

## ER4043

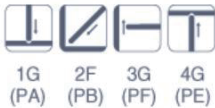
AWS A5.10 ER4043

EN ISO 18273 S Al 4043 (AlSi5)

### Description:

An Al-Si alloy welding wire can use where base metal require thermal treatment, mainly 6xxx series alloys. Higher silicon improve fluidity, make it become preferred choices of welders. This product is not sensitive to weld crack, it also can be used on weld forge and casting materials. Welding for 6xxx series alloys.

### Welding Position:



### Diameters:

0,8mm, 0,9mm, 1,0mm, 1,2mm, 1,6mm.

### Typical Mechanical Properties:

Tensile strength(MPa):	168
Yield strength(MPa):	60
Elongation(%):	19
Impact values( $\geq 47$ )/+20°C):	--

### Typical Chemical Compositon:

Si	Fe	Cu	Mn	Mg
4,7-5,3	0,3	0,05	0,04	0,04
Cr	Zn	Be	Ti	Al
0,05	0,05	0,0002	0,005	Allowance

### Welding Current:(AC)

Dia:(mm)	0,8	0,9	1,0	1,2	1,6
Current/A	60-170	60-170	90-210	140-260	190-350
Voltage/V	13-24	13-24	15-26	20-29	25-30

Note:

- 1.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
2. Shield Gas:100%Ar or 75%Ar+25%He or 50%Ar+50%He
3. In order to get good welding bead, weld on thick plate should be preheat 100-200°C before welding.
- 4. Tig rods ER4043 1.6mm, 2.0mm, 2.4mm, 3.2mm available**