

|                |   |   |
|----------------|---|---|
| CATEGORY       | GTAW Solid wires  |   |
| TYPE           | Pure aluminum filler metal for TIG welding  |   |
| APPLICATIONS   | Aluminium wire for welding mostly pure aluminium (maximum 0.3% 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<br>EN ISO<br>F-nr   | A 5.10: ER1070<br>18273: S AL 1070 (Al99,7)<br>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   |
|-----|------|------|-----|------|------|------|
| 0.1 | 0.02 | 0.02 | 0.1 | 0.01 | 0.01 | 99.8 |

ALL WELD MECHANICAL PROPERTIES

| Heat Treatment | R <sub>p0,2</sub><br>MPa | R <sub>m</sub><br>MPa | A <sub>5</sub><br>(%) |
|----------------|--------------------------|-----------------------|-----------------------|
| As Welded /1h  | 40                       | 70                    | 30                    |

WELDING PARAMETERS / PACKING

| D (MM)     | WELDING PARAMETERS | CURRENT (A) AC | PACKING (KG) |        |
|------------|--------------------|----------------|--------------|--------|
|            |                    |                | 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     |

|                        |              |
|------------------------|--------------|
| REDRYING TEMPERATURE   | Not required |
| GAS ACCORDING EN 14175 | I1, I3       |