

Al 99,5 Ti

CATEGORY GMAW-GTAW Solid wires

TYPE Pure aluminum filler metal for Tig welding

PROPERTIES This pure aluminum filler metal offers excellent weldability when properly cleaned prior to welding. Heavy parts and thicker plates should be preheated (150°C), prior to welding

CLASSIFICATION

AWS	A 5.10: no standard
EN ISO	18273: S Al 1450 / Al99,5Ti
DIN: W.Nr.	3.0805
DIN	1732: SG-Al 99,5

SUITABLE FOR Cast aluminium special repairs, Al99,0 Al.99,5 Al.99,7 E-Al

APPROVALS CE approved

WELDING POSITIONS:



Al	Ti
Bal.	0.15

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	30	80	40				

WELDING PARAMETERS PACKING

Welding Parameters		Packing (kg)	
D (mm)	Current (A) AC	Single	Master
1.6 x 1000	25-50	5	20
2.0 x 1000	40-75	5	20
2.4 x 1000	90-130	5	20
3.2 x 1000	160-240	5	20

GAS ACC. EN ISO 14175: I1, Argon+Helium (70-30)