

Classifications

EN ISO 18273	AWS A5.10
S Al 1450 (Al99,5Ti)	ER1450

Characteristics and typical fields of application

This wire is a pure aluminium wire for welding joints and cladding on aluminium base materials acc. to EN ISO 18273. Thanks to the Ti for a fine grained structure this wire has good weld ability in all welding positions.

Base materials

Al99.5	3.0255
Al99.7	3.0275
Al99.8	3.0285
Al Mn	
E Al Mg Si	

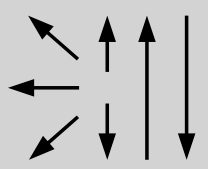
Typical analysis of solid wire (wt.-%)

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

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)
	MPa	MPa	%
u	≥ 20	≥ 65	≥ 35
u	untreated, as welded		

Operating data

	Polarity: DC (+)	Shielding gases: EN ISO 14175: I1, I3	ø (mm) 1.2
	Base material should be cleaned near the seam. Pre-heating 200 °C for plates > 15 mm		

Approvals

TÜV (02317.), DB (61.014.01), CE