

Classifications

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

Characteristics and typical fields of application

Is a pure aluminium welding wire for joining and surfacing of aluminium materials according to EN ISO 18273. It is a welding consumable with Ti for grain refinement and weldable in all positions.

Base materials

Al99.5	3.0255
Al99.7	3.0275
Al99.8	3.0285

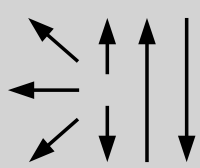
Typical analysis of welding rod (wt.-%)

	Al	Si	Fe	Ti
wt.-%	min. 99.5	≤ 0.25	< 0.4	0.15

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

	Polarity: DC (+)	Shielding gas: EN ISO 14175: I1 Base material should be cleaned near the seam. Pre-heating 200 °C for plates > 15 mm	ø (mm)
			1.6
			2.0
			2.4
			3.2
			4.0

Approvals

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