

OK Autrod 4043

GMAW
ER4043

Description

OK Autrod 4043 is one of the most widely used welding and brazing alloys and can be classified as a general-purpose filler alloy. The silicon addition results in improved fluidity (wetting action), making the alloy the preferred choice of welders. The alloy is not sensitive to weld cracking and produces bright, almost smut-free welds. Not recommended for anodising. Non-heat treatable.

Welding current

DC(+)

Classifications

SFA/AWS A5.10	ER4043
EN ISO 18273	S Al 4043 (AISI5)
EN ISO 18273	S Al 4043A (AISI5(A))

Wire composition

Si	Mn	Cr	Cu	Ti	Zn	Fe
5.0	<0.05	<0.05	<0.05	<0.15	0.10	<0.6

Typical mech. properties all weld metal

Yield stress, MPa	55
Tensile strength, MPa	165
Elongation, %	18

Approvals

CWB	AWS A5.10 (Item number ending with A)
DB	61.039.05
Ü	61.039

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.8	5-13	60-170	13-24	0.4-1.1
0.9	5-13	60-170	13-24	0.5-1.3
1.0	7-14	90-210	15-26	0.9-1.8
1.2	6-13	140-260	20-29	1.1-2.4
1.6	4.5-7.5	190-350	25-30	1.5-2.5
2.4	3.5-5	280-400	26-31	2.5-3.7

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