

❖ Product Description

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|--|----------------------------------|
| I. A 99% aluminium solid wire | III. High corrosion resistance |
| II. Smooth wire feedability with efficient welding | IV. High electrical conductivity |
| | V. Radiographic weld quality |

❖ Range of Application

- | | |
|--|---|
| I. For welding of 1XXX series and pure aluminium | II. For aluminium grades Al99.8, Al 99.7, Al 99.5, E-Al |
| | III. Tanks brackets and bus bodies |

❖ Classification

- AWS/SFA 5.10 ER1100

❖ % Chemical Composition

Type of Wire		Si+Fe	Mn	Zn	Ti	Be	Al	Cu	Be	Other Each	Other Total
ER1100	Min	-	-	-	-	-	99.0	0.05	-	-	-
	Max	0.95	0.05	0.10	0.20	0.0003	-	0.20	0.0003	0.05	0.15

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
As Welded	93	-	-	-

❖ Wire Size & Welding Position

- | | |
|--|---|
| <ul style="list-style-type: none"> • Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60 | <ul style="list-style-type: none"> • Weld Position- All position |
|--|---|

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Size Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60			
Packing Code	A	B	C	D
Packing Available	SD 100	SD200	SD270	SD 300
Net Weight of Wire	0.5KG	1KG	7KG	7KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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