

CATEGORY	GMAW Solid wires	
TYPE	Pure aluminum filler metal for Mig 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 EN ISO F-nr	A 5.10: ER1070 18273: S Al 1070 (Al99,7) 21
SUITABLE FOR	Al99,0 Al99,5 Al99,7 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	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

Si	Mn	Ti	Fe	Cu	Zn	Al
0.18	0.02	0.01	0.1	0.01	0.01	99.8

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)
As Welded /	40	70	30

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE (V)	CURRENT (A)	SPOOL TYPE	KG / SPOOL / DRUM	KG / PALLET
1.0	15-26	90-210	D-100 / D-200 / K-300 / DRUM	0.5 / 2.0 / 7.0 / 80	
1.2	20-29	140-260	D-100 / D-200 / K-300 / DRUM	0.5 / 2.0 / 7.0 / 80	
1.6	25-30	190-350	D-200 / K-300 / DRUM	2.0 / 7.0 / 80	

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1, I3