

OK Autrod 1070

GMAW

S Al 1070 (Al99.7)

Description

OK Autrod 1070 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.

Welding current

DC(+)

Classifications

EN ISO 18273

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Wire composition

Si	Mn	V	Cu	Al	Fe
<0.20	<0.03	<0.05	<0.04	>99.7	<0.25

Typical mech. properties all weld metal

Yield stress, MPa	35
Tensile strength, MPa	75
Elongation, %	45

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
1.0	7-14	90-210	15-26	0.9-1.8
1.2	6-13	140-260	20-29	1.1-2.4
1.6	4.5-7.5	190-350	25-30	1.5-2.5
2.0		190-350	25-30	