Al
Welding Wire	12.00	88.00

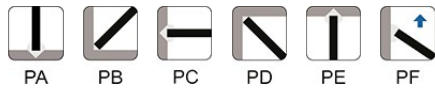
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)
As welded	I1	80	170	5

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
2.00x1000
2.40x1000
3.20x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
24102HAKM2	2.00x1000	3 kg	2.80	4	11.30	Cardboard Tube

24102IAKM2	2.40x1000	3 kg	2.80	4	11.30	Cardboard Tube
24102LAKM2	3.20x1000	3 kg	2.80	4	11.30	Cardboard Tube

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.