ALMIGWELD 4047

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

Specifications	
Classifications	AMS 4185 : (Chemistry Only) ANSI/AWS A5.10 : (ER & R)
Approvals	CWB

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Aluminum

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

Recommended Welding Parameters		
Current	**Wire Diameter**	**Voltage**
60-170 A	0.8 mm (0.030 in.)	13-24 V
100-130 A	0.8 mm (0.030 in.)	18-22 V
125-150 A	0.8 mm (0.030 in.)	20-24 V
60-170 A	0.9 mm (0.035 in.)	13-24 V
85-120 A	0.9 mm (0.035 in.)	20-23 V
125-150 A	0.9 mm (0.035 in.)	20-24 V
170-190 A	0.9 mm (0.035 in.)	21-26 V
140-260 A	1.2 mm (0.047 in.)	20-29 V
180-210 A	1.2 mm (0.047 in.)	22-26 V
170-240 A	1.2 mm (0.047 in.)	24-28 V
125-150 A	1.2 mm (0.047 in.)	20-24 V
140-300 A	1.2 mm (0.047 in.)	20-29 V
190-350 A	1.6 mm (1/16 in.)	25-30 V
190-260 A	1.6 mm (1/16 in.)	21-26 V
240-300 A	1.6 mm (1/16 in.)	22-27 V
260-310 A	1.6 mm (1/16 in.)	22-27 V
280-320 A	1.6 mm (1/16 in.)	24-28 V
290-340 A	1.6 mm (1/16 in.)	26-30 V
280-400 A	2.4 mm (3/32 in.)	26-31 V
280-360 A	2.4 mm (3/32 in.)	26-30 V
300-400 A	2.4 mm (3/32 in.)	26-32 V