

## Al 99,5 Ti

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Pure aluminum filler metal for Tig welding

**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: no standard
EN ISO	18273: S Al 1450 / Al99,5Ti
DIN: W.Nr.	3.0805
DIN	1732: SG-Al 99,5

**SUITABLE FOR** Cast aluminium special repairs, Al99,0 Al.99,5 Al.99,7 E-Al

**APPROVALS** CE approved

**WELDING POSITIONS:**



Al	Ti
Bal.	0.15

### MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	30	80	40				

### 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

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