

OK Autrod 4008

Alloy 4008 has controlled lower levels of impurities than those present in alloys 4010 and 356.0. It is a product that meets the chemistry requirements of AMS 4181. Alloys 356.0, A356.0 and A357.0 are typically used to manufacture sand and permanent mold castings. Alloy 4008 is excellent choice to join or repair these castings, and if needed, it can be heat treated to increased mechanical properties.

Specifications

Classifications	EN ISO 18273 : S Al Z (AlSi7MgTi)
Approvals	CE : EN 13479 DB : 61.039.09 VdTÜV : 12189

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	55 MPa (8 ksi)	165 MPa (24 ksi)	18 %

Typical Wire Composition %

Mn	Si	Al	Cu	Ti	Zn	Fe	Mg
0.01	7.0	Rem	0.02	0.1	0.01	0.06	0.4

Recommended Welding Parameters

Current	Wire Diameter	Voltage
90-275 A	1.6 mm (1/16 in.)	15-26 V
90-275 A	2.0 mm (5/64 in.)	15-26 V