



HILCO FLUXCORED AI99,5

Gas welding rods – aluminium

AWS A5.10: ~ER 1070

Werkstoffnr. 3.0259

Wire type:

OAW Cored wire

Shielding gas:

Oxy-acetylene

Welding positions:

Fluxcored AI99,5 is our flux cored aluminium wire rod for oxy-acetylene gas welding, repairing and surfacing pure aluminium and wrought aluminium alloys. The internal flux core makes the need of additional fluxes unnecessary.

Base materials to be welded:

- Pure aluminium acc. to DIN 1712 AI99,8 and AI99
- Pure aluminium Werkstoffnr. 3.0285 and 3.0205
- Similar aluminium and wrought aluminium alloys

Applications:

- Construction works (aluminium base metals)
- Repair shops

Chemical composition, wt.% weld metal – typical:

Mn	Si	Fe	Cu	Ti	Zn	Mg	Al
0,01	0,1	0,3	0,001	0,01	0,01	0,02	Bal.

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Melting range °C
As welded	35	80	30	647 – 658

Packaging data:

Dia. mm.	Weight / package kg.
3,0	1