

CATEGORY	GTAW Solid wires		
TYPE	99,0 % pure aluminum filler metal for Tig welding		
APPLICATIONS	Aluminum wire for welding mostly pure aluminum (maximum 0,95% of alloyed elements). Applications in chemistry, electronics, construction and food industries.		
PROPERTIES	This 99,0% pure aluminum filler metal offers excellent weldability and is the strongest in the 1000 series of the pure aluminium grades. Heavy parts and thicker plates should be preheated (150°C), prior to welding. At the same time, it keeps the benefits of being relatively lightly alloyed (compared to other series), such as high electrical conductivity, thermal conductivity, corrosion resistance, and workability. It can be strengthened by cold working, but not by heat treatment.		
CLASSIFICATION	AWS	A 5.10: ER1100	
	EN ISO	18273: S AL 1100 (Al99,0Cu)	
	F-nr	21	
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, 1060, 1070, 1080, and 3003.		
APPROVALS	CE		

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Mn	Cu	Al	Si+Fe
0.03	0.1	99.5	0.75

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)
As Welded /	52	93	30

WELDING PARAMETERS / PACKING

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1, I3