

# AL SAFRA

## Si12/4047

### DESCRIPTION

Aluminium wires and rods for welding and brazing. Good mechanical characteristics: its excellent corrosion resistance and low melting point ensure a very low number of deformations in the parent metal. This material is generally used for brazing aluminium sheets, for extrusions and castings (after anodizing the welding will be of a different colour).

**AWS A5.10/A5.10M**  
ER4047A,R4047A

**EN ISO 18273**  
S Al 4047 A / AlSi12(A)

### MATERIALS TO BE WELDED

G-Al Si 10 Mg / G-Al Si 11 / G-Al Si 12 (Cu) / G-Al Si 7 Mg / G-Al Si 6 Cu 4

Al Mg Si 0.8 / Al Mg Si 1

*(use flux when brazing oxyacetylene)*

### SHIELDING GASES FOR GMAW/GTAW

I1, I2, I3

### MINIMAL VALUES OF THE MECHANICAL PROPERTIES *(welded metal)*

Tensile strenght Rm: 130 N/mm<sup>2</sup>

Yeld strenght Rp 0,2: 60 N/mm<sup>2</sup>

Elongation L=5d: 5%

### CHEMICAL COMPOSITION

in%(m/m)<sup>(a)</sup>

<b>Al</b>	remainder
<b>Si</b>	11,0 - 13,0
<b>Fe</b>	0,60
<b>Cu</b>	0,30
<b>Mn</b>	0,15
<b>Mg</b>	0,10
<b>Zn</b>	0,20
<b>Ti</b>	0,15
<b>Be</b>	0,0003
	others each 0,05
	others total 0,15

*(a) Single values shown in the table are maximum values, unless otherwise noted.*

### AVAILABLE SIZES\*

**MIG: 5-6-7 Kg D300 or K300/KS300 spools**

*Diameter of the wire*

1,0 mm - 1,2 mm - 1,6 mm - 2,0 mm - 2,4 mm

**TIG carton box of 10 Kg (x 1000 mm length)**

*Diameter of the rods*

1,6 mm - 2,0 mm - 2,4 mm - 3,2 mm - 4,0 mm - 5,0 mm

**MINI-MIG: 0,5 Kg D100 spools / 2 Kg D200 spools**

*Diameter of the wire*

1,0 mm - 1,2 mm - 1,6 mm

\* More diameters and packaging upon request