

## AX-AI99,7

Material.-No.: 3.0259

### Standards

EN ISO 18273:	S Al 1070 (AI99,7)
AWS A5.10:	-

### Properties

TIG rod/solid wire for welding of pure aluminium. Highly resistant to chemical corrosion.

### Important base materials / Important applications

Pure aluminium e.g. EN AW-1050A (AI 99,5), EN AW-1070A (AI 99,7) , EN AW-1080A (AI 99,8), EN AW-1098 (AI 99,98), EN AW-1200 (AI 99,0), EN AW-1350 (AI 99,5A).

### Typical composition of welding rod / solid wire in %

Al				
min. 99,7				

### Mechanical properties of all-weld metal (typical values)

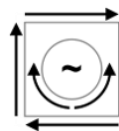
Yield strength $R_{p0,2}$	[MPa]	30
Tensile strength $R_m$	[MPa]	65
Elongation A ( $L_0 = 5d_0$ )	[%]	30
Electrical conductivity	[S*m/mm <sup>2</sup> ]	34 – 36
Thermal conductivity	[W/(m*K)]	210 – 230
Thermal expansion coefficient	[1/K]	$23,5 \cdot 10^{-6}$

Shielding gas: 100% Argon, PWHT: untreated

### Operating data

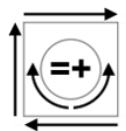
#### TIG:

Shielding gas: I1 (100%Argon)  
acc to. ISO 14175



#### GMAW:

I1 (100%Argon)  
I3 (e.g. Ar+30%He)



For large workpieces and wall thicknesses over 15mm, preheat the area of the weld joint to 150°C.

### Approvals

(Please ask for current scope)

### Packaging and available sizes

Spools	Ø mm	0,8	1,0	1,2	1,6	2,4	
Rods	Ø mm x 1000mm	1,6	2,0	2,4	3,2	4,0	5,0

Other dimensions on request.