MIG ALS12

Old reference: MIG AlSi12

Classification

ISO 18273 : S Al 4047 (Al Si12) Material N° : 3.2585
AWS A5.10 : ER4047

Description & Applications

Solid wire for GMAW used to weld Aluminium-Silicon alloys with Si content up to 12%. Very similar to a eutectic brazing product (570-585°C), therefore very good flowing and wetting characteristics.

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

Typical Chemical Composition (%)

Si	Fe	Cu	Mn	Mg	Zn	Al
12.0	0.2	0.007	0.01	0.02	0.03	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
80	140	20

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0 1.2 1.6	100-150 130-200 170-280	18-22 18-25 20-27	Ar/He: 18-20 l/min

Ind.10

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