

❖ Product Description

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| I. An 12%Si Al all position weld wire | IV. Improved wetting action yielding a less crack sensitive bright weld bead Most widely used general purpose filler wire |
| II. Smooth wire feedability with efficient welding | V. Radiographic weld quality |
| III. Narrow melting range which reduces shrinkage during cooling | |

❖ Range of Application

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|-------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------|
| I. For welding heat treatable alloys such as 6XXX base metals and cast alloys | II. Good for common welding applications such as bicycles, trucks, trailers, automotive parts and equipment |
| | III. For ship building and mobile machinery |

❖ Classification

- AWS/SFA 5.10 ER4047

❖ Chemical Composition

Type of Wire		Si	Fe	Mn	Mg	Zn	Al	Cu	Be	Other Each	Other Total
ER4047	Min	13.0	-	-	-	-	-	-	-	-	-
	Max	11.0	0.8	0.15	0.10	0.20	Bal	0.3	0.0003	0.05	0.15

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
-	200	-	-	-

❖ Wire Size & Welding Position

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|------------------------------------------------------------|-------------------------------|
| • Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60 | • Weld Position- All position |
|------------------------------------------------------------|-------------------------------|

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Size Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60			
Packing Code	A	B	C	D
Packing Available	SD 100	SD200	SD270	SD 300
Net Weight of Wire	0.5KG	1KG	7KG	7KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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