



MIG ALS12

Old reference: MIG AISi12

Classification

AWS A5.10 : ER4047
AMS : 4185

ISO 18273 : S Al 4047 (AISi12)

Description & Applications

Solid wire for GMAW of Aluminium-Silicium alloys with a Silicium content more than 7% and up to 12%. Very similar to a eutectic brazing product (570-585°C), therefore very good flowing and wetting characteristics.

Main applications: For the reparation of foundry pieces or unidentified nuances of aluminium alloys, this is often the case in reparation of agricultural equipments / machinery.

Typical Chemical Composition (%)

	Si	Fe	Cu	Mn	Mg	Zn	Be	O/E	O/T	Al
Min	11.0									
Max	13.0	0.8	0.30	0.15	0.10	0.20	0.0003	0.05	0.15	Rem.
Type	12.0	0.20	0.01	0.01	0.02	0.03	0.0001	<0.05	<0.15	Rem.

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max			
Type	80	140	20

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = + / Pulsed	1.0	100-150	18-22	ISO 14175: I1 (100% Ar) I3 (Ar+ 5-30%He) 15-20L/min
	1.2	130-200	18-25	
	1.6	170-260	20-27	

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Fumes: Consult information on MSDS, available upon request.

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