

Al 99,5

CATEGORY GMAW-GTAW 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	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 %)

Al	Rest
>99.5	<0.5

MECHANICAL PROPERTIES

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

Welding Parameters			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 ACC. EN ISO 14175: I1, Argon+Helium (70-30)