EAL 4047

Coated Electrode for Alüminium Alloys -

Standards

AWS/ASME SFA - 5.3	E4047
EN ISO 18273	E Al 4047 (AlSi 12)
TS EN ISO 18273	E Al 4047 (AlSi 12)
TS 9604	EL-AlSi12
DIN 1732	EL-AlSi12
DIN M. No.	3.2585

Approvals & Certificates

GOST

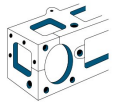
Materials

DIN	Material
G-AlSi 12	3.2581
G-AlSi 12 (Cu)	3.2583
G-AlSi 10 Mg	3.2381
G-AlSi 10 Mg (Cu)	3.2383
G-AlSi 6 Cu 4	3.2151

Properties and Applications

Special coated electrode for aluminium-silicon and aluminium-magnesium-silicon castings. Suitable to use also in aluminium castings, containing up to 12% silicon. Used with DCEP. Hold the electrode perpendicularly to workpiece, with a short arc length, during welding. If the thickness is greater than 10 mm or in large workpieces, preheating shall be applied between 150°C to 250°C. Since slag residues are corrosive, they must be completely removed from the weld bead. Electrode serves well as consumable in oxyacetylene welding. The covering being hygroscopic, electrodes must be stored in an absolutely dry location, or redried if required.

Typical Applications



Typical Chemical Values of Weld Metal

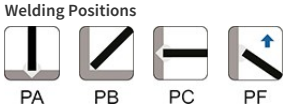
Type of Analysis	Si	Al	Cu	Fe
Weld Deposit	12.00	87.70	0.20	0.30

Typical Mechanical Values of Weld Metal

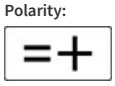
Test Condition	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)
As welded	80	200	8

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
2.50x350	50-80
3.25x350	70-120
4.00x350	110-150

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

14002HYEM2	2.50x350	216 pcs	2.12	3	6.50	Tin Box
14002NYEM2	3.25x350	146 pcs	2.12	3	6.50	Tin Box
14002QYEM2	4.00x350	102 pcs	2.12	3	6.50	Tin Box

Storage & Re-Drying Information

It has to be dried at 120°C for 2 hour.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.