

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	90 MPa	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	20-29 V
190-350 A	1.6 mm	25-30 V
280-400 A	2.4 mm	26-31 V