

## Classifications

EN ISO 18273	AWS A5.10
S Al 1450 (Al99,5Ti)	ER1450

## Characteristics and typical fields of application

Pure aluminium welding wire for joining and surfacing of aluminium materials with maximum of 0.5% of alloyed elements. The welding consumable contains Ti for grain refinery. Base material should be cleaned near the seam.

## Base materials

EN AW-1200 [Al99,0]	Al99,0	3.0205
EN AW-1050A [Al99,5]	Al99,5	3.0255
EN AW-1070A [Al99,7]	Al99,7	3.0275
EN AW-1350A [EAl99,5]	E-Al	3.0257

and similar.

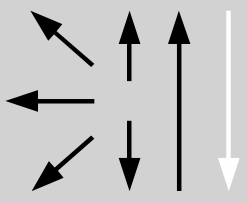
## Typical analysis of solid wire (wt.-%)

Al	Si	Fe	Cu	Mn	Mg	Zn	Ti
≥ 99.5	< 0.25	< 0.4	< 0.05	< 0.05	< 0.05	< 0.07	0.1 – 0.2

## Mechanical properties of all-weld metal

Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )
MPa	MPa	%
20	65	35

## Operating data

	<b>Polarity:</b> DC (+)	<b>Shielding gases:</b> (EN ISO 14175) I1, I3	<b>ø mm</b>
			1.0
			1.2
			1.6

## Approvals

TÜV, DB, CE