

Technical data sheet

011121MBA

Aluminium - Solid wire

WA MAL/TAL 4047**CLASSIFICATION**

EN ISO 18273: S AL 4047A (AlSi12(A))
 ASME IIC SFA 5.10 / AWS A 5.10: ER4047 (nearest)
 Material number: 3.2585

DESCRIPTION

- Solid GTAW rod / GMAW aluminium wire with 12% silicon

APPLICATIONS

WA MAL/TAL 4047 are designed for joining aluminium-silicon alloys and Al-Mg-Si alloys with silicon contents exceeding 7 %, with or without copper addition.

Examples

EN	Material number	International designation
G-AlSi12	3.3581	
G-AlSi12(Cu)	3.3583	
G-AlSi11		
G-AlSi10Mg	3.2381	
G-AlSi10Mg(Cu)	3.2383	
G-AlSi9Mg	3.2373	
G-AlSi9Cu3	3.2161	
G-AlSi7Mg	3.2371	
G-AlSi6Cu4	3.2151	
AlMg1SiCu	3.3211	6061
AlMgSi1	3.2315	6082

TYPICAL WIRE ANALYSIS

Si	Cr	Mn	Fe	Al
12.0	0.1	0.2	0.2	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]
180	90	15

SHIELDING GAS

GTAW	EN ISO 14175: I1 (Argon)
GMAW	EN ISO 14175: I1 (Argon), I3 e.g. (Argon + 30% helium)

Preheating at 150-200°C for base metal thicknesses exceeding 15 mm is recommended.

WELDING POSITIONS

GTAW	GMAW

PACKAGING

Welding process	Product type	Diameter x Length
GTAW	Rod	1.6 - 5.0 mm x 1000 mm
GMAW	Wire	0.8 - 2.4 mm

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.