



# Changzhou Sanzhong Welding Materials Co.,Ltd

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Standard: AWS A5.10 ER1100	Chemical Composition %						
	Si + Fe	Cu	Mn	Zn	AL	Other Each	Other Total
Grade ER1100	≤ 0.95	0.05 – 0.2	≤ 0.05	≤ 0.10	≥ 99	≤ 0.05	≤ 0.15
Type	Spool (MIG)			Tube (TIG)			
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0			1.6、2.0、2.4、3.2、4.0、5.0			
Package	S100/0.5kg S270,S300/6kg-7kg		S200/2kg S360/20kg		5kg/box	10kg/box	length :1000MM
Mechanical Properties	Fusion Temperature °C	Electrical IACS	Heat W/m.k	Tensile Mpa	Yield Mpa	Elongation %	
	646 – 657	62%	210 –230	70 – 95	30 – 55	20 – 30	
	Diameter (MM)	1.2		1.6		2.0	
MIG Welding	Welding Current - A	180 – 300		200 – 400		240 – 450	
	Welding Voltage- V	18 – 26		20 – 28		22 – 32	
TIG Welding	Diameter (MM)	2.0 – 2.4		2.4 – 4.0		4.0 – 5.0	
	Welding Current - A	150 – 250		200 – 320		220 – 400	
Performance characteristics	Purity aluminium, Al ≥ 99.0%						
	Excellent corrosion resistance, excellent thermal conductivity, electrical conductivity and excellent machinability.						
	The welding seam is beautiful and bright, the arc is stable and the spatter is small.						
	Good color matching after anodic treatment, recommended for welding 1000 series aluminum alloy.						
Application	Filling material for pure aluminum welding.						
	It is widely used in connection of aluminum busbar and guide bar in electrolytic aluminum factory and welding of related aluminum alloy such as electric power.						
Notice	1、The product can be kept for two years under the condition of factory packing and sealed, and the packing can be removed for three months under the usual atmospheric environment.						
	2、Products should be stored in a ventilated, dry and place.						
	3、After the wire is removed from the package, it is recommended that appropriate dust proof cover be applied over the wire.						



TEL:86 189 1234 9999

E-mail: manager@kkweld.com

Whatsapp : +86 189 1234 9999