LNM AlSi12

CLASSIFICATION

AWS A5.10/5.10M - ER4047
ISO 18273 - S Al 4047A (AlSi12)
EN 573.3 - EN AW-AlSi12
AA - 4047
Werkstoff Nr. - 3.2585

GENERAL DESCRIPTION

Lower melting point and higher fluidity than 4043 wires
Can be used as a substitute for 4043 to increase silicon content in the weld metal and minimize hot cracking and produce higher fillet weld shear strength
Can be used as a brazing alloy

WELDING POSITIONS

ISO/ASME

PA/1G PB/2F PC/2G PD/4F PE/4G PF/3G up

SHIELDING GASES (ACC. ISO 14175)

I1 : Inert gas Ar (100%)
Flow Rate : 14.2 - 23.6 L/min

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

Al	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Be
bal.	11-13	max. 0.6	max. 0.30	max. 0.15	0.10	0	max. 0.20	max. 0.15	max. 0.0003

Notes : Unspecified elements should not exceed a total of 0.15%

MECHANICAL PROPERTIES. TYPICAL. ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)
Typical values	I1	AW	60-80	130-190	5-20

PHYSICAL PROPERTIES

Melting range : 573 - 585°C
Density : approximately 2680 kg/m^3

MATERIAL TO BE WELDED

Refer to “Filler Metal Guide for Aluminium”

APPLICATIONS

For welding 6XXX alloys. and most casting alloys
Automotive components , radiators and air conditionning

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2	1.6
Unit : 7.0 kg spool B300	X	X	X

Other sizes and packaging on request

LNM AlSi12: rev. EN 22

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