

VBC Alloy 0031 4047 Aluminium

Designation and Description	GTAW and GMAW Solid Welding Wire Aluminium Base		Issued: Mar/2014	MSRR: 9500/31	AMS: 4185E
			Revision: 01		
Cross Reference/ Conformance Specification	MSRR 9500/31 AMS 4185 BS 2901-4:1990 4047A CLASS FS-BAI Si 4	718AC N2 (NG2) B Al-2 FED-QQ-B 655	BS EN ISO 18273:2004 AISi12 4047 4047A AWS A5.10/A5.10M:1999 ER 4047 R4047 UNS Number A94047 AA4047 AWS A5.10.92, R4047		
Metallurgical Background Information	4047 is a solid welding wire produced conventionally and the surface cleaned to remove standard metal working lubricants. 4047 is an Al-12Si alloy with a single melting point, eutectic composition.				
Materials To Be Welded, Applications and Advice	L159, L155, LM2, LM6, LM9, LM20 Also used for gas brazing applications. 1xxx, 3xxx, 6xxx, series alloys 2014, 2219, 5005, 5050, 5052, 705, 7039. Al-Si and Al-Si-Mg casting alloys and combinations to wrought alloys as listed above.				
Wire Chemistry WT% (as per AMS)	Silicon – 11.0-13.0%		Zinc – 0.20% max		
	Iron – 0.8%max		Beryllium – 0.0003%		
	Copper – 0.30% max		Other Elements (each) – 0.05%		
	Manganese – 0.15% max		Other Elements (total) – 0.15%		
	Magnesium – 0.10% max		Aluminium - Balance		
Weld Properties	Melting range (approx.) 576°C - 582°C (Eutectic point) Density 2.66gm/cc				
Sizes and Forms of Supply	Straight Length: 2.5 kg Packs 36" / 914mm lengths Flag tagged (Double tagging and other lengths on request)		Spooled Wire: Precision layer wound and with controlled cast and helix 300mm diameter standard		

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