



# SAFRA Al.Si.12/ER 4047

A.W.S./ASTM A5.10:  
ER 4047

DIN EN ISO 18273:  
S Al 4047 A - Al Si 12 A

## DESCRIPTION

Aluminium wires and rods for welding and brazing.

Good mechanical characteristics: its excellent corrosion resistance and low melting point ensure a very low number of deformations in the parent metal. This material is generally used for brazing aluminium sheets, for extrusions and castings.

(After anodizing the welding will be of a different colour).

## CHEMICAL COMPOSITION

Al	remainder
Si	11,0 - 13,0
Fe	<0,60
Cu	<0,30
Mn	<0,15
Mg	<0,10
Zn	<0,20
Ti	<0,15
Be	<0,0003

## MATERIALS TO BE WELDED

G-Al Si 10 Mg | G-Al Si 11 | G-Al Si 12 (Cu) | G-Al Si 7 Mg | G-Al Si 6 Cu 4 | Al Mg Si 0.8 | Al Mg Si 1

(use flux when brazing oxyacetylene).

## SHIELDING GASES FOR GMAW/GTAW

Ar 99,99% min.

## MINIMAL VALUES OF THE MECHANICAL PROPERTIES (WELDED METAL)

Tensile strenght Rm:	130 N/mm <sup>2</sup>
Yeld strenght Rp 0,2:	60 N/mm <sup>2</sup>
Elongation L=5d:	5%
Melting range:	573-585°C

## AVAILABLE SIZES

MIG: 6-7 Kg D300 or K300/KS300 Spools

TIG carton box of 10 kg  
(x 1000 mm length)

## DIAMETER OF THE WIRE

0,8 mm - 1,0 mm - 1,2 mm - 1,6 mm - 2,0 mm - 2,4 mm

## DIAMETER OF THE RODS

1,6 mm-2,0 mm-2,4 mm-3,2 mm-4,0 mm-5,0 mm

OTHERS EACH <0,05

OTHERS TOTAL <0,15

MORE DIAMETERS AND PACKAGING UPON REQUEST