


Al 99,5 Tig

CATEGORY	GMAW-GTAW Solid wires																												
TYPE	Pure aluminum filler metal for Tig welding																												
APPLICATIONS	Aluminium wire for welding mostly pure aluminium (maximum 0,5% of alloyed elements). Applications in chemistry, electronics, construction and food industries.																												
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: ER 1100																											
	EN ISO	1715: AW 1050A (Al99,5)																											
	DIN: W.Nr.	3.0259																											
	DIN	1732: SG-AL 99,8																											
SUITABLE FOR	Al99,0 Al.99,5 Al.99,7 E-Al., 99,5, 3.0205, 3.0255, 3.0275, 3.0257, EN AW 1200, EN AW 1050A, EN AW 1070A, EN AW 1350																												
APPROVALS	CE approved																												
WELDING POSITIONS:																													
ALL WELD DEPOSIT (WEIGHT %)	<table border="1"> <thead> <tr> <th>Al</th> <th>Rest</th> </tr> </thead> <tbody> <tr> <td>>99.5</td> <td><0.5</td> </tr> </tbody> </table>			Al	Rest	>99.5	<0.5																						
Al	Rest																												
>99.5	<0.5																												
MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (N/mm²)</th> <th rowspan="2">R_m (N/mm²)</th> <th rowspan="2">A₅ (%)</th> <th colspan="3">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness HRC / HV</th> </tr> <tr> <th>-20°C</th> <th>-40°C</th> <th>-60°C</th> </tr> </thead> <tbody> <tr> <td>AW</td> <td>>40</td> <td>>70</td> <td>>30</td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>			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	>40	>70	>30											
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	>40	>70	>30																										
AW: as welded																													
WELDING PARAMETERS / PACKING	<table border="1"> <thead> <tr> <th rowspan="2">D (mm)</th> <th rowspan="2">Welding Parameters</th> <th colspan="2">Packing (kg)</th> </tr> <tr> <th>single</th> <th>master</th> </tr> </thead> <tbody> <tr> <td>1.6 x 1000</td> <td>Current (A) AC</td> <td>5</td> <td>20</td> </tr> <tr> <td>2.0 x 1000</td> <td>25-50</td> <td>5</td> <td>20</td> </tr> <tr> <td>2.4 x 1000</td> <td>40-75</td> <td>5</td> <td>20</td> </tr> <tr> <td>3.2 x 1000</td> <td>90-130</td> <td>5</td> <td>20</td> </tr> <tr> <td></td> <td>160-240</td> <td>5</td> <td>20</td> </tr> </tbody> </table>			D (mm)	Welding Parameters	Packing (kg)		single	master	1.6 x 1000	Current (A) AC	5	20	2.0 x 1000	25-50	5	20	2.4 x 1000	40-75	5	20	3.2 x 1000	90-130	5	20		160-240	5	20
D (mm)	Welding Parameters	Packing (kg)																											
		single	master																										
1.6 x 1000	Current (A) AC	5	20																										
2.0 x 1000	25-50	5	20																										
2.4 x 1000	40-75	5	20																										
3.2 x 1000	90-130	5	20																										
	160-240	5	20																										
REDRYING TEMPERATURE	not required																												
GAS ACC. EN ISO 14175:	I1, Argon+Helium (70-30)																												