

## Al 99,5 Tig

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Pure aluminum filler metal for Tig 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 <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	>40	>70	>30				

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters	Packing (kg)	
		single	master
1.6 x 1000	Current (A) AC 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 ACC. EN ISO 14175:** I1, Argon+Helium (70-30)