

OK Autrod 1100

OK Autrod 1100 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	SFA/AWS A5.10 : ER1100 EN ISO 18273 : S Al 1100 (Al99,0Cu)
Approvals	CWB : AWS A5.10/A5.10M:2012 (ER1100)

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Al
Shielding Gas	I1, I3 (EN 439)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	30 MPa (4 ksi)	75 MPa (11 ksi)	35 %

Typical Wire Composition %

Cu	Si+Fe	Zn	Be
0.07	0.55	0.01	0.0001

Recommended Welding Parameters

Current	Wire Diameter	Voltage
140-260 A	1.0 mm (0.040 in.)	20-29 V
140-300 A	1.0 mm (0.040 in.)	20-29 V
140-260 A	1.2 mm (0.047 in.)	20-29 V
180-210 A	1.2 mm (0.047 in.)	22-26 V
125-150 A	1.2 mm (0.047 in.)	20-24 V
170-240 A	1.2 mm (0.047 in.)	24-28 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
240-300 A	1.6 mm (1/16 in.)	22-27 V
190-260 A	1.6 mm (1/16 in.)	21-26 V
280-320 A	1.6 mm (1/16 in.)	24-28 V
260-310 A	1.6 mm (1/16 in.)	22-27 V
290-340 A	1.6 mm (1/16 in.)	26-30 V