



# Product Data Sheet

G 'Gas-shielded metal-arc welding'

# Autrod 1450

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## REASON FOR ISSUE

New Product Name

## GENERAL

Autrod 1450 is highly resistant to chemical attack and weathering. The alloy has a small addition of titanium, which has a grainrefining effect, which reduces the cracking susceptibility. It has good welding characteristics. A desirable characteristic of the alloy is the bright finishes obtained by anodising. Non Heat treatable.

**Shielding Gas:** I1, I3 (EN ISO 14175)

**Alloy Type:** Al

## CLASSIFICATIONS Wire Electrode

EN ISO 18273      S Al 1450 (Al99,5Ti)

## CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
Si		0.25
Mn		0.05
Cu		0.05
Al	99.50	
Ti	0.10	0.20
Zn		0.07
Fe		0.40
Be		0.0003
Mg		0.05
Other each		0.03

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	
	Typ	
Rp0.2 (MPa)	40	
Rm (MPa)	90	
A4-A5 (%)	35	

## ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	$\eta$	H		Feed		U	
	Min	Max			Nom	Nom	Min	Max	Min	Max
$\emptyset$			Nom	Nom	Min	Max	Min	Max	Min	Max
1.2	140	260	19					20	29	
1.6	190	350	25					25	30	

**W** = Gas consumption (l / min)

**$\eta$**  = Recovery, g weld metal / 100g wire (%)

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

**Feed** = Feeding rate (m/min)

**U** = Arc voltage (V)