

LNM Al99.5

CLASSIFICATION

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

GENERAL DESCRIPTION

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

WELDING POSITIONS

ISO/ASME						
	PA/1G	PB/2F	PC/2G	PD/4F	PE/4G	PF/3G up

SHIELDING GASES (ACC. ISO 14175)

I1	: Inert gas Ar (100%)
I3	: Inert gas Ar+ 0.5-95% He

CHEMICAL COMPOSITION (W%) TYPICAL WIRES

Al	Zn	Ti	Cu	Mn	Si	Si+Fe	Fe
min. 99.7	0.02	0.04	0.04	<0.01	0.05	0.2	0.12

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/m ³

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

APPLICATIONS

General Construction Industry
Automotive bumpers and supports

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	1.0	1.2	1.6
Unit :	7.0 kg spool B300	X	X	X
Other sizes and packaging on request				

LNM Al99.5: rev. EN 22