MIG A L99.7

Old reference: MIG Al99.5

Classification

ISO 18273 : S Al 1070 (Al99.7) Material N° : 3.0259
AWS A5.10 : ~ER1100

Description & Applications

Solid wire for GMAW used to weld pure aluminium or similar chemical composition alloys. Often used for its excellent electrical conductivity or for its high resistance against certain corrosions.

Base material:

Alloy	DIN	Material N°.
1080A	Al99,5	3.0255
1050A	Al99,7	3.0275
1100	Al99,8	3.0285
3004	Al99	3.0205
3005		
3303		

Typical Chemical Composition (%)

Si	Fe	Cu	Mn	Zn	Al
0.03	0.13	0.001	0.005	0.01	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
80	100	30

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0 1.2 1.6	100-150 130-200 170-280	18-22 18-25 20-27	Ar/He 18-20 l/min

Ind.10

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