

# GM 4047

## IDENTIFICATION

GM 4047, ER4047

## CLASSIFICATION

AWS/SFA 5.10: ER4047

## DESCRIPTION

GM 4047 is a premium quality Aluminum- nominal 12% Silicon alloy suitable for the Mig Welding (GMAW) of a wide range of cast and wrought Aluminum alloys. GM 4047 is used extensively for the repair welding of many aluminum alloy castings. It's lower weld deposit strength, and excellent crack resistance make it suitable for the Mig welding of cast (mainly 4XX & 6XX series) and wrought (selected 1XXX, 5XXX & 6XXX series) aluminum alloys, except where an accurate colour match is required after anodising.

## CHEMICAL ANALYSIS (RANGE) %

Si	Fe	Mn	Mg	Zn	Cu	Al
11.0 - 13.0	0.80 max	0.15 max	0.10 max	0.20 max	0.30 max	balance

## TYPICAL APPLICATIONS

Suitable for Gas MIG Welding applications of cast mainly (4XX & 6XX series) alloys and wrought (selected 1XXX, 5XXX & 6XXX series) aluminum alloys, except where an accurate colour match is required after anodizing.

## STORAGE AND HANDLING RECOMMENDATIONS

- Store in a heated room with uniform temperature control and, if possible, with humidity control as well.
- Store unpackaged wires for long periods in a heated cabinet at 10-15°C above ambient temperature.
- Hold GM 4047 wire in the welding area for 24 hours before unpacking to allow its temperature to equalise with that of the surrounding area.
- Use dust covers on open wire feed units to protect wire during welding.

**APPROXIMATELY MELTING RANGE :** 577 - 582°C

**SHIELDING GAS :** Welding Grade Argon (High Pure Argon)

## PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
1	7
1.2	7
1.6	7
2	7