



Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod 1070

Signed by Mats Linde	Approved by Per-Åke Pettersson/Christos Skodras	Reg no EN005060	Cancelling EN002634	Reg date 2009-11-25	Page 1 (2)
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REASON FOR ISSUE

Shielding Gas standard up date.

GENERAL

OK Autrod 1070 is 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. It has good welding characteristics. A desirable characteristic of the alloy is the bright finish obtained by anodising. Non-Heat treatable.

Shielding Gas: I1, I3 (EN ISO 14175)

Alloy Type: Al

CLASSIFICATIONS Wire Electrode

EN ISO 18273 S Al 1070 (Al99,7)

APPROVALS

Not applicable

CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
Si		0.20
Mn		0.03
V		0.05
Cu		0.04
Al	99.70	
Ti		0.03
Zn		0.04
Fe		0.25
Be		0.0003
Mg		0.03
Other each		0.03

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	Typ
Rp0.2 (MPa)		35
Rm (MPa)		75
A4-A5 (%)		45



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W Nom	η Nom	H		Feed		U	
	Min	Max			Min	Max	Min	Max	Min	Max
1.0	90	210	16						15	26
1.2	140	260	19						20	29
1.6	190	350	25						25	30
2.0	190	350	25						25	30

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)

OTHER DATA

Clean material is essential for a good weld quality. Remove oxide, dirt, oil, humidity etc. before welding. If brushing use a stainless steel wire brush.

Preheating: is not required for welds in sections up to 20 mm but risk of porosity can be reduced by preheating sections over 10 mm. Preheating temperature is usually 150-200 °C.
