



NEXALLOY ER1100 – PRODUCT DATA SHEET

Nexalloy ER1100 is 99% aluminum filler typically used on similar base metal such as 1060, 1070, 1080, 1100, 1350, and 3003. It is resistant to chemical damage and weathering. Nexalloy 1100 is a soft alloy that is formable and commonly used in thin gauge and foil products. Another desirable characteristic is a bright finish obtained by anodizing. Nexalloy 1100 is also commonly used in metallizing applications.

NEXAL WELDING PRODUCTS APPROVALS AND SPECIFICATIONS

AWS A5.10/A5.10M/ASME SFA 5.10 Classification ER1100, R1100, ISO 18273 S AL1100 /AL99.0CU, EN AW-1100/ Al 99,0Cu, TUV, CE 0035-CPR-C809.

Chemical Composition (weight %)

Aluminum	99.0 Min
Manganese	0.50 Max
Iron + Silicon	0.95 Max
Copper	0.05-0.20
Beryllium	0.0001 Max

Typical Properties

Melting Range	1090 – 1215 F 643 – 657 C
Density	.098 lbs.\cu in. Other
Post Anodize Color	White Gold
UTS	33ksi – 230MPA
Elongation	(2") 5%

Elements 0.05 Max & Total 0.15 Max

Wire and Rod Diameters Available

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

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



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Aluminum Manufacturing since 1973