

MAL 4047

Gas Metal Arc (MIG) Welding Wire - Aluminium Alloys

Standards

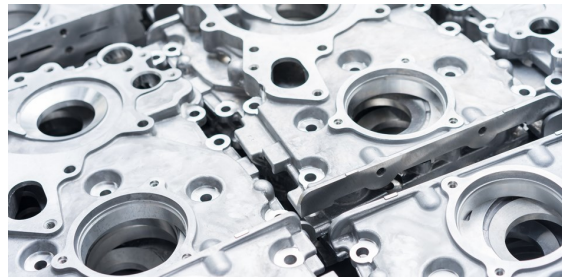
AWS/ASME SFA - 5.10	ER4047
EN ISO 18273	S Al 4047A (AlSi12(A))
TS 6204 EN ISO 18273	S Al 4047A (AlSi12(A))
DIN M. No.	3.2585

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

12% Silicon containing aluminium alloy welding wire, for GMA (MIG) welding of aluminium-silicon (Al-Si) and aluminium-silicon-magnesium (Al-Si-Mg) alloy castings, having a Si content of up to 7% alloying elements.



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	Tensile Strength (N/mm ²)	% 0,2 Yield Strength (N/mm ²)	Elongation A5 (%)
As welded	I1	190	90	6

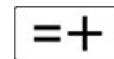
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions



Polarity:



Protection Gas:

I3 I1 I2

Welding Parameters & Efficiency

Diameter (mm)
1.20
1.60

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
24002EHAM2	1.20	6 kg	6.80	1	6.80	Plastic Spool (D300)
24002EJAM5	1.20	7 kg	7.60	1	7.60	Wire Basket Spool (K300MS)

24002GHAM2	1.60	6 kg	6.80	1	6.80	Plastic Spool (D300)
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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.