

ES MIG 1100

GMAW
ER1100

ESWECO
The Art of Welding

Description

ES MIG 1100 is highly resistant to chemical attack and weathering. It is a relatively soft alloy that is very formable and it is used extensively in thin-gauge and foil products. It has good welding characteristics. One characteristic feature of the alloy is the bright finish obtained by anodising. Non-heat treatable.

Current

DC+

Classifications

SFA/AWS A5.10	ER1100
EN ISO 18273	S Al 1100 (Al99.0Cu)

Typical all weld metal composition, %

Mn	V	Cu	Al	Ti	Zn
<0.05	<0.5	0.13	>99.0	<0.03	<0.1

Typical mech. Properties all weld metal

Yield stress, MPa	30
Tensile strength, MPa	75
Elongation, %	35

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V
1.2	6-13	140-260	20-29
1.6	4.5-7.5	190-350	25-30