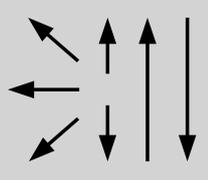


Classifications				
EN ISO 18273	AWS A5.10			
S Al 1450 (Al99,5Ti)	-			
Characteristics and typical fields of application				
Is a pure aluminium welding wire for joining and surfacing of aluminium materials according to EN ISO 18273. It is a welding consumable with Ti for grain refinement and weldable in all positions.				
Base materials				
Al99.5	3.0255			
Al99.7	3.0275			
Al99.8	3.0285			
Typical analysis of solid wire (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				
	<b>Polarity:</b> DC ( + )	<b>Shielding gas:</b> EN ISO 14175: I1, I3  Base material should be cleaned near the seam. Pre-heating 200 °C for plates > 15 mm		<b>ø (mm)</b> 1.0 1.2 1.6
Approvals				
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