



# CEWELD Al 99,0 Tig

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                     |                               |                                    |
|------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------|-------------------------------|------------------------------------|
| TYPE                                                 | 99,0 % pure aluminum filler metal for Tig welding                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                                     |                               |                                    |
| APPLICATIONS                                         | Aluminum wire for welding mostly pure aluminum (maximum 0,95% of alloyed elements). Applications in chemistry, electronics, construction and food industries.                                                                                                                                                                                                                                                                                                                                        |                                                     |                               |                                    |
| PROPRIÉTÉS                                           | This 99,0% pure aluminum filler metal offers excellent weldability and is the strongest in the 1000 series of the pure aluminium grades. Heavy parts and thicker plates should be preheated (150°C), prior to welding. At the same time, it keeps the benefits of being relatively lightly alloyed (compared to other series), such as high electrical conductivity, thermal conductivity, corrosion resistance, and workability. It can be strengthened by cold working, but not by heat treatment. |                                                     |                               |                                    |
| CLASSIFICATION                                       | AWS<br>EN ISO<br>F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | A 5.10: ER1100<br>18273: S Al 1100 (Al99,0Cu)<br>21 |                               |                                    |
| CONVIENT POUR                                        | Al99,0 Al.99,5 Al.99,7 E-Al., 99,5, 3.0205, 3.0255, 3.0275, 3.0257, EN AW 1200, EN AW 1050A, EN AW 1070A, EN AW 1350, 1060, 1070, 1080, and 3003.                                                                                                                                                                                                                                                                                                                                                    |                                                     |                               |                                    |
| AGRÉMENTS                                            | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                     |                               |                                    |
| POSITIONS DE SOUDAGE                                 |                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                     |                               |                                    |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | Mn<br>0.03                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Cu<br>0.1                                           | Al<br>99.5                    | Si+Fe<br>0.75                      |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment<br>As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | R <sub>P0,2</sub><br>(MPa)<br>52                    | R <sub>m</sub><br>(MPa)<br>93 | A5<br>(%)<br>30<br>Hardness<br>HRc |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                     |                               |                                    |
| GAS ACC. EN ISO 14175                                | I1, I3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                     |                               |                                    |