



NEXALLOY ER1080A – PRODUCT DATA SHEET

Nexalloy ER1080A is 99.80% aluminum filler typically used on similar base metal such as 1060, 1070, 1080, 1100, 1350 and 3003.

NEXAL WELDING PRODUCTS APPROVALS AND SPECIFICATIONS

AWS A5.10/A5.10M/ASME SFA 5.10 Classification ER1080A, R1080A, ISO 18273 S AL1080 (AL99.8(A)), EN AW-1080A/Al 99,8, TUV, CE 0035-CPR-C809.

Chemical Composition (weight %)

Aluminum	99.80 Min
Manganese	0.02 Max
Iron	0.15 Max
Silicon	0.15 Max
Copper	0.03 Max

Gallium	0.03 Max
Magnesium	0.02 Max
Zinc	0.06 Max
Titanium	0.06 Max

Others 0.02 Max

Typical Properties

Melting Range	11215 – 1220 F 657 – 660 C
Density	.098 lbs.\cu in.
Post Anodize Color	Clear
UTS	28ksi – 195MPA
Elongation	(2") 10%

Wire and Rod Diameters Available

0.030" 0.035" 3/64" 1/16" 3/32" 1/8" 5/32" 3/16" 1/4" 5/16"

Packaging Available

Plastic Spools – 1LB/0.4KG, 5LB/2.2KG, 10LB/4.5KG, 16LB/7.2KG, 20LB/9KG

Metal Spools – 10LB/4.5KG, 15LB /6.8KG **TIG Rods** – 5LB/2.2KG, 10LB/4.5KG, 50LB/22.6KG

Drums – 150LB/68KG, 300LB/136KG

MIG Welding Procedures: DCEP

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
3/8"	3/16"	3/16"	330-380	15-20	5/8"	35
1/2"	1/4"	1/4"	400-500	25-40	5/8"	40



Nexal Aluminum Inc.
www.nexalloy.com

5938 Ambler Drive Mississauga, ON L4W 2N3
An ISO 9001:2015 Certified Company

Phone: 1-905-629-8282
Fax: 1-905-629-8532

The data and information contained or referenced is presented as typical results without guarantee or warranty and Nexal expressly disclaims liability incurred of any kind with reliance thereon.

Aluminum Manufacturing since 1973