

NEXALLOY ER1070 – PRODUCT DATA SHEET

Nexalloy ER1070 Pure aluminum welding wire containing more than 99.7% aluminum. It provides good electrical conductivity, corrosion resistance and excellent weldability. It is commonly used for the welding of industrial pure aluminum plates and sheets in electronics, construction, and food industries etc.

NEXAL WELDING PRODUCTS APPROVALS AND SPECIFICATIONS

AWS A5.10/A5.10M/ASME SFA 5.10 Classification ER1070, R1070, ISO 18273 Al 1070 (Al99.7), EN AW-1070/Al 99,7, TUV, CE 0035-CPR-C809.

Chemical Composition (weight %)

Aluminum	99.7 Min	Silicon	0.20 Max
Manganese	0.03 Max	Magnesium	0.03 Max
Iron	0.25 Max	Titanium	0.03 Max
Copper	0.04 Max	Zinc	0.04 Max
Beryllium	0.0001 Max	Vanadium	0.05 Max

Other Elements 0.03 Max each

Typical Properties

Melting Range	1060 – 1175 F 646 – 657 C
Density	.096 lbs.\cu in.
Post Anodize Color	Gray
UTS	28ksi – 195MPA
Elongation	H18 (2'') 10%

Wire and Rod Diameters Available

MIG Wire: 0.030", 0.035", 0.045", 1/16", 3/32"

TIG Rod: 1/16" 3/32" 1/8" 5/32" 3/16"

Packaging Available

MIG Wire – 1LB/0.45KG, 5LB/2.2KG, 16LB/7.27KG, 20LB/9.08KG

TIG Rod – 5LB/2.2KG, 10LB/4.5KG, 50LB/22.6KG

MIG Welding Procedures:

Wire Diameter	WFS ipm	Amps	Volts	Consumption LB/100FT	Argon(cfh)
0.030"	480-625	60-175	15-24	0.65-1.25	25-30
0.035"	450-750	70-185	15-27	1.00-4.25	30-35
3/64"	330-500	125-260	20-29	1.00-4.25	35-45
1/16"	250-450	170-300	24-30	3.8-66	45-75
3/32"	160-200	275-400	26-31	35-66	60-85

TIG Welding Procedures: ACHF

Base Thickness	Filler Wire Size	Tungsten	Amps	Consumption LB/100FT	Gas Cup Size	Argon(cfh)
1/16"	1/16"	1/16"	60-80	0.75	3/8"	20
3/32"	3/32"	3/32"	85-120	1.00	3/8"	20
1/8"	3/32"	3/32"	125-160	1.50	3/8"	20
3/16"	1/8"	1/8"	190-220	4.5-6.0	7/16"	25
1/4"	5/32"	5/32"	200-300	8-10	1/2"	30



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