

OK Autrod 1450

OK 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.

Specifications

Classifications	EN ISO 18273 : S Al 1450 (Al99,5Ti)
Alloy Type	Al
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	40 MPa (6 ksi)	90 MPa (13 ksi)	35 %

Typical Wire Composition %

Mn	Si	Al	Cu	Ti	Zn	Fe
0.02	0.02	99.8	0.01	0.12	0.01	0.16

Recommended Welding Parameters

Current	Wire Diameter	Voltage
140-260 A	1.2 mm (0.047 in.)	20-29 V
190-350 A	1.6 mm (1/16 in.)	25-30 V
280-400 A	2.4 mm (3/32 in.)	26-31 V