

ER1100

AWS A5.10 ER1100

EN ISO 18273 S Al 1070 (Al99,7)

Description:

ER1100 aluminum wire is designed for applications with electrical conductivity requirements & chemical storage facilities. Excellent corrosion resistance, highest electrical and thermal conductivity.

Used to weld Electrical conductors, chemical storage tanks, piping & tubing for chemicals, refrigeration, food handling equipment, heat exchangers etc.

Welding Position:



Diameters:

0.8mm, 0.9mm, 1.0mm, 1.2mm, 1.6mm.

Typical Mechanical Properties:

Tensile strength(MPa):	75
Yield strength(MPa):	30
Elongation(%):	--

Typical Chemical Compositon:

Si	Fe	Cu	Mn	Mg
0.25	0.3	0.05-0.2	0.05	0.05
Cr	Zn	Be	Ti	Al
0.05	0.1	0.0002	0.05	Min99.0

Welding Current:(AC)

Dia:(mm)	0.8	0.9	1.0	1.2	1.6
Current/A	60-170	60-170	90-210	140-260	190-350
Voltage/V	13-24	13-24	15-26	20-29	25-30

Note:

1. Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
2. Shield Gas: 100%Ar or 75%Ar+25%He or 50%Ar+50%He
3. In order to get good welding bead, weld on thick plate should be preheat 100-200°C before welding.
4. Tig rods ER1100 1.6mm, 2.0mm, 2.4mm, 3.2mm available