OK Autrod 4047

OK Autrod 4047 was originally developed as a brazing alloy to take advantage of its low melting point and narrow freezing range. In addition, it has higher silicon content than OK Autrod 4043, which provides an increased fluidity and reduced shrinkage. The alloy produces bright and almost smut free welds. Hot cracking is significantly reduced when using OK Autrod 4047 as a filler alloy. The alloy may be used in applications of sustained elevated temperatures. Non-Heat treatable.

Specifications	
Classifications	SFA/AWS A5.10 : ER4047 EN ISO 18273 : S Al 4047 (AlSi12)
Approvals	CWB : AWS A5.10

Alloy Type	AlSi

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	55 MPa	124 MPa	12 %

Typical Wire Composition %					
Mn	**Si**	**Al**	**Cu**	**Zn**	**Fe**
0.01	11.5	Rem	0.01	0.01	0.18

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
85-120 A	0.9 mm	20-23 V
125-150 A	0.9 mm	20-24 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
170-240 A	1.2 mm	24-28 V
180-210 A	1.2 mm	22-26 V
125-150 A	1.2 mm	20-24 V
190-350 A	1.6 mm	25-30 V
190-260 A	1.6 mm	21-26 V
240-300 A	1.6 mm	22-27 V
260-310 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

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