

AS MIG AISi12 / AS TIG AISi12



MIG Wire and TIG Rod for Welding of Aluminium Alloys

Classification

AWS A5.10 : ER4047
ISO 18273 : S Al 4047A / AISi12(Al)

General Description

Solid wire and rod for welding of cast aluminium alloys containing up to 12% silicium.

Chemical Composition (w%), Typical, Wire

Si	Mn	Fe	Cu	Zn	Ti	Al
11.5 - 12.5	< 0.15	< 0.50	< 0.30	< 0.20	< 0.01	kalan

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 80 N/mm ²	Melting Range	: 575 - 585 °C
Tensile Strength	: 180 N/mm ²	Density	: 2.65 gr/cm ³
Elongation (L=5d)	: 5 %		

Shielding Gases (acc. ISO 14175 and EN 439)

MIG : I1 - Ar (%100)
TIG : I1 - Ar (%100)

Materials to be Welded

	DIN 1725-1	DIN 1725-2	Mat. Nr.	Alloy Nr.
Aluminium Cast Alloys		G-AISI 12	3.3581	A413.0
		G-AISI 12 (Cu)	3.3583	
		G-AISI 10 Mg	3.2381	361.0
		G-AISI 10 Mg (Cu)	3.2383	
		G-AISI 9 Mg	3.2373	359.0
		G-AISI 9 Cu 3	3.2161	
		G-AISI 7 Mg	3.2171	356.0
		G-AISI 6 Cu 4	3.2151	319.0

Packaging and Available Sizes

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	4.0	Spool/Tube Weight
MIG Wire	-	X	X	-	-	-	-	-	7 kg
TIG Rod	-	-	-	-	X	-	X	-	5 kg

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance. **Fumes** : Consult information on Welding Safety Sheet, available upon request.