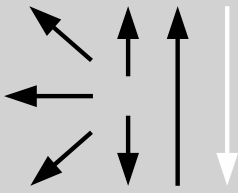


Classifications						
EN ISO 18273			AWS A5.10			
S Al 2319 (AlCu6MnZrTi)			ER2319			
Characteristics and typical fields of application						
Solid wire for GMAW of AlCu alloys. Provides higher strength and better ductility than AlSi filler alloys when welding AlCu alloys. Superior resistance to stress corrosion cracking where high temperature properties are required. Thorough cleaning of the workpiece bevels is necessary prior to welding.						
Base materials						
EN AW-2219 [AlCu6Mn]		AlCu6Mn				
EN AW-2014 [AlCu4SiMg]		AlCu4SiMg		3.1255		
EN AW-2036 [AlCu2SiMg]		AlCu2,6Si0,5Mg0,3				
EN AC-45000 [AlSi6Cu4]		G-AlSi5Cu3				
and similar.						
Typical analysis of solid wire (wt.-%)						
Al	Cu	Mn	Mg	Ti	Zr	V
Bal.	5.8 – 6.8	0.2 – 0.4	< 0.02	0.1 – 0.2	0.10 – 0.25	0.05 – 0.15
Mechanical properties of all-weld metal						
Yield strength		Tensile strength		Elongation A (L <sub>0</sub> =5d <sub>0</sub> )		
R <sub>p0.2</sub>		R <sub>m</sub>				
MPa		MPa		%		
150		250		12		
Operating data						
		<b>Polarity:</b> DC (+)		<b>Shielding gases:</b> (EN ISO 14175) I1, I3		<b>ø mm</b> 1.0 1.2 1.6
Approvals						
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