



XTR 1100

AWS A5.10 ER1100 R1100

Description:

ER1100 is a 99% aluminum welding wire, highly resistant to chemical attack and weathering. It is a relatively soft alloy that is very formable and is used extensively in thin gauge and foil products.

Typical Applications:

XTR 1100 is a softer alloy that is commonly used in architectural and decorative applications on furniture and piping, thin gauge materials and foil products. Its softness makes it easy to shape and form giving it an advantage in decorative work and where an attractive weld appearance is critical. Its post anodized color is slightly golden. It has good wetting characteristics; one desirable characteristic of the alloy is the bright finishes obtained by anodizing. Typically used on similar base metal such as 1060, 1070, 1080, 1100, 1350, and 3003.

Chemistry:

	Typical	AWS Spec. Single values are max.
Silicon (Si) + Iron (Fe)	0.220	0.950
Copper (Cu)	0.065	0.05-0.20
Manganese (Mn)	0.000	0.050
Zinc (Zn)	0.000	0.010
Beryllium (Be)	0.000	0.0008
Aluminum (Al)	99.695	99.000min



Mechanical Properties: (As Welded)

	Typical	AWS Spec. Single values are min.
Tensile Strength	13,000	11,000 psi
Yield Strength	5,500	ns
Elongation in 2" (%)	35	ns
Post anodize color	White Gold	-

Welding Positions:

All

Operating Parameters: MIG (GMAW), DCEP DC+

Spray ARC 100% Argon					
Typically, the wire speed is set, then adjust to voltage to the desirable performance.					
Diameter	Amperage	Voltage	Speed (IPM)	Stickout (In.)	Flow Rate (CFH)
0.030 (.8mm)	60-175	15-24	480-625	1/2-3/4	25-30
0.035 (.9mm)	70-185	15-27	450-750		30-35
3/64 (1.2mm)	125-260	20-29	330-500		35-45
1/16 (1.6mm)	170-300	24-30	250-450		45-75

Operating Parameters: TIG (GTAW), DCEN DC- or ACHF

Shielding gas use 100% Argon Shielding Gas					
Best when using XTRweld brand tungsten, Zirconiated (EWZr-X), Lanthanated (EWLa-X), or Pure (EWP)					
Diameter	Amperage	Voltage	Tungsten Size	Flow Rate (CFH)	Gas Cup Size
1/16 (1.6mm)	60-80	15	1/16 (1.6mm)	20	3/8" (6)
3/32 (2.4mm)	85-160	15	3/32 (2.4mm)	20	3/8" (6)
1/8 (3.2mm)	190-220	15	1/8 (3.2mm)	25	7/16" (7)
5/32 (4.0mm)	200-300	15-17	5/32 (4.0mm)	30	1/2" (8)
3/16 (4.8mm)	330-380	15-20	3/16 (4.8mm)	35	5/8" (10)



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