

Standards

TS EN ISO 18273	: ~S Al 1100 (Al 99.0 Cu)
EN ISO 18273	: ~S Al 1100 (Al 99.0 Cu)
AWS A5.10	: ~ER1100

Chemical Composition of Welding Wire % (Typical)

Al
min. 99

Mechanical Properties

Density (kg/dm ³)	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (L ₀ =5d ₀) (%)	Melting Range (°C)	Electrical Conductivity (Sm/mm ²)
2.7	min. 40	min. 70	30	658 - 674	35

Features and Applications

- Al99.5 TIG is pure aluminum welding TIG rod
- It is used for joining of aluminum alloys required high electrical conductivity
- It is recommended that preheating to 200°C before welding of plates thicker than 15mm
- For gas welding, GeKaTec F-LH1 is recommended
- Shielding gas: Ar

Welding Method

TIG Welding - Gas Welding

Current Type	MIG Wire	Electrode
TIG A.C.	GeKa Al99.5	GeKaTec Aluweld 99Al

Welding Positions



Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6011100036	2.0 x 1000	5/64 x 39"	5
6011100392	2.4 x 1000	3/32 x 39"	5
6011100038	3.2 x 1000	1/8 x 39"	5
6011100039	4.0 x 1000	5/32 X 39"	5

Approvals: SEPRO