

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 (AISI5)
Approvals	CE : EN 13479 CWB : ER4043 DB : 61.039.05 VdTÜV : 12187

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

Alloy Type	AlSi
Shielding Gas	I1, I3 (EN ISO 14175)

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
90-275 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
125-150 A	1.2 mm	20-24 V
180-210 A	1.2 mm	22-26 V
140-300 A	1.2 mm	20-29 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