

A/99.8

CLASSIFICATION

AWS A5.3 : E1100*
ISO 18273 : Al 1080A (Al 99.8(A))
*:Deviation,see remarks

ASME IX QUALIFICATION & EN MATERIAL NO.

QW 432 : F - No. : 21
QW 442 : A - No. : N.A.
EN Material No. : 3.0286

GENERAL DESCRIPTION

Especially for welding pure aluminium
Good weldability, no porosity

WELDING POSITIONS

ISO/ASME  PA/1G  PB/2F

CURRENT TYPE

DC +

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Al	Mn	Si	Zn	Fe	Cu	Others
99.8 min	0.02 max.	0.085 max.	0.03 max.	0.13 max.	0.02 max.	0.02 max.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)
Typical values	AW	30	80	30

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.5
	Length (mm)	350
Unit: Can	Pieces / unit	-
	Net weight/unit (kg)	2.0

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MATERIALS TO BE WELDED

Pure Aluminium like:

Al99.8 (Werkstoff-Nr. 3.0285)

Al99 (Werkstoff-Nr. 3.0205)

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Weight/ 1000 pcs (kg)
2.5 x 350	40-70	DC+	9.2

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions	
	PA/1G	PB/2F
2.5	60A	60A

REMARKS / APPLICATION ADVICE

Deviations:chemical composition

Cu = max.0.02% AWS:Cu = 0.05 - 0.20%

If the thickness is more than 10 mm, it is advisable to preheat at 150 - 250°C