



MIG ALC6

Old reference: MIG AlCu6

Classification

AWS A5.10 : ER2319
AMS : 4191

ISO 18273 : S Al 2319 (AlCu6MnZrTi)

Description & Applications

Solid wire for GMAW of Aluminium alloy with similar chemical composition like AlCu6. Used for applications with service temperature at -196°C up to 300°C.

Main applications: Space industries, nuclear plant and armament.

Typical Chemical Composition (%)

	Si	Fe	Cu	Mn	Mg	Zn	V
Min			5.8	0.20			0.05
Max	0.20	0.30	6.8	0.40	0.02	0.10	0.15
Type	0.06	0.15	6.7	0.30	0.01	0.01	0.08

	Ti	Zr	Be	O/E	O/T	Al
Min	0.10	0.10				
Max	0.20	0.25	0.0003	0.05	0.15	Rem.
Type	0.15	0.15	0.0001	<0.05	<0.15	Rem.

All Weld Metal Mechanical Properties

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

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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