

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 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