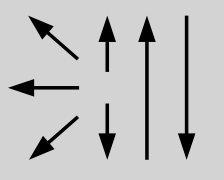


Classifications				
EN ISO 18273		AWS A5.10		
S Al 1450 (Al99,5Ti)		ER1450		
Characteristics and typical fields of application				
This TIG rod is a pure aluminium wire for welding joints and cladding on aluminium base materials acc. to EN ISO 18273. Thanks to the Ti for a fine grained structure this 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: AC	Shielding gases: EN ISO 14175: I1	ø (mm)	
			1.6	
			2.0	
			2.4	
		3.2		
		Base material should be cleaned near the seam. Pre-heating 200 °C for plates > 15 mm		
Approvals				
TÜV (02317.), DB (61.014.01), CE				