

PRODUCT DATA SHEET

Afrox Filmax 4047 Afrox TIG 4047



Afrox Filmax 4047 and Afrox TIG 4047 are 11-13% silicon wires, which have a lower melting point and higher fluidity than ER4043 type wires. Used as a substitute for an ER4043 type wire to increase silicon in the weld metal, minimise hot cracking and produce slightly higher fillet weld shear strength. Also suitable for sustained elevated temperature service, i.e. above 65°C. Afrox Filmax 4047 is suitable for spray arc and pulsed arc transfer using high purity argon on thin sections or an argon/helium mixture (Alushield®) on thicker sections. Flow rates of 15-20 l/min should be used. Afrox TIG 4047 should

be used with a zirconiated tungsten electrode with pure argon or an argon/helium mixture (Alushield®) for thick sections, at flow rates of 15-20 l/min. With oxy-acetylene brazing, aluminium brazing flux (Item Numbers W001753 and W001755) should be used.

Applications

For welding, but normally for brazing aluminium sheets, for extrusions and castings. Also for automotive components, body panels, heat exchangers, etc.

Classifications

AWS	A5.10	ER4047
EN	18273	Al 4047 (AlSi12)

Typical Chemical Analysis (Wire analysis)

% Silicon	11,0 - 13,0	% Zinc	0,1 max
% Iron	0,5 max	% Titanium	0,15 max
% Copper	0,05 max	% Beryllium	0,0008 max
% Manganese	0,15 max	% Aluminium	Bal.
% Magnesium	0,05 max	(After anodizing, welding will be of a different colour)	

Typical Mechanical Properties (All weld metal in the as welded condition)

0,2% Proof Stress	60 MPa
Tensile Strength	130 MPa
% Elongation on 5d	5
% Melting Range	573 - 585°C

Packing Data

MIG			TIG			
Diameter (mm)	Pack Mass (kg)	Item Number	Diameter (mm)	Pack Mass (kg)	Consumable Length (mm)	Item Number
1,0	7,0	W077524	1,6	2,0	1 000	W000850
1,2	7,0	W077525	2,0	2,0	1 000	W077518
1,6	7,0	W077526	2,4	2,0	1 000	W030519
-	-	-	3,2	2,0	1 000	W000851

Recommended shielding gases: Argon or Alushield®

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance therein. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02
E-mail: customer.service@afrox.linde.com Website: www.afrox.com

