



MIG AL99.7

Old reference: MIG Al99.5

Classification

AWS A5.10 : ER1070

ISO 18273 : S Al 1070 (Al99.7)

Description & Applications

Solid wire for GMAW of pure Aluminium and similar composition alloys. Often used for its excellent electrical conductivity or for its high resistance against corrossions in food industry

Main applications: Food industry, boiler making, chemical industry...

Base materials:

Alloy	DIN	Material N°
1080A	Al 99.5	3.0255
1050A	Al 99.7	3.0275
1100	Al 99.7	3.0285
3004-3005	Al 99	3.0205
3303		

Typical Chemical Composition (%)

	Si	Fe	Cu	Mn	Mg	Zn	V	Ti	Be	O/E	Al
Min											99.70
Max	0.20	0.25	0.04	0.03	0.03	0.04	0.05	0.03	0.0003	0.03	
Type	0.05	0.15	0.005	0.01	0.001	0.01	0.002	0.001	0.0001	<0.03	>99.70

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
Min	-	-	-
Max			
Type	70	100	30

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = + / Pulsed	1.0	100-150	18-22	ISO 14175: I1 (100% Ar) I3 (Ar+ 5-30%He) 15-20L/min
	1.2	130-200	18-25	
	1.6	170-260	20-27	

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Fumes: Consult information on MSDS, available upon request.

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