

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.

Specifiche

Classificazioni	SFA/AWS A5.10 : ER4047 EN ISO 18273 : S Al 4047 (AlSi12)
Omologazioni	CWB : AWS A5.10

Le approvazioni si basano sulla posizione della fabbrica. Si prega di contattare ESAB per ulteriori informazioni.

Tipo di lega	AlSi
Gas di protezione	I1, I3 (EN ISO 14175)

Proprietà tensili tipiche

Stato	Resistenza allo snervamento	Resistenza alla trazione	Allungamento
Come saldato	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

Parametri di saldatura

Amp	Diametro del filo	Volt
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
90-275 A	1.0 mm	15-26 V
140-260 A	1.2 mm	20-29 V
180-210 A	1.2 mm	22-26 V
170-240 A	1.2 mm	24-28 V
125-150 A	1.2 mm	20-24 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
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