

# Inweld Aluminum 1100

AWS A5.10 ER1100

## Chemical Composition of Inweld Aluminum 1100

Fe	Cr	Ni	Zn	Mn	Si	Mg	Ti	Cu	Al
Si+Fe < 0.95	---	---	0.10	0.05	Si+Fe < 0.95	---	---	0.05- 0.20	Balance

Single values are maximum unless otherwise specified.

## Description and Applications

Inweld 1100 is a 99% aluminum filler metal for MIG and TIG welding base metals of unalloyed aluminum and provides a good color match after anodizing. Suitable for electrical applications. Highly resistant to chemical corrosion. Common applications would include base metals 1100, 3003, Aic. 3003 to similar base metals or to 1060, 1070, 1080 and 1350. Average tensile strength as welded is 13,500 psi.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	44,000 psi
Yield Strength:	40,000 psi
Elongation:	17%

## Recommended Parameters

GMAW (DCEP – Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Wire Feed IPM</u>
0.030"	15-24	60-175	45-45
0.035"	15-27	70-185	45-40
3/64"	20-29	125-260	24-35
1/16"	24-30	170-300	28-38
3/32"	26-31	275-400	14-20

GTAW (DCEN – Electrode-)

<u>Filler Wire Size</u>	<u>Tungsten Dia.</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Argon (CFH)</u>
1/16"	1/16"	15	60-80	20
3/32"	3/32"	15	125-160	20
1/8"	1/8"	15	190-220	20
5/32"	5/32"	15	200-300	25
3/16"	3/16"	15-20	330-380	25
1/4"	1/4"	25	400-450	25

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