



Changzhou Giant Welding Co.,Ltd
www.giantweld.com

Standard: AWS A5.10 ER4047	Chemical Composition %								
	Si	Fe	Cu	Mn	Mg	Zn	AL	Other Each	Other Total
Grade ER4047	11 – 13	≤ 0.8	≤ 0.3	≤ 0.15	≤ 0.1	≤ 0.2	Rest	≤ 0.05	≤ 0.15
Type	Spool (MIG)					Tube (TIG)			
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0					1.6、2.0、2.4、3.2、4.0、5.0			
Package	S100/0.5kg S270,S300/6kg-7kg					S200/2kg S360/20kg	5kg/box	10kg/box	length :1000MM
Mechanical Properties	Fusion Temperature ℃		Electrical IACS	Heat W/m.k		Tensile Mpa		Yield Mpa	Elongation %
	532 – 571		40%	2.68		130 – 160		70 – 85	6 – 12
	Diameter (MM)		1.2		1.6			2.0	
MIG Welding	Welding Current - A		180 – 300		200 – 400			240 – 450	
	Welding Voltage- V		18 – 26		20 – 28			22 – 32	
TIG Welding	Diameter (MM)		1.6 – 2.4		2.4 – 4.0			4.0 – 5.0	
	Welding Current - A		150 – 250		200 – 320			220 – 400	
Performance characteristics	The eutectic Al-Si wire containing 12% Si,which has lower melting point and finer solidification range than ER4043;								
	High silicon content, good fluidity, and reducing the hot cracking tendency to the minimum, increasing the shear strength of the weld;								
	The color after anodizing is gray – black.								
Application	It is used in argon arc welding of aluminum, magnesium, copper and cast aluminum (7%Si) ;								
	More widely used in pure aluminum, aluminum manganese, aluminum-silicon magnesium alloy brazing.								
Notice	1、The product can be kept for two years under the condition of factory packing and sealed, and the packing can be removed for three months under the usual atmospheric environment.								
	2、Products should be stored in a ventilated, dry and place.								
	3、After the wire is removed from the package, it is recommended that appropriate dust proof cover be applied over the wire.								

