

# ES MIG 4043

GMAW  
ER4043

**ESWECO**  
*The Art of Welding*

## Description

ES MIG 4043 is one of the most widely used welding and brazing alloys and can be classified as a general-purpose filler alloy. The silicon addition results in improved fluidity (wetting action), making the alloy the preferred choice of welders. The alloy is not sensitive to weld cracking and produces bright, almost smut-free welds. Not recommended for anodising. Non-heat treatable.

## Current

DC+

## Classifications

SFA/AWS A5.10	ER4043
EN ISO 18273	S Al 4043 (AlSi5)
EN ISO 18273	S Al 4043A (AlSi5(A))

## Typical all weld metal composition, %

Si	Mn	Cr	Cu	Fe	Ti	Zn
5.0	<0.05	<0.05	<0.05	<0.6	<0.15	0.10

## Typical mech. Properties all weld metal

Yield stress, MPa	55
Tensile strength, MPa	165
Elongation, %	18

## Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V
0.8	5-13	60-170	13-24
1.0	7-14	90-210	15-26
1.2	6-13	140-260	20-29
1.6	4.5-7.5	190-350	25-30