

Aluminium wire

Classification

AWS A5.10 :ER1100*

* Nearest classification

General Description

Solid wire for welding pure aluminium with maximum of 0.5% alloying elements

Shielding gas (acc. EN)

GTAW	I1	Inert gas Ar 100%
GMAW	I1	Inert gas Ar 100%
	I3	Inert gas Ar + > 0-95% He

Chemical composition (w%), typical, all weld metal

Al	Zn	Ti	Cu	Mn	Si	Si+Fe	Fe
rest	0.02	0.04	0.04	<0.01	0.05	0.2	0.12

Mechanical properties, all weld metal

	Process	Shielding gas	Condition	0.2% Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact (ISO), J		Hardness HB
							+20 °C	-60 °C	
Typical values	GTAW	I1	AW	30	80	40			
after welding	GMAW	I1	AW	30	80	40			

Physical properties

Melting range 647-658°C

Density approximately 2700 kg/m³

Materials to be welded

Material	Type	W.Nr.	Int.Reg.Nr.
DIN 1712-3	Al 99.9	3.03.05	1090 A
	Al 99.8	3.0285	1080 A
	Al 99.7	3.0275	1070 A
	Al 99.5	3.0255	1050 A
	E-Al	3.0257	1350 A
	Al 99	3.0205	1200

Packaging, available sizes and identification

Process	Unit:	Sizes, mm								
		0.8	1.0	1.2	1.6	2.0	2.4	3.2	4.0	5.0
GTAW	5 kg tube					X	X	X	X	
GMAW	7.0 kg basket spool BS300	X	X	X	X					

X

Other sizes and packaging on request

Identification

Imprint: Reval[®]1100

Tip colour:

Reval[®]1100 : rev.EN 20