

OK Autrod 4043

OK Autrod 4043 is one of the most widely used welding and brazing alloys and can be classed as a general purpose filler alloy. The silicon additions result in improved fluidity (wetting action) to make the alloy a preferred choice by welders. The alloy is not sensitive to weld cracking and produces bright and almost smut free welds. Not recommended for anodizing. Non-Heat treatable.

Classifications Wire Electrode	SFA/AWS A5.10 : ER4043 EN ISO 18273 : S Al 4043 (AlSi5) JIS Z 3232 : A4043
Approvals	CE EN 13479 CWB ER4043 DB 61.039.05 JIS JIS Z 3232 VdTUV 12187

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	AlSi
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	55 MPa	124 MPa	18 %

Typical Wire Composition %

Mn	Si	Al	Cu	Ti	Fe	Zn
0.01	5.00	Rem	0.02	0.01	0.14	0.01

Recommended Welding Parameters

Wire Diameter	Current	Voltage
0.8 mm	60-170 A	13-24 V
0.8 mm	100-130 A	18-22 V
0.8 mm	125-150 A	20-24 V
0.9 mm	60-170 A	13-24 V
0.9 mm	125-150 A	20-24 V
0.9 mm	85-120 A	20-23 V
0.9 mm	170-190 A	21-26 V
1.0 mm	90-210 A	15-26 V
1.2 mm	140-260 A	20-29 V
1.2 mm	125-150 A	20-24 V
1.2 mm	170-240 A	24-28 V
1.2 mm	180-210 A	22-26 V
1.6 mm	190-350 A	25-30 V
1.6 mm	190-260 A	21-26 V
1.6 mm	260-310 A	22-27 V
1.6 mm	240-300 A	22-27 V
1.6 mm	280-320 A	24-28 V
1.6 mm	290-340 A	26-30 V
2.0 mm	280-400 A	26-31 V
2.4 mm	280-400 A	26-31 V
2.4 mm	280-360 A	26-30 V
2.4 mm	300-400 A	26-30 V