


# CEWELD Al 99,0

|   |  |                      |                         |                      |        |          |           |      |     |    |     |
|---|--|----------------------|-------------------------|----------------------|--------|----------|-----------|------|-----|----|-----|
| TYPE  | 99,0% pure aluminum filler metal for Mig welding   |                      |                         |                      |        |          |           |      |     |    |     |
| TOEPASSINGEN                                      | Aluminum wire for welding mostly pure aluminum (maximum 0,95% of alloyed elements). Applications in chemistry, electronics, construction and food industries.  |                      |                         |                      |        |          |           |      |     |    |     |
| EIGENSCHAPPEN                                     | 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. |                      |                         |                      |        |          |           |      |     |    |     |
| CLASSIFICATIE                                     | AWS                    A 5.10: ER1100<br>EN ISO                18273: S Al 1100 (Al99,0Cu)<br>F-nr                    21   |                      |                         |                      |        |          |           |      |     |    |     |
| GESCHIKT VOOR                                     | 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.  |                      |                         |                      |        |          |           |      |     |    |     |
| GOEDKEURINGEN                                     | CE   |                      |                         |                      |        |          |           |      |     |    |     |
| LASPOSITIES                                       |   |                      |                         |                      |        |          |           |      |     |    |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Mn</td> <td style="width: 25%;">Cu</td> <td style="width: 25%;">Al</td> <td style="width: 25%;">Si+Fe</td> </tr> <tr> <td>0.03</td> <td>0.1</td> <td>99.4</td> <td>0.5</td> </tr> </table>   | Mn                   | Cu                      | Al                   | Si+Fe  | 0.03     | 0.1       | 99.4 | 0.5 |    |     |
| Mn  | Cu   | Al                   | Si+Fe                   |                      |        |          |           |      |     |    |     |
| 0.03  | 0.1  | 99.4                 | 0.5                     |                      |        |          |           |      |     |    |     |
| MECHANISCHE WAARDEN                               | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Heat Treatment</td> <td style="width: 15%;">R<sub>p0,2</sub> (MPa)</td> <td style="width: 15%;">R<sub>m</sub> (MPa)</td> <td style="width: 10%;">A5 (%)</td> <td style="width: 35%;">Hardness</td> </tr> <tr> <td>As Welded</td> <td>52</td> <td>93</td> <td>30</td> <td>HRc</td> </tr> </table>   | Heat Treatment       | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness | As Welded | 52   | 93  | 30 | HRc |
| Heat Treatment                                    | R <sub>p0,2</sub> (MPa)  | R <sub>m</sub> (MPa) | A5 (%)                  | Hardness             |        |          |           |      |     |    |     |
| As Welded   | 52   | 93                   | 30                      | HRc                  |        |          |           |      |     |    |     |
| HERDROGEN   | Not required   |                      |                         |                      |        |          |           |      |     |    |     |
| GAS ACC. EN ISO 14175                             | I1, I3   |                      |                         |                      |        |          |           |      |     |    |     |