

OK Autrod 1070

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.

Specifications

Classifications	EN ISO 18273 : S Al 1070 (Al99,7)
Alloy Type	Al
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	35 MPa (5 ksi)	75 MPa (11 ksi)	45 %

Typical Wire Composition %

Mn	Si	V	Al	Cu	Fe
0.01	0.02	0.01	99.80	0.01	0.13

Recommended Welding Parameters

Current	Wire Diameter	Voltage
90-275 A	1.0 mm (0.040 in.)	15-26 V
140-260 A	1.2 mm (0.047 in.)	20-29 V
140-300 A	1.2 mm (0.047 in.)	20-29 V
190-350 A	1.6 mm (1/16 in.)	25-30 V
190-350 A	2.0 mm (5/64 in.)	25-30 V
280-400 A	2.4 mm (3/32 in.)	26-31 V