

LNT AI99.5

CLASSIFICATION

AWS 5.10/5.10M - ER1100* * Nearest classification
ISO 18273 - S Al 1070

GENERAL DESCRIPTION

Solid rod for welding pure aluminium with maximum of 0.5% alloying elements

SHIELDING GASES (ACC. ISO 14175)

I1 : Inert gas Ar (100%)

CHEMICAL COMPOSITION (W%) TYPICAL WIRES

Al	Zn	Ti	Cu	Mn	Si
min. 99.5	0.02	0.04	0.04	<0.01	0.05

MECHANICAL PROPERTIES. TYPICAL. ALL WELD METAL

	Shielding gas	Condition	0.2 proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)
Typical values	I1	AW	30	80	40

PHYSICAL PROPERTIES

Melting range : 647 - 658°C
Density : approximately 2700 kg/m³

MATERIALS TO BE WELDED

Standard	Type	W. Nr	Int.Reg.Nr.
DIN 1712-3	Al 99,8	3.0285	1080 A
	Al 99,7	3.0275	1070 A
	Al 99,5	3.0255	1050 A
	E-Al	3.0257	1350 A
	Al 99	3.0205	1200

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	2.0	2.4	3.2	4.0	
Unit : 5 kg tube	X	X	X	X	<i>Note : Cut length = 1000 mm</i>
Other sizes and packaging on request					

LNT AI99.5: rev. EN 22