



TECHNICAL SPECIFICATION SHEET

HARRIS PRODUCTS GROUP
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4047(718) ALUMINUM WELD WIRE

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

STATEMENT OF LIABILITY — DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. Harris Products Group and its affiliates shall have no liability in respect thereof.

NOMINAL COMPOSITION: (2)

Aluminum	BALANCE	Titanium	.15 % (2)
Magnesium	.10% max.	Copper	.30% max.
Manganese	.15% max.	Iron	.80% max.
Silicon	11.0-13.0%	Zinc	.20% max.
Beryllium	.0008% max.		
Others	Each .05% max.	Total	.15 % max.

PHYSICAL PROPERTIES:

Solidus	1070 °F (577°C)	Density lbs/cu in	.096
Liquidus	1080 °F (582°C)	Post Anodize Color	Gray
<i>As Brazed</i>			
Tensile Strength	35,000 psi	Yield Strength	28,000 psi

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

Additional information available at our web site:



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RECOMMENDED WELDING PARAMETERS:

* **GMAW (MIG) Parameters** (DC Reverse Polarity) Electrode Positive Spray transfer

<u>Metal Thickness</u>	<u>Wire Diameter</u>	<u>Amps</u>	<u>Volts</u>	<u>Argon (cfh)</u>
1/16"	.030	70-110	15-20	25
1/8"	.030-3/64	120-150	20-24	30
3/16"	.030-3/64	130-210	22-26	30-35
1/4"	3/64-1/16	170-225	24-28	40
3/8"	1/16	225-300	26-29	50

***GTAW (TIG) Parameters** (AC) (1) Hemisphere tip shape tungsten electrode

<u>Material (1)</u>	<u>Pure or ziconiated</u>	<u>Filler Wire Size</u>	<u>Amps</u>	<u>Volts ACHF</u>	<u>Gas Cup</u>	<u>Argon(cfh)</u>
1/16"	1/16"-3/32"	1/16"-3/32"	70-100	15	3/8	20
1/8"	1/8"-5/32"	1/8"-5/32"	125-175	15	7/16	20
3/16"	5/32"-3/16"	5/32"-3/16"	170-225	15	7/16-1/2	25
1/4"	3/16"-1/4"	3/16"	220-275	15	1/2	30
3/8"	1/4"	3/16"-1/4"	330-380	15	5/8	35
1/2"	1/4"	1/4"	400-450	25	5/8	35

* **All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.**

**SPECIFICATION COMPLIANCE: ANSI/AWS A5.10, ASME SFA 5.10, QQ-R-566B
Class R/ER 4047**

**ANSI/AWS A5.8, ASME SFA 5.8 (BAISi-4) QQ-B-655c (FS-BAISi-4)
(2)DIN 1732 (S-AISi-12) Composition may vary from AWS**

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