

## 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.

Specifications	
<b>Classifications</b>	SFA/AWS A5.10 : ER4043 EN ISO 18273 : S Al 4043 (AISI5)
<b>Approvals</b>	CE : EN 13479 CWB : ER4043 DB : 61.039.05 UKCA : EN 13479 VdTÜV : 12187

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

<b>Alloy Type</b>	AISI
<b>Shielding Gas</b>	I1, I3 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	85 MPa	185 MPa	18 %

Typical Wire Composition %						
Mn	Si	Al	Cu	Ti	Zn	Fe
0.01	5.00	Rem	0.02	0.01	0.01	0.14

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	90-290 A	15-26 V
1.2 mm	140-260 A	20-29 V
1.2 mm	170-240 A	24-28 V
1.2 mm	125-150 A	20-24 V
1.2 mm	180-210 A	22-26 V
1.2 mm	140-300 A	20-29 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