

#### DESCRIPTION

Executive 4047 is a good general-purpose aluminum welding alloy. Originally designed as a brazing alloy Executive 4047 boast low freezing temperatures. The low freezing range reduces shrinkage in the weld during cooling.

Executive 4047 has a high silicon level that improves wetting out and gives a less crack sensitive weld.

Executive aluminum wire is non-annealed which allows for smoother feedability especially when utilizing long MIG guns.

Our enhanced feedability design uses less lubricant than standard aluminum wire resulting in considerably less fume generation.

#### APPLICATIONS & FEATURES

Executive 4047 is the exceptionally smooth welds that are cosmetically appealing making it suitable for automotive components, heat exchangers, body panels and brazing of aluminum sheets, extrusions and castings.

#### TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

Si	Fe	Cu	Mn	Mg	Sr	Zn	Ti	Be	Al	TOE
11.5	0.10	<0.001	<0.01	0.002	0.028	<0.01	0.016	<0.0001	Rem	<0.15

<b>Tensile Strength:</b>	18,900 PSI min	<b>Elongation:</b>	5-12%
<b>Yield Strength:</b>	8,700 PSI min		

#### TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
<b>GMAW</b>	.035"	23-25	90-170		
	.047"	25-27	110-220	30 to 50 CFH	100% Ar
	.062"	26-30	200-300		
<b>GTAW</b>	.093"	Direct Current; Electrode -		20 to 30 CFH	100% Ar
	.125"				

#### STANDARD PACKAGING

<b>GMAW (MIG)</b>	16-lb / 20-lb wire spools	1,536-lb / 1,920-lb pallet	300-lb / 500-lb drums
	1-lb plastic spools	20-lb box	
<b>GTAW (TIG)</b>	10-lb tube	50-lb box	



#### CLASSIFICATION

AWS/SFA 5.10, Class **ER4047**