

**KISWEL****M-4043(AWS A5.10 ER4043)****0.035"(0.9mm) DC(+) 400IPM, 17-19V, 100%Ar(Gas flow-30-35CFH)****■ Classifications**

AWS A5.10 ER4043

■ Conformances and Approvals**ABS, CWB****■ Descriptions**

M-4043 is 5% silicon all position aluminum weld wire used to weld heat treatable alloys such as the 6XXX base metals and cast alloys. Found in many common welding applications such as bicycles, trucks, trailers, automotive parts and equipment. Silicon with this alloys give improved wetting action yielding a less crack sensitive bright weld bead.

It is not recommended any drying treatment but, keep this product in the dry environment at specific atmosphere (- 15°C: max 60% RH, 15 - 25°C: max 50% RH, >25°C: max 40% RH)

■ Wire Composition - As Required per AWS A5.10

Si	Mn	Mg	Fe	Ti	Cu	Zn	Be	Al
4.5-6.0	≤0.05	≤0.05	≤0.80	≤0.20	≤0.30	≤0.10	≤0.0003	Remainder

■ Welding Positions

PA/1G PB/2F PC/2G PF/3G up & dow PE/4G

■ Polarity & Shielding gas

100%Ar (15~25ℓ/min)

Argon/Helium Mixtures

DCEP (DC+) for GMAW

Gas flow (10~15ℓ/min)

■ Mechanical properties of all-weld-metal - As Required per AWS A5.10

Melting Range	Density	Post Anodize Color	Electrical/Thermal Conductivity	Elevated Temp. Applications +150°F
1065-1170°F (574-632 °C)	0.097lbs/in ³	70-90(520-620) Gray	42% IACS/1050 EU	YES

■ Recommended Operating Conditions (DC +)

Diameter		WFS (IPM)	Amps	Volts	Consumption (LB/100FT)	Argon (cfh)
Inches	(mm)					
0.030	0.8	400-600	60-120	14-20	0.65-1.25	25-30
0.035	0.9	350-550	80-130	16-21	1.0-4.25	30-35

■ Packaging Available

Dia. (")	0.030	0.035
Spool (LB)	1, 2, 10	

■ Plate thickness

0.030 size: under 0.04", 0.035 size: under 0.06"

■ Technical Support and advice

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■ Recommended Filler metals for Aluminium Base

Base Metal	201	319 333	356 A356 357	511 512	7004 7005	6009	6005 6051 6063													
	206	354 355	A357 413	513 514	7039 710	6010	6101 6151 6201	5456	5454	5154 5254	5086	5083	5052 5652	5005 5050	3004 Alc- 3004	2219	2014 2036	1100 3003 Alc- 3003	1060 3003 1070 1080 1350	
	224	C355	443 A444	535	712	6070	6351 6951													
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5083	-	-	5356 4043 5183	5356 5183 5556	5183 5356 5556	-	5356 5183 5556	5183 5356 5556	5356 5183 5556	5356 5183 5556	5356 5183 5556	5356 5183 5556								
5086	-	-	5356 4043 5183	5183 5356 5556	5356 5183 5556	-	5356 5183 5556	5183 5356 5556	5356 5183 5556	5356 5183 5554	5356 5183 5556	5356 5183 5556								
5154 5254	-	-	4043 5183 5356	5356 5183 5554	5356 5183 5554	-	5356 5183 5554	5356 5183 5554	5356 5183 5554	5654 5183 5356										
5454	-	4043 4047	4043 5183 5356	5356 5183 5554	5356 5183 5554	4043 4047	5356 4043 5183	5356 5183 5554	5554 4043 5183											
5456	-	-	5356 4043 5183	5356 5183 5556	5556 5183 5356	-	5356 5183 5556	5356 5183 5356												
6005 6061 6063 6101 6151 6201 6351 6951	4145	4145 4047 4043	4043 4047 5183	5356 5183 5554	5356 4043 5183	4043 4145	4043 4047 5183													
6009 6010 6070	4145	4145 4047 4043	4043 4145 4047	4043	4043	4043 4145 4047														
7004 7005 7039 710 712	-	4043 4047	4043 4047 5183	5356 5183 5554	5356 5183 5556															
511 512 513 514 535	-	-	4043 5183 5356	5356 5183 5554																
356 A356 357 A357 413 443 A444	4145	4145 4047 4043	4043 4047																	
319 333 354 355 C355	4145 2319	4145 4047 4043																		
201 206 224	2319 4145																			