

OK Autrod 4043

OK Autrod 4043 is one of the most widely used welding and brazing alloys and can be classed as a general purpose filler alloy. The silicon additions result in improved fluidity (wetting action) to make the alloy a preferred choice by welders. The alloy is not sensitive to weld cracking and produces bright and almost smut free welds. Not recommended for anodizing. Non-Heat treatable.

Specifications	
Classifications	SFA/AWS A5.10 : ER4043 EN ISO 18273 : S Al 4043 (AlSi5) JIS Z 3232 : A4043
Approvals	CE : EN 13479 CWB : ER4043 DB : 61.039.05 JIS : JIS Z 3232 VdTÜV : 12187

Alloy Type	AlSi
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Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	55 MPa	124 MPa	18 %

Typical Wire Composition %						
Mn	Si	Al	Cu	Ti	Zn	Fe
0.01	5.00	Rem	0.02	0.01	0.01	0.14

Recommended Welding Parameters		
Current	Wire Diameter	Voltage
60-170 A	0.8 mm	13-24 V
100-130 A	0.8 mm	18-22 V
125-150 A	0.8 mm	20-24 V
60-170 A	0.9 mm	13-24 V
125-150 A	0.9 mm	20-24 V
85-120 A	0.9 mm	20-23 V
170-190 A	0.9 mm	21-26 V
90-210 A	1.0 mm	15-26 V
140-260 A	1.2 mm	20-29 V
125-150 A	1.2 mm	20-24 V
170-240 A	1.2 mm	24-28 V
180-210 A	1.2 mm	22-26 V
190-350 A	1.6 mm	25-30 V
190-260 A	1.6 mm	21-26 V
260-310 A	1.6 mm	22-27 V
240-300 A	1.6 mm	22-27 V
280-320 A	1.6 mm	24-28 V
290-340 A	1.6 mm	26-30 V
280-400 A	2.0 mm	26-31 V
280-400 A	2.4 mm	26-31 V
280-360 A	2.4 mm	26-30 V
300-400 A	2.4 mm	26-30 V